



# Technical Data Sheet

## Bondloc B3291 1 Minute Polyurethane

### PRODUCT DESCRIPTION

B3291 is a toughened 1:1 ration structural adhesive, very fast setting, room temperature cure polyurethane adhesive system. This sand able adhesive system has an excellent adhesion to wide variety of surfaces.

### APPLICATIONS

Clean surface by solvent-wiping any deposits of heavy grease, oil, dirt, or other contaminants. Surface can also be cleaned with industrial cleaning equipment such as vapor phase degreasers or hot aqueous baths. If working with metal, abrade or roughen the surface to significantly increase the microscopic bond area and increase the bond strength. Proper homogenous mixing of resin and hardener is essential for the curing and development of stated strengths. Attach cartridge to 50ml or 400ml manual or pneumatic dispensing systems. Open tip. Burp cartridge by squeezing out some material until both sides are uniform (ensures no air bubbles are present during mixing). Attach mix nozzle to end of cartridge. Apply to surface and attach other substrate quickly, as you have 2 minutes of working time to use the product. Substrates can be clamped with a bond line thickness as small as 0.007".

### USEFUL HINTS/NOTES

Benefits:

- Fast setting time with convenient 1:1 mix ratio
- Excellent adhesion to wide variety of surfaces such as aluminum, stainless steel, ABS, PVC, polyurethane, composites, thermoplastics, thermosetting plastics, wood, glass, concrete without any use of primer.

### TYPICAL PROPERTIES

|                                    | Part A                    | Part B |
|------------------------------------|---------------------------|--------|
| Colour                             | Beige                     | Black  |
| Viscosity @25°C<br>Brookfield, cps | 30,000                    | 30,000 |
| Weight per Gallon                  | 11                        | 11     |
| Mix Ratio                          | 1:1                       |        |
| Working Time                       | < 60 seconds              |        |
| Fixture Time                       | < 20 Minutes              |        |
| Functional Cure                    | 2 hours                   |        |
| Full Cure                          | 24 Hours                  |        |
| Service Temperature                | -40°C to 121.1°C          |        |
| Coverage Per lb.                   | 94 sq. inch per lb @ 1/4" |        |

### TYPICAL CURED PROPERTIES

|                     |                   |                  |
|---------------------|-------------------|------------------|
| T-Peel Strength     | 3,500 - 4,500 Pli | ASTM D1876       |
| Tensile Elongation  | 170%              | ASTM D638        |
| Shore Hardness      | 70D               | ASTM D 2240      |
| Dielectric Strength | 350               | volts/ASTM D 149 |
| Cure Shrinkage      | 0.0020 in./in.    | ASTM D 2566      |
| Tear Resistance     | 450 Pli           | ASTM D 624       |
| Tensile Strength    | 2,850 psi         | ASTM D 638       |

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### LAP SHEAR STRENGTH (after 7 days @ 25°C)

|                           |          |
|---------------------------|----------|
| ABS to ABS                | 925 psi  |
| Steel to Steel            | 1975 psi |
| Glass to Glass            | 4050 psi |
| SMC to SMC                | 1280 psi |
| Aluminium to Aluminium    | 2650 psi |
| Concrete to Concrete      | 1945 psi |
| GBS to GBS                | 2550 psi |
| Galvanised Metal to Metal | 2850 psi |

### STORAGE

Store in a cool dry place.

### 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

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