



Technical Data Sheet

Bondloc B2204 Steel Epoxy Bonder

PRODUCT DESCRIPTION

B2204 is two-part, cold curing epoxy adhesive. B2204 will bond a wide range of metals and plastics. B2204 has a medium length work-life, 90 mins, to cater for a long assembly time.

APPLICATIONS

General purpose metal and plastics assembly.

USEFUL HINTS/NOTES

- Clean & easy to use
- Viscous but not thixotropic
- Rapid curing

INSTRUCTIONS FOR USE

- Ensure that surfaces to be bonded are clean and free from grease, dirt, dust and any other contamination.
- Mix equal quantities either by weight or volume of the two parts and stir thoroughly until a colour is obtained. Where a static mixing nozzle is supplied the 2 parts will be mixed correctly upon dispensing.
- Apply to one surface and offer up the second surface. Clamp or jig together under light pressure. Leave to cure at room temperature.

CAUTION

Some instances have occurred of the Part 1 setting solid. This is due to it crystallising. It can be returned to normal by placing in a bath of hot water.

STORAGE

Stored under dry conditions in closed containers between 5 and 25°C B2204 will have a shelf life of 12 months.

ADHESION

METALS	Shear Strength		PLASTICS	Shear Strength	
	Psi	MPa		Psi	MPa
Steel	3500	24	HIPS	300	2.1
Steel, Abraded	2250	15.5	ABS	500	3.4
Stainless Steel	2950	20.3	Polycarbonate	550	3.8
Aluminium	2100	14.5	Perspex	580	4.0
Aluminium, Abraded	2400	16.6	GRP	870	6.0
Galvanised Steel	1800	12.4			

TECHNICAL FEATURES

	Part 1	Part 2
Physical Form	Viscous paste	
Appearance	Black	Cream
Viscosity @ 25°C	35,000cps	35,000cps
Specific Gravity	1.6	1.4
Mix Ratio	1:1	
Work Life	As a mix 90mins	
Temperature Range	-40°C to +121°C	

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

PACKAGING FORMAT

Cartridge.....50ml, 400ml

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 Units 1 & 2
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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 consider 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.

