



Technical Data Sheet

Bondloc B3422 Universal Bonder Acrylic

PRODUCT DESCRIPTION

B3422 is a 10:1 ratio, two component, toughened methacrylate structural adhesive designed for primer-less bonding of composites, thermoplastics and metals. It demonstrates excellent impact, peel, shear, compressive strength and fatigue resistance properties across all bonded parts. B3422 is a non sagging, medium setting, with excellent environmental resistance and has a gap fill capability of 14mm.

APPLICATIONS

B3422 is suitable for bonding composites, thermoplastics and metals. (Not recommended for PE, PP, PTFE, polyacetals)

USEFUL HINTS/NOTES

- High strength and modulus
- Rapid setting and curing
- 20-25 minute work life
- Non-sag for vertical application

INSTRUCTIONS FOR USE

- Some surface preparation maybe required. Ensure the surfaces to be bonded are clean of oil, dust, dirt and grease by using Bondloc Prep Bond wipes or B7063 solvent degreaser.
- Abrading/etching the surface can make bonded joints stronger and more durable.
- Allow product to reach room temperature (18 - 25°C) before use.
- Purge cartridge making sure that Part A & B are extruded before applying the nozzle.
- Apply the adhesive, mate the substrates within the work life of the adhesive; 20-25 minutes.
- The bonded surfaces should be held in place or clamped for at least 60 minutes.

STORAGE

Shelf life up to 9 months when stored unopened at the recommended temperature between 10 - 25°C. Exposure to temperatures higher or lower temperature will shorten shelf life. Do not freeze.

TECHNICAL FEATURES

	Adhesive	Activator
Colour	Off White	Black
Viscosity @23°C	450,000 – 650,000 cps	80,000 – 250,000 cps
Shelf Life	9 months	
Storage	10 - 25°C	
Working Time	20-25 mins	
Time to Handling strength	30-60 mins	
Full Cure Time @	24 hours	
Operating Temp	-40 to 120°C	
Recommended application Temp	18 to 25°C	
Gap Fill	1-14mm	

TYPICAL BOND CHARACTERISTICS

Property	Typical value
Tensile Strength at break	18 MPa
Lap Shear - GRP	Substrate Failure
- Aluminum	19 MPa
-Steel	20 MPa
Tensile Modulus	900-12000 MPa
Hardness (ShoreD)	70-80
Tensile Elongation	35%

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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. Industrial use only.

PACKAGING FORMAT

Cartridge -490ml

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