

Technical Data Sheet

B2204 STEEL EPOXY Revised

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BARNWELL
THE SEAL OF APPROVAL

B2204 – Steel Epoxy

PRODUCT DESCRIPTION

B2204 is two part, cold curing epoxy adhesive. B2204 will bond a wide range of metals and plastics. B2204 has a medium length work-life, 90 mins, to cater for a long assembly time.

APPLICATIONS

General purpose metal and plastics assembly.

INSTRUCTIONS FOR USE

Refer to Material Safety Data Sheet.

Ensure the surfaces to be bonded are clean, dry and free from grease and dust. Mix equal quantities, by weight or volume, of the two parts and stir thoroughly until an even colour is obtained. Apply to one surface and offer up the second surface, clamp or jig together under light pressure. Allow to cure overnight.

CAUTION

Some instances have occurred of the Part 1 setting solid. This is due to it crystallising. It can be returned to normal by placing in a bath of hot water. Bonding performance is unaffected by this treatment.

TECHNICAL FEATURES

	Part 1	Part 2	Mix
Appearance	Viscous paste		
Colour	Black	Cream	
Specific Gravity	1.6	1.4	
Viscosity, poise@ 25°C	350	350	
Mix ratio			1:1
Work-life, 40 gm			90 min

ADHESION

METALS	Shear Strength		PLASTICS	Shear Strength	
	Psi	MPa		Psi	MPa
Steel	3500	24	HIPS	300	2.1
Steel, abraded	2250	15.5	ABS	500	3.4
Stainless steel	2950	20.3	Polycarbonate	550	3.8
Aluminium	2100	14.5	Perspex	580	4.0
Aluminium, abraded	2400	16.6	GRP	870	6.0
Galvanised steel	1800	12.4			

STORAGE

Store in closed containers between 5 and 25°C. Shelf life is 12 months in above conditions.

HEALTH AND SAFETY

This technical information sheet does not constitute a Material Safety Data Sheet (MSDS). Before using this product please ensure you have read and fully understand B2204 MSDS.

PRESENTATION

Cartridges.....50ml, 4000ml

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 Material Safety Data Sheets (MSDS) 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 considered 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.