

# Technical Data Sheet

Bondloc B3278 Structural Polyurethane

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**BONDLOC**<sup>™</sup>  
**FORMULAS THAT WORK**

## B3278 Structural Polyurethane

### PRODUCT DESCRIPTION

B3278 is a two-component reaction adhesive for the building and automotive industry. Different pot life versions. For bonding ABS, rigid PVC, GRP, steel and aluminium.

### TECHNICAL PROPERTIES

	Part A	Part B
Base	Polyurethane, two part, solvent free	
Colour	Black	Yellow-white
Density	1,2 g/cm <sup>3</sup>	1,6 g/cm <sup>3</sup>
Viscosity, Brookfield RTV	40,000 mPas	20,000 mPas
Mix Ratio by Volume	1:1	
Mix Ratio by Weight	1:1,3	
Pot Life	5/2/1 min depending on A-component (see chart below)	
Hardness Shore D	65	

### PROCESSING

#### Processing temperature

+15°C to +25°C

#### Preparation

The surfaces must be clean, dry and free of grease. Metals must normally be pretreated and possibly sanded. Surfaces of glass fibre-reinforced plastics must also be sanded. Resin and hardener must be thoroughly mixed with a stirrer (approx. 400 revs/min) until the mixture shows a uniform colour. Prepare tandem cartridge as instructed.

#### Bonding

Apply adhesive evenly with a spatula or a doctor blade to the surfaces and join them.

The thickness of the adhesive layer depends on the properties of the materials to be bonded.

By different A-components, the pot life and the bond strengths can be varied. When using B3278, the bond can be exposed to light strain after 12 hours. Final bond strength is reached after 24 hours.

High temperatures will shorten the curing time, low temperatures will lengthen it

A-component	Pot life	Handling time after
B3278/5	5 minutes	1-2 hours
B3278/2	2 minutes	30 minutes
B3278/1	1 minute	15 minutes

### CLEANING

Clean tools immediately after use. Cured adhesive can only be removed mechanically.

### SAFETY

Please read our Safety-Data-Sheet and the labels of each product before use.

Pay particular attention to the directions given in the Dangerous Substance Regulations.

Make sure the safety data sheet is readily available as it gives valuable information regarding the safe usage and disposal of the product and what to do in the event of an accident involving the product.

### STORAGE

Do not store below +10°C and for more than 12 months.

### PRECAUTIONS

When processing B3278 avoid direct skin contact with the uncured adhesive. Wear protective gloves. Hazardous fumes may form when the product is heated or sprayed.

### PRESENTATION

B3278 is available in 50ml twin gun syringe and 400ml twin gun syringe.

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 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.