



# Technical Data Sheet

## Bondloc B510 Gasket Maker

**PRODUCT DESCRIPTION**

B510 is a fast set, Form-In-Place Gasket Maker for all types of metal parts, sealing and resisting temperatures up to 200°C.

**APPLICATIONS**

B510 is used for sealing any shape or size of high temperature application, dressing gaskets or making rigid assemblies. Apply B510 by tube tracing, roll coating, screen printing, pads etc.

**USEFUL NOTES**

Before cure takes place B510 will give an instant seal. The cure process can be accelerated with the use of an activator.

**PROPERTIES**

Fast Set Instant Seal. Does not run or sag. Resists relaxation, shrinkage and operates at temperatures up to 200°C.

**INSTRUCTIONS FOR USE**

Clean and dry surfaces to be bonded. Apply adhesive to surface and assemble parts. Parts should be left for 15 minutes to reach handling strength. Leave for 12 hours to fully cure. Activators may be used to aid bonding on surfaces where imperfections in surface tolerance exceed maximum gap fill. Suitability should be determined prior to final application.

**COMPATIBLE ACCELERATORS/PRIMERS**

Primers such as B7471 (Standard Anaerobic Activator) can be used, however up to 30% strength loss can occur when using accelerators, but cure thickness will increase with activators up to the maximum limits.

**STORAGE**

Store in a cool area out of direct sunlight. Shelf Life >18 months at ambient temperature.

**TECHNICAL FEATURES**

Resin	Modified Acrylate
Colour	Pink
Fixture speed with Activator	15mins to 2 hours
Fixture speed without Activator	Up to 12 hours
Viscosity Brookfield Sp3 @20rpm@25°C	>50,000 cps (paste)
Gap Fill	0.25mm
Flash Point	>100°C
Shelf Life	18 months
Specific Gravity	1.15
Temperature Range	-55°C to +230°C

**TYPICAL BOND CHARACTERISTICS**

Full Cure Time	12 hours
Shear Strength	<10N/mm <sup>2</sup>
Typical prevailing strength	12.5 N/mm <sup>2</sup>
Percentage strength retained at:	
100°C	50%
135°C	25%
150°C	20%

**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**

Bottles.....50ml,65ml,160ml,250ml  
Clam Packs.....50ml,65ml

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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.

