



# Technical Data Sheet

## Bondloc B330 Multi-Bonder

**PRODUCT DESCRIPTION**

B330 is our All Purpose "Multi" style rubber toughened Acrylic Structural Adhesive. B330 is used in conjunction with our B738 Activator and a strong, flexible bond is formed within 1-2 minutes.

**APPLICATIONS**

Typical applications are varied but include wood to metals, metal to metal such as handles, strengthening bars for sheet fabrication, magnets to coated or plated steel including aluminium, brass and some plastics such as hard and slightly flexible parts. Teflon and rubbers are difficult, if not impossible without special treatments.

**USEFUL NOTES**

Where one surface is absorbent (i.e. wood) apply activator to non-porous surface. Always allow the activator to dry first, bring parts together and hold under light pressure until fixture occurs.

**RECOMMENDATION**

Fast Set with B738, alternative cure time with a choice of activators.  
 Tensile Strength up to 20 N/mm<sup>2</sup>.  
 All Purpose Multi Use Bonder.  
 Gap Design Typical 0.05 mm, maximum 0.6 mm.

**INSTRUCTIONS FOR USE**

Ensure parts are clean, dry and free from oil and grease.

**PROCEDURE FOR APPLICATION**

Product is normally hand applied from the bottle.

**COMPATIBLE ACCELERATORS/PRIMERS**

Primer such as B738 (Standard Activator) can be used.

**STORAGE**

Store in original containers in a cool area out of direct sunlight and away from sources of high temperature. Shelf Life: 12 months at ambient temperature.

**TECHNICAL FEATURES**

Resin	THF Methacrylate
Colour	Amber
Cure Speed with Activator	1-2 mins
Viscosity	45,000 - 90,000 cps
Flash Point	>80°C
Shelf Life	12 months @ 20°C
Specific Gravity	1.05
Max Operating Temp	-50°C to +130°C

**TYPICAL BOND CHARACTERISTICS**

Full Cure Time	12 hours (Steel)
Tensile Shear Strength	15-30 N/cm <sup>2</sup>
Tensile Strength	10-22 N/mm <sup>2</sup>
Gap Fill/Cure Rate Minimum	0.05 mm <12 hours
Gap Fill/Cure Rate Maximum	0.6mm >24 hours
Gap Size Strength (Steel)	0.05mm / 100%
Gap Size Strength (Steel)	0.6mm/>30% best
Max Strength at Temp	60% @ 80°C 100% @ 50°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**

Tube.....50ml (kit), 80ml, 300ml

Bondloc UK Ltd.  
 Units 1 & 2  
 Bewdley Business Park  
 Bewdley, Worcestershire  
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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.

