



# Technical Data Sheet

## Bondloc B3299 Universal Bonder - Acrylic

### PRODUCT DESCRIPTION

B3299 is a 1:1 ratio, two component, toughened, methacrylate structural adhesive, formulated for high strength bonding of thermoplastics, metals and composites. The combination of minimal surface preparation and rapid fixture time makes it ideal for a variety of assembly operations. B3299 is medium setting, shows excellent environmental resistance and has a gap fill capability of 5mm.

### APPLICATIONS

B3299 is suitable for bonding composites, thermoplastics and metals.

### USEFUL HINTS/NOTES

- High strength and modulus
- Medium setting and curing
- 12-15 minute work life
- Minimal surface preparation

### INSTRUCTIONS FOR USE

- Some surface preparation maybe required. Ensure the surfaces to be bonded are clean of oil, dust, dirt and grease. Use B7063 Solvent Cleaner or PreBond Solvent wipes.
- Abrading/etching the surface can make bonded joints stronger and more durable. If required a second thorough clean should be carried out using MP120 Primer/Cleaner.
- Apply the adhesive, mate the substrates within the work life of the adhesive; 12-15 minutes.
- The bonded surfaces should be held in place or clamped for at least 45 minutes.

### TECHNICAL FEATURES

	Adhesive Part A	Activator Part B
Colour	Off white	Off white or Black
Appearance	Thixotropic Gel	
Viscosity (Brookfield) @23°C	500k-750k cps	400k-500k cps
	Spindle T-D @ 1.00rpm	Spindle 7 @ 2.5rpm
Shelf Life @ 23°C	12 months	
Storage	7 - 27°C	
Working Time	12 - 15 mins	
Fixture Time	40 - 55 mins	
Full Cure Time @ 23°C	24 hours	
Operating Temperature	-50 - 120°C	
Recommended application Temp	18 - 24°C	
Gap Fill	0.25 - 5mm	
Shore Hardness	75 Shore D	
Specific Gravity	Part A = 0.98 Part B = 0.96	

### TYPICAL PHYSICAL PROPERTIES

Property	Typical value
Tensile Strength *	24-31 N/mm <sup>2</sup>
Tensile Modulus	900-1000 MPa
Tensile Elongation	4-8%

\* ASTM D638 tested on Grit Blasted Mild Steel (GBMS)

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### 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. This product is classified for Industrial use.

### STORAGE

Store product in the unopened container in a dry area out of direct sunlight. Storage below 7°C or greater than 27°C can adversely affect product performance. Allow product to reach room temperature (18 - 24°C) before use.

### PACKAGING FORMAT

Cartridge – 50ml, 400ml

### PRODUCT DISCLAIMER

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