



# Technical Data Sheet

## Bondloc B3295 BLK Universal Bonder 1:1

### PRODUCT DESCRIPTION

B3295 BLK is a second-generation acrylic adhesive designed to combine the high shear and temperature resistance of a conventional acrylic with the qualities of a rubber toughened adhesive where high peel and impact strength are a feature.

### APPLICATIONS

B3295 BLK bonds to a wide variety of materials such as metals, glass, epoxy, unsaturated polyesters, GRP, bakelite etc, B3295 BLK is supplied in our EMR (Equal Mix Ratio) system syringe or cartridge and is produced in various other forms of packaging.

### USEFUL HINTS/NOTES

B3295 BLK can be applied from bottles 1:1 ratio and the cure time can be adjusted by variation of the ratio (3.2 max) without affecting the bond strengths after full cure.

### PROPERTIES

B3295 BLK is suitable for paint bake cycling to + 180°C for typical coatings etc. Normal acrylic operating limits recommended for continuous temperature exposure is 50°C to +130°C.

### INSTRUCTIONS FOR USE

Never mix a large volume of A and B together as an exothermic reaction generating great heat and fumes will result. Ensure parts are clean and dry, however B3295 BLK is tolerant of light oil films. It is sufficient to apply part A to one side and Part B to the other.

### PROCEDURE FOR APPLICATION

Using EMR twin syringe or cartridge, affix posi- nozzle and fit the cartridge to the gun in the usual manner. Where the adhesive is being applied by hand, simply apply bead on bead.

### STORAGE

Store in a cool, dark area out of direct sunlight. Shelf Life: 9 months @ 20°C.

### TYPICAL BOND CHARACTERISTICS

Cure Time (50% final strength)	1 hour
Full Cure Time	6 hours
Strength	Max 35 N/mm <sup>2</sup>

### TECHNICAL FEATURES

Resin	Methyl Methacrylate
Colour A	Black
Colour B	Black
Colour When Mixed	Black
Cure Speed 1.1 Mix	<2 mins
Cure Speed Ratios	2-7 mins
Viscosity	3500 cps + -500 cps
Gap Fill	<3 mm
Flash Point	12°C
Shelf Life	9 months @ 20°C
Specific Gravity	1.02
Operating Temp	-40°C to + 180°C max
Max Operating Temp	+200°C (intermittent)
Normal Operating Limits	+130°C (continuous)

### 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.....28ml, 50ml, 400ml

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Bewdley Business Park  
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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.

