

Technical Data Sheet

TDS B330 MULTI BONDER

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BARNWELL
THE SEAL OF APPROVAL

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(2).

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

CURED PERFORMANCE

Full cure time	12 hours (Steel)
Tensile shear strength	15-30 N/cm(2)
Tensile strength	10-22 N/mm(2)
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 IN USE

IRRITANT: Contains Aliphatic Methacrylate's and some products contain small amounts of Methacrylic Acid. Irritates the eyes, the respiratory organs and the skin. In case of contact with the skin wash immediately with plenty of water. CONSULT HSS 189. Activator contains iii Trichloroethane and a blend of active ingredients based on a condensation product of butyrolaldehyde aniline. Avoid breathing spray particles. Treat as harmful and read Product Cautions on Health and Safety Sheets.

PRESENTATION

Syringe Kit: 50 ml Adh. + 18ml Act
Cartridge Kit:.....300 ml Adh + 30ml Act

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.