



Technical Data Sheet

Bondloc B3420 Universal Bonder 10:1

PRODUCT DESCRIPTION

B3420 is a 10:1 ratio, two component, toughened methacrylate structural adhesive designed for primer-less bonding of composites, thermoplastics and metals. It demonstrates excellent impact, peel, shear, compressive strength and fatigue resistance properties across all bonded parts. B3420 is a non sagging, rapid setting, with excellent environmental resistance and has a gap fill capability of 12mm.

APPLICATIONS

B3420 is suitable for bonding composites, thermoplastics and metals.
Please note; not recommended for PE, PP, PTFE, polyacetals.

USEFUL HINTS/NOTES

- High strength and modulus
- Rapid setting and curing
- 5–8-minute work life
- Non-sag for vertical application

INSTRUCTIONS FOR USE

- Some surface preparation maybe required. Ensure the surfaces to be bonded are clean of oil, dust, dirt and grease by using Bondloc PreBond wipes or B7063 solvent degreaser.
- Abrading/etching the surface can make bonded joints stronger and more durable.
- Allow product to reach room temperature (18 - 25°C) before use.
- Purge cartridge making sure that Part A & B are extruded before applying the nozzle.
- Apply the adhesive, mate the substrates within the work life of the adhesive; 5-8 minutes.
- The bonded surfaces should be held in place or clamped for at least 20 minutes.

STORAGE

Shelf life up to 9 months when stored unopened at the recommended temperature between 10 - 25°C. Exposure to temperatures higher or lower temperature will shorten shelf life. Do not freeze.

TECHNICAL FEATURES

	Adhesive	Activator
Colour	Off White	Black
Viscosity @23°C	330,000 – 500,000	80,000 – 250,000
Shelf Life	9 months	
Storage	10 - 25°C	
Working Time	5-8 mins	
Time to Handling strength	12–16 mins	
Full Cure Time @	24 hours	
Operating Temperature	-40 to 120°C	
Recommended application Temp	18 to 25°C	
Gap Fill	1-12mm	

TYPICAL BOND CHARACTERISTICS

Property	Typical value
Tensile Strength at break	18 MPa
Lap Shear - GRP	Substrate Failure
- Aluminum	19 MPa
-Steel	20 MPa
Tensile Modulus	900-12000 MPa
Hardness (ShoreD)	70-80
Tensile Elongation	30%

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. Industrial use only.

PACKAGING FORMAT

Cartridge -50ml, 490ml
Bulk - 19L pail, 190L drum

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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 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.