



# Technical Data Sheet

## Bondloc DTBKIT Difficult to Bond Instant Adhesive Kit

### PRODUCT DESCRIPTION

Bondloc Difficult to Bond Kit has been developed for the bonding of "difficult to Bond" plastics and thermoplastic rubbers.. DTB is a low cost solutions that eliminates the need for expensive surface treatments such as plasma, corona, flame or chemical etching. DTB Adhesive is a low viscosity, high quality, triple distilled cyanoacrylate, this highly catalyzed adhesive works perfectly with DTB Primer to wet the surface of most low surface energy materials to ensure a high strength bond is achieved.

### APPLICATIONS

DTB can be used on the following materials:

**Polypropylene (PP)** – Automotive body panels, bumpers, in-take manifolds, door cladding, containers/packaging, appliances and electrical/electronic applications.

**Polyethylene (PE)** – Automotive, packaging, housewares and wire and cable insulations, pipe and processing equipment.

**Fluoroplastics (PTFE) (FEP) (PFA)** – gaskets, seals, slides/guides, insulators, tubing.

**Silicone rubber (TPE)** – Automotive, O-rings, food industry, gaskets, anti-vibration, weather stripping

### USEFUL NOTES

- Rapid bonding of plastics & elastomers
- High quality triple distilled adhesive
- Replaces expensive surface treatment
- Bonds dissimilar substrates

### INSTRUCTIONS FOR USE

- Ensure surfaces are clean, dry and free from grease.
- Apply DTB Primer to the low energy surface material by wiping (using a brush or clean cloth) or dipping. Allow to dry at an ambient temperature prior to bonding.
- Bonding polyolefins with DTB adhesive can be performed up to 2 hours after the primer has been applied (this may be less depending on the particular blend of polyolefin) Immediate bonding is recommended for PTFE
- Apply the DTB adhesive and press together. Full cure will be achieved after 24 hours.

### TECHNICAL FEATURES

#### DTB ADHESIVE

Base	Ethyl Cyanoacrylate
Appearance	Clear
Specific Gravity	1.06 g/cm <sup>3</sup>
Shelf Life	12 months
Viscosity @ 25°C	25-35 cps

#### DTB PRIMER

Base	Heptane/acetone
Evaporation	30-60 seconds
Specific Gravity	0.68 g/cm <sup>3</sup>
Shelf Life	12 months
Viscosity @ 20°C	1.25 mPas
Drying Time	<35 seconds

### STORAGE

BCA HV should ideally be stored in original sealed containers until used. Containers should be stored between 2°C and 10°C with a maximum storage temperature of 25°C. Avoid exposure to strong light and heat sources. Refrigeration can prolong shelf life.

### 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

Kit.....20g/20ml, 50g/50ml, 500g/500ml

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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 considered 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.

