



Technical Data Sheet

Bondloc B3400 Crystal Clear Acrylic 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.

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.

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 @ 23°C	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

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, 100ml, 250ml, 490ml

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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.

