



Technical Data Sheet

Bondloc B415 Metal Bonder

PRODUCT DESCRIPTION

B415 is a general purpose adhesive.

APPLICATIONS

B415 bonds metals, plastics, wood, ceramics, rubber, leather, card, glass and many other materials.

INSTRUCTIONS FOR USE

Clean and dry surfaces to be bonded. Apply adhesive sparingly to one surface and assemble parts. Hold or clamp parts together for 60 seconds. Leave for 1 hour to fully cure. Activators and primers may be used to aid bonding.

LIQUID PROPERTIES

Ester base	Methyl
Appearance	Clear liquid
Specific Gravity 25°C	1.043g/cm ³
Shelf life	12 months unopened
Viscosity Brookfield - S p 1 @20rpm @25°C	1,200 – 1,800 cps

STORAGE

Bondloc cyanoacrylates 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.

TEMPERATURE RESISTANCE

Tested on mild steel cured for 24 hours, conditioned to test temperature for 1 hour before pull-test.

ENVIRO-CHEMICAL RESISTANCE

Exposed to conditions for 1000 hours at 22°C except for 98% RH which had an exposure of 42°C.

CURED PERFORMANCE

Cured Speed

Defined as the time taken to develop a strength of 0.1N/mm² at 22°C and 50% relative humidity.

Balsa	<3 seconds
Nitrile	<5 seconds
Neoprene	<5 seconds
EPDM	<5 seconds
Steel (degreased)	25-40 seconds
Polycarbonate	10-30 seconds
ABS	10-15 seconds

SHEAR STRENGTH

Steel	15-25 N/mm ²
Aluminum	7-10 N/mm ²
Nitrile Rubber	5-10 N/mm ²
Polycarbonate	5-10 N/mm ²
ABS	6-10 N/mm ²

TENSILE STRENGTH

Nitrile Rubber	5-15 N/mm ²
Neoprene	5-15 N/mm ²
EPDM	2-6 N/mm ²

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

Bottles.....20g, 50g, 500g

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