



# Technical Data Sheet

## Bondloc B3400 Acrylic/PMMA Bonder

### PRODUCT DESCRIPTION

B3400 is a 10:1 ratio, two component, reactive acrylic adhesive. Designed to be high strength and transparent, B3400 is recommended for applications where excellent clarity is needed. Suitable applications include aquarium manufacture and repair, museum quality cases, sign making and plastic fabrication industries.

### APPLICATIONS

B3400 is suitable for bonding polyester, polycarbonate, cellulose acetate butyrate, acrylics and is especially designed for use on clear acrylic/PMMA.

### USEFUL HINTS/NOTES

- High strength and excellent clarity
- Supplied in cartridge for ease of use
- 14-17 minute working life

### INSTRUCTIONS FOR USE

- Some surface preparation maybe required. Ensure the surfaces to be bonded are clean of oil, dust, dirt and grease
- Load cartridge into dispensing gun, ensure both A/B are free flowing.
- Secure the mixer tip to cartridge and place into applicator gun. Dispense and discard the first portion of the mixed adhesive.
- Apply the adhesive, mate the substrates within the work life of the adhesive; 14-17 minutes.
- The bonded surfaces should be held in place or clamped for at least 2 hours.

### TECHNICAL FEATURES

	Adhesive	Activator
Colour	Clear	Clear
Viscosity	3000 cps	400 cps
Shelf Life @ 20°C	12 months	
Storage	10 - 23°C	
Working Time	14 - 17 mins	
Full Cure Time @	72 hours	
Time to Handling	110 – 125 mins	

### TYPICAL BOND CHARACTERISTICS

Property	Typical value
Tensile Strength	15 - 17 MPa
Tensile Elongation	<5%
Gap Fill	0.1 – 2 mm

### STORAGE

Shelf life up to 12 months when stored unopened at the recommended temperature between 10 - 23°C. Exposure to temperatures above 23°C will shorten shelf life. Do not freeze. Allow product to reach room temperature (18 - 25°C) before use

### 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

### PACKAGING FORMAT

Cartridge.....50ml, 490ml

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