Technical Data Sheet

B390 Instant Adhesive

PRODUCT DESCRIPTION

B390 is a gap filling instant adhesive/ repair product with excellent adhesion to a very broad range of materials and surfaces. Curing times of only 4 minutes while a hard and tough polymer results within 8 minutes, working times (in-mixer) up to 10 minutes, total volumetric gap filling, with minimal volumetric shrinkage make this product an ideal repair adhesive filler. instant adhesion to most plastics, wood and metals including aluminum, and to porous and irregular surfaces. The gel consistency enables application in any orientation whilst the static mixing nozzle ensures uniform and precise application for exceptional user convenience.

Appearance (uncured comp. A)	Transparent gel
Appearance (uncured comp. B)	Cream opaque gel
Chemical Type	Ethyl Cyanoacrylate
Components	Two-part – requires mixing
Cure	By mixing
Technology	Cyanoacrylate
Viscosity	High, thixotropic gel

TYPICAL CURING PERFORMANCE

Under normal conditions, the atmospheric moisture initiates the curing process. Although full functional strength is developed in a relatively short time, curing continues for at least 24 hours before full chemical resistance is developed.

FIXTURE TIMES

Fixture time is the time at which an adhesive bond (250 mm2) is capable of supporting a 3kg load for 10 seconds. The fixture time will depend on the substrate. The table shows the fixture time for different substrates using lap shears. depend on the substrate. The table below shows the fixture time for different substrates using lap shears.

	Time (s)	Strength (N/mm^2)
ABS	30 – 60	9-12*
Aluminum A5754	5 – 20	3-7
Beech Wood	15 –30	14-15*
Mild steel	15 – 45	17-20
Pine Wood	45 – 75	11-13*
Polycarbonate	15 – 45	10-12*

*Substrate Failure

TYPICAL PROPERTIES OF UNCURED MATERIAL

PART A: Specific gravity, 25 °C, g/cm3:	1.09
Viscosity, Brookfield,	25 °C, mPa·s (cP):
Spindle 14, speed 1.5 rpm	100.000 to 195000
PART B: Specific gravity, 25 °C, g/cm3:	1.17
Viscosity, Brookfield,	25 °C, mPa·s (cP):
Spindle 14, speed 1.5 rpm	80.000 to 110.000
MIXED A and B: Open time at 25 °C:	4 – 8 minutes
Working time at 25 °C:	5 – 10 minutes
Glass Transition Temperature (Tg, °C):	87.2
Shore D Hardness:	56

GENERAL INFORMATION

Directions for use:

1) Before applying the glue, make sure the gluing surface is clean, dry and free of grease.
2) To assemble the syringe, first introduce the plunger, then exchange the cap with a mixer. Discard the first few drops.
3) Apply the material on one of the two surfaces and assemble the two parts within 1 minute.
4) After uniting the substrates, 15-30 seconds are available for repositioning on the substrates. Press the two parts together firmly for around 30 seconds. After releasing the pressure, wait 5 minutes before good handling strength, 10 minutes for a fully cured material and 24 hours for full strength.
5) Make use of the syringe or discard the product at least every 2 minutes to avoid the product from polymerizing inside the mixer, if you do not want to replace the mixer.
6) After use, discard the mixer and replace the cap. Store the syringe in a cool and dry environment.
7) Optimal Storage: 2°C to 8°C. Storage below 2°C or greater than 8°C can adversely affect product properties.
8) Product shelf-life: 12 months.

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.