



# Technical Data Sheet

## Bondloc B3291 PU 1:1 One Minute Bonder

**PRODUCT DESCRIPTION**

B3291 is a toughened 1:1 ration structural adhesive, very fast setting, room temperature cure polyurethane adhesive system. This sand able adhesive system has an excellent adhesion to wide variety of surfaces.

**APPLICATIONS**

Clean surface by solvent-wiping any deposits of heavy grease, oil, dirt, or other contaminants. Surface can also be cleaned with industrial cleaning equipment such as vapor phase degreasers or hot aqueous baths. If working with metal, abrade or roughen the surface to significantly increase the microscopic bond area and increase the bond strength. Proper homogenous mixing of resin and hardener is essential for the curing and development of stated strengths. Attach cartridge to 50ml or 400ml manual or pneumatic dispensing systems. Open tip. Burp cartridge by squeezing out some material until both sides are uniform (ensures no air bubbles are present during mixing). Attach mix nozzle to end of cartridge. Apply to surface and attach other substrate quickly, as you have 2 minutes of working time to use the product. Substrates can be clamped with a bond line thickness as small as 0.007".

**USEFUL HINTS/NOTES**

Benefits:

- Fast setting time with convenient 1:1 mix ratio
- Excellent adhesion to wide variety of surfaces such as aluminum, stainless steel, ABS, PVC, polyurethane, composites, thermoplastics, thermosetting plastics, wood, glass, concrete without any use of primer.

**STORAGE**

Store in a cool dry place.

**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

**TYPICAL PROPERTIES**

	Part A	Part B
Colour	Beige	Black
Viscosity @25°C Brookfield, cps	30,000	30,000
Weight per Gallon	11	11
Mix Ratio	1:1	
Working Time	60 – 100 seconds	
Fixture Time	10 – 14 Minutes	
Functional Cure	2 hours	
Full Cure	24 Hours	
Service Temperature	-40°C to 121.1°C	
Coverage Per lb.	94 sq. inch per lb @ 1/4"	

**TYPICAL CURED PROPERTIES**

T-Peel Strength	3,500 - 4,500 Pli	ASTM D1876
Tensile Elongation	170%	ASTM D638
Shore Hardness	70D	ASTM D 2240
Dielectric Strength	350	volts/ASTM D 149
Cure Shrinkage	0.0020 in./in.	ASTM D 2566
Tear Resistance	450 Pli	ASTM D 624
Tensile Strength	2,850 psi	ASTM D 638

**LAP SHEAR STRENGTH (after 7 days @ 25°C)**

ABS to ABS	925 psi
Steel to Steel	1975 psi
Glass to Glass	4050 psi
SMC to SMC	1280 psi
Aluminium to Aluminium	2650 psi
Concrete to Concrete	1945 psi
GBS to GBS	2550 psi
Galvanised Metal to Metal	2850 psi

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**PRECAUTIONS:** This product and the auxiliary materials normally combined with it are capable of producing adverse health effects ranging from minor skin irritation to serious systemic effects. None of these materials should be used, stored, or transported until the handling precautions and recommendations as stated in the Safety Data Sheets (SDS) for this and all other products being used are understood by all persons who will work with the product. Warranty: All products purchased from or supplied by Bondloc are subject to terms and conditions set out in the contract. Bondloc warrants only that its product will meet those specifications designated as such herein or in other publications. All other information supplied by Bondloc is consider accurate but are furnished upon the express condition the customer shall make its own assessment to determine the product's suitability for a particular purpose. Bondloc makes no other warranty, either express or implied, including those regarding such other information, the data upon which the same is based, or the results to be obtained from the use thereof; that any product shall be merchantable or fit for any particular purpose; or that the use of such other information or product will not infringe any patent.

