



Technical Data Sheet

Bondloc B3294 Plastic Weld

PRODUCT DESCRIPTION

B3294 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. B3294 is rapid setting, shows excellent environmental resistance and has a gap fill capability of 5mm.

APPLICATIONS

B3294 is suitable for bonding thermoplastics, composites 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
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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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 syringe

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