



# Technical Data Sheet

## Bondloc B3294 Structural Acrylic

**PRODUCT DESCRIPTION**

A toughened structural adhesive formulated for bonding dissimilar substrates as well as unprepared metals, ceramics, wood, concrete and standard thermoset plastics. The final adhesive bond is designed to be load bearing and resistant to weathering, humidity and wide temperature variations.

**APPLICATIONS**

Outdoor weathering or solvent exposure thermoformed plastic assemblies PVC, fibreglass, vinyl's, ABS, steel aluminium, stainless steel, acrylics, phenolic, polycarbonate, Styrenics, Noryl, PET, wood, concrete and ceramic magnet and speaker assembly, sign assembly.

**USEFUL HINTS/NOTES**

- Convenient 1:1 mix ratio
- Room temperature
- Rapid fixture time
- Minimal surface preparation required
- High resistance to hydrocarbon based fuels (gasoline, jet fuel, motor oil, hydraulic fluid)
- Thixotropic/non-sagging
- Bonds dissimilar plastics in combination

**INSTRUCTIONS FOR USE**

- Ensure that surfaces to be bonded are clean and free from grease, dirt, dust and any other contamination.
- Mix equal quantities either by weight or volume of the two parts and stir thoroughly until a colour is obtained. Where a static mixing nozzle is supplied the 2 parts will be mixed correctly upon dispensing.
- Apply to one surface and offer up the second surface.
- Clamp or jig together under light pressure.
- Leave to cure at room temperature.

**STORAGE**

B3294 should be stored in a cool, dry place when not in use for extended time periods. B3294 has a shelf life of 1 year or more when stored at room temperature 70°F (22°C) in its original container. Shelf life may be extended by refrigeration. NOTE Mass mixing of B3294 generates intense heat levels due to its rapid curing features (film thickness cures in excess of 1/8" should be avoided whenever possible) which can cause the release of volatile components as evidences by outgassing. Use only enough material as needed within the working time, and confine gap thickness to no more than 0.125" to prevent this.

**TECHNICAL FEATURES**

Viscosity	55,000cps
Colour	Off white
Weight (lbs./gal)	8.44
Mixed Density (lbs./gal)	8.28
Flash Point	51°F
Mixed Viscosity	No sagging gel
Open Time	3 mins @ 72°F, 22°C
Assembly Time	6 mins @ 72°F, 22°C
Functional Cure	3/4-1 hour
Full Cure	4 Hours
Solvents	None
Coverage (based on 25ml)	152 sq.in @ 0.010"

**TYPICAL BOND CHARACTERISTICS**

Bond Strength Tensile Shear (ASTMD1002)	Polycarbonate Alloy - 1,400 psi ABS - 1,300 psi Grit blasted steel - 3,000 psi
T-Peel Strength (ASTMD1876, 10"/min on 0.060" 6061 aluminium)	75 pli
Impact Resistance (ASTMD950-61T grit blasted steel)	22 ft.lb/in
Shore Hardness (D)	78
Gap Filling	0.125 in
Minimum Elongation	75%
Operating Temp Range	-40°C to +121 °C

**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.....28ml, 400ML  
Clam.....28ml

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**PRECAUTIONS:** This product and the auxiliary materials normally combined with it are capable of producing adverse health effects ranging from minor skin irritation to serious systemic effects. None of these materials should be used, stored, or transported until the handling precautions and recommendations as stated in the Safety Data Sheets (SDS) for this and all other products being used are understood by all persons who will work with the product. Warranty: All products purchased from or supplied by Bondloc are subject to terms and conditions set out in the contract. Bondloc warrants only that its product will meet those specifications designated as such herein or in other publications. All other information supplied by Bondloc is consider accurate but are furnished upon the express condition the customer shall make its own assessment to determine the product's suitability for a particular purpose. Bondloc makes no other warranty, either express or implied, including those regarding such other information, the data upon which the same is based, or the results to be obtained from the use thereof; that any product shall be merchantable or fit for any particular purpose; or that the use of such other information or product will not infringe any patent.

