



# Technical Data Sheet

## Bondloc B3298 Structural Acrylic

### PRODUCT DESCRIPTION

B3298 is a 1:1 ratio, two component, toughened, methacrylate structural adhesive, formulated for high strength bonding of thermoplastics, metals and composites. The combination of minimal surface preparation and rapid fixture time makes it ideal for a variety of assembly operations. B3298 is rapid setting, shows excellent environmental resistance and has a gap fill capability of 5mm.

### APPLICATIONS

B3298 is suitable for bonding composites, thermoplastics and metals.

### USEFUL HINTS/NOTES

- High strength and modulus
- Rapid setting and curing
- 4–6 minute work life
- Minimal surface preparation

### INSTRUCTIONS FOR USE

- Some surface preparation maybe required. Ensure the surfaces to be bonded are clean of oil, dust, dirt and grease. Use B7063 Solvent Cleaner or PreBond Solvent wipes.
- Abrading/etching the surface can make bonded joints stronger and more durable. If required a second thorough clean should be carried out using MP120 Primer/Cleaner.
- Apply the adhesive, mate the substrates within the work life of the adhesive; 4–6 minutes.
- The bonded surfaces should be held in place or clamped for at least 25 minutes.

### TECHNICAL FEATURES

	Adhesive Part A	Activator Part B
Colour	Off white	Off white or Black
Appearance	Thixotropic Gel	
Viscosity (Brookfield) @23°C	500k–750k cps	400k–500k cps
	Spindle T-D @ 1.00rpm	Spindle 7 @ 2.5rpm
Shelf Life @ 23°C	12 months	
Storage	7 - 27°C	
Working Time	4 - 6 mins	
Fixture Time	12 – 15 mins	
Full Cure Time @ 23°C	24 hours	
Operating Temperature	-50 - 120°C	
Recommended application Temp	18 - 24°C	
Gap Fill	0.25 - 5mm	
Shore Hardness	75 Shore D	
Specific Gravity	Part A = 0.98 Part B = 0.96	

### TYPICAL PHYSICAL PROPERTIES

Property	Typical value
Tensile Strength *	30 MPa
Tensile Modulus	900-1000 MPa
Tensile Elongation	4-8%

\* ASTM D638 tested on Grit Blasted Mild Steel (GBMS)

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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.





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### 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. This product is classified for Industrial use.

### STORAGE

Store product in the unopened container in a dry area out of direct sunlight. Storage below 7°C or greater than 27°C can adversely affect product performance. Allow product to reach room temperature (18 - 24°C) before use.

### PACKAGING FORMAT

Cartridge – 25ml, 50ml, 400ml

Bulk - 19L pail, 190L drum

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