



# 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.

### 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	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%

Bondloc UK Ltd.  
Units 1 & 2  
Bewdley Business Park  
Bewdley, Worcestershire  
DY12 2TZ, UK

+44 (0) 1299 269 269  
sales@bondloc.co.uk





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### 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.

### 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

### PRODUCT DISCLAIMER

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