



Technical Data Sheet

Bondloc B3295 Rubber Toughened – Acrylic

PRODUCT DESCRIPTION

B3295 is a 1:1 ratio, two component, toughened, acrylic structural adhesive, formulated for high strength bonding of a wide range of substrates. The combination of minimal surface preparation and rapid fixture time makes it ideal for a variety of assembly operations. B3295 is rapid setting, shows excellent environmental resistance. Can be applied with mixing nozzle but can be used as a bead on bead no mix application.

APPLICATIONS

B3295 is suitable for bonding composites, thermoplastics and metals. thermoplastics, metals, wood, glass and composites

USEFUL HINTS/NOTES

- High strength and modulus
- Rapid setting and curing
- <3 minute work life
- Minimal surface preparation

INSTRUCTIONS FOR USE

- Some surface preparation maybe required. Ensure the surfaces to be bonded are clean of oil, dust, dirt and grease. Use B7063 Solvent Cleaner or PreBond Solvent wipes.
- Abrading/etching the surface can make bonded joints stronger and more durable. If required a second thorough clean should be carried out using MP120 Primer/Cleaner.
- Apply the adhesive, mate the substrates within the work life of the adhesive; <3 minutes.
- The bonded surfaces should be held in place or clamped for at least 15 minutes.

TECHNICAL FEATURES

	Adhesive Part A	Activator Part B
Colour	Pink	Green
Viscosity (Brookfield) @25°C	5000 cps	4900 cps
Shelf Life @ 23°C	12 months	
Storage	7 – 27°C	
Working Time	<3 mins	
Fixture Time	<6 mins	
Full Cure Time @ 23°C	24 hours	
Flash point	>80°C	
Operating Temperature	-55 - 125°C	
Recommended application Temp	18 - 24°C	
Gap Fill	0.25 - 3mm	
Shrinkage	<1%	
Tg	50°C	
Shore Hardness	55 Shore D	
Specific Gravity	Part A = 0.98 Part B = 0.96	

TYPICAL PHYSICAL PROPERTIES

Property	Typical value
Tensile Strength *	27 N/mm ²
Tensile Elongation	<8%

* ASTM D638 tested on Grit Blasted Mild Steel (GBMS)

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HEALTH & SAFETY

This technical information sheet does not constitute a Safety Data Sheet (SDS). Before using this product ensure you have read and fully understood this products SDS. This product is classified for Industrial use.

STORAGE

Store product in the unopened container in a dry area out of direct sunlight. Storage below 7°C or greater than 27°C can adversely affect product performance. Allow product to reach room temperature (18 - 24°C) before use.

PACKAGING FORMAT

Cartridge – 25ml, 50ml, 400ml

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