



Technical Data Sheet

Bondloc B3293 3 Minute Polyurethane

PRODUCT DESCRIPTION

B3293 is a two-component fast setting, room temperature cure structural 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 5 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 Brookfield, cps	30,000	30,000
Weight per Gallon	11	11
Mix Ratio	1:1	
Working Time	< 3 Minutes	
Fixture Time	12 – 15 Minutes	
Functional Cure	< 30 Minutes	
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	65 – 75 Pli	ASTM D1876
Tensile Elongation	200%	ASTM D638
Shore Hardness	65 – 70	ASTM D 2240
Dielectric Strength	350	volts/mil ASTM D 149
Cure Shrinkage	0.0014 in./in.	ASTM D 2566
Tear Resistance	400 Pli	ASTM D 624
Tensile Strength	2,200 psi	ASTM D 638

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

ABS to ABS	1250 psi
Steel to Steel	2050 psi
Glass to Glass	4100 psi
SMC to SMC	1200 psi
Aluminium to Aluminium	2225 psi
Concrete to Concrete	1940 psi
GBS to GBS	2750 psi
Galvanised Metal to Metal	2840 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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