



# Technical Data Sheet

## Bondloc B3422 Universal Bonder 10:1

### PRODUCT DESCRIPTION

B3422 is a 10:1 ratio, two component, toughened methacrylate structural adhesive designed for primer-less bonding of composites, thermoplastics and metals. It demonstrates excellent impact, peel, shear, compressive strength and fatigue resistance properties across all bonded parts. B3422 is high viscosity, medium setting, shows excellent environmental resistance and has a gap fill capability of up to 20mm.

### APPLICATIONS

B3422 is suitable for bonding composites, thermoplastics and metals. Please note; not recommended for PE, PP, PTFE, polyacetals, zinc/galvanised coated metals.

### USEFUL HINTS/NOTES

- High strength and modulus
- Medium setting and curing
- 20-25 minute work life
- Non-sag

### INSTRUCTIONS FOR USE

- Some surface preparation maybe required. Ensure the surface 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.
- Apply the adhesive, mate the substrates within the work life of the adhesive; 20-24 minutes.
- The bonded surfaces should be held in place or clamped for at least 40 minutes.

### STORAGE

Shelf life up to 12 months when stored unopened at the recommended temperature between 2 - 23°C. Exposure to temperatures above 23°C will shorten shelf life. Do not freeze. Allow product to reach room temperature (18 - 24°C) before use.

### TECHNICAL FEATURES

	Adhesive	Activator
Colour	Off White	Black
Viscosity	100,000 – 140,000 cps	80,000 – 120,000 cps
Shelf Life @ 20°C	12 months	
Storage	2 - 23°C	
Working Time	20 - 25 mins	
Time to Handling strength	40 – 45 mins	
Full Cure Time @ 24°C	24 hours	
Operating	-40 - 100°C	
Recommended application Temp	18 - 24°C	
Gap fill	1-20mm	

### TYPICAL BOND CHARACTERISTICS

Property	Typical value
Tensile Strength	20 MPa
Tensile Modulus	600 – 800 MPa
Tensile Elongation	75%

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

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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.

