



# Technical Data Sheet

## Bondloc B3299 Structural Acrylic

### PRODUCT DESCRIPTION

B3299 is a 1:1 ratio, two component, toughened methacrylate structural adhesive formulated for bonding thermoplastics, metals and composites. The combination of minimal surface preparation and medium fixture time makes it ideal for a variety of assembly operations. B3299 is medium setting, shows excellent environmental resistance and has a gap fill capability of 5mm.

### APPLICATIONS

B3299 is suitable for bonding composites, thermoplastics and metals including galvanised. Please note; not recommended for PE, PP, PTFE, polyacetals.

### USEFUL HINTS/NOTES

- High strength and modulus
- Medium setting and curing
- 12-20 minute work life
- Minimal surface preparation
- Non-sag

### INSTRUCTIONS FOR USE

- Some surface preparation maybe required. Ensure the surfaces to be bonded are clean of oil, dust, dirt and grease
- 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; 12-20 minutes.
- The bonded surfaces should be held in place or clamped for at least 40 minutes.

### STORAGE

Shelf life up to 6 months when stored unopened at the recommended temperature between 15 - 23°C. Exposure to temperatures above 23°C will shorten shelf life. Long term exposure to higher temperatures will cause the product to thicken and become unstable. Do not freeze. Allow product to reach room temperature (18 - 24°C) before use.

### TECHNICAL FEATURES

	Adhesive	Activator
Colour	Off white / Black	Off white
Viscosity	40,000 – 80,000 cps	40,000 – 50,000 cps
Shelf Life @ 20°C	12 months	
Storage	2 - 23°C	
Working Time	12 - 20 mins	
Time to Handling strength	30 – 45 mins	
Full Cure Time @ 24°C	24 hours	
Operating Temperature	-40 - 100°C	
Recommended application Temp	18 - 24°C	
Gap fill	0.25-5mm	

### TYPICAL BOND CHARACTERISTICS

Property	Typical value
Tensile Strength	30 MPa
Tensile Modulus	1200 – 1500 MPa
Tensile Elongation	15%

### 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, 400ml  
Bulk..... 19L pail, 190L drum

Bondloc UK Ltd.  
Units 1 & 2  
Bewdley Business Park  
Bewdley, Worcestershire  
DY12 2TZ, UK  
  
+44 (0) 1299 269 269  
sales@bondloc.co.uk

**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.

