

Technical Data Sheet

B3299 Structural Bonder Revised

01.06.15



B3299 Structural Bonder

PRODUCT DESCRIPTION

B3299 is a toughened 1:1 ratio structural adhesive formulated for bonding thermoplastics, metals and composites. The combination of minimal surface preparation and rapid fixture time makes it ideal for a variety of assembly operations.

APPLICATIONS

B3299 is used for outdoor weathering or solvent exposure applications, thermoformed plastic assemblies, PVC, Fiberglass, Vinyls, ABS, Steel, FRP, Coated Metals, Aluminium, Acrylics, Phenolic, Polycarbonate, Styrenics, Wood, Concrete and Ceramics.

USEFUL NOTES

Benefits:

- B3299 working time 15-18 mins, fixture time 25 – 30 mins
- Minimal surface preparation required
- High resistance to hydrocarbon based fuels (petrol, jet fuel, motor oil and hydraulic fluid)
- Thixotropic/non-sagging
- Bonds dissimilar plastic combinations

TECHNICAL FEATURES

	Part 1 Base resin	Part 2 Activator
Chemical type	Methyl Methacrylate Methacrylic acid Organic peroxide	Methyl methacrylate
Colour	Off white	Off white
Viscosity	50000 - 100,000 cps	50000 cps - 100,000 cps
Service Temperature	-40°C to 150°C Constant temperature	
Service Temperature	220°C Intermittent temperature	

TYPICAL BOND CHARACTERISTICS

Tensile Strength (psi)	3,500 - 4,500 psi
Modulus (psi)	125,000
Bond strength (psi)	3,500 max
Elongation (max %)	50-75%

PROCEDURE FOR APPLICATION

For optimum performance, surfaces should be solvent wiped, free from heavy grease deposits, oil, dirt or other contaminants.

STORAGE

Adhesive should be stored between 10°C - 27°C and in a dry place when not in use for extended periods. B3299 has a shelf life of 6 months when stored at room temperature in its original container.

HEALTH & SAFETY IN USE

Usual hygiene procedures should apply. Do not swallow. If skin contact occurs, wash with soap and water. Splashes to the eyes should be washed out thoroughly with water, if in doubt seek medical advice.

This Technical information sheet does not constitute a Material Safety Data Sheet. Before using this product ensure you have read and fully understood Bondloc Material Safety Data Sheet B3299.

PRESENTATION

Cartridges..... 50ml, 400ml

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 is 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.