



# Technical Data Sheet

## Bondloc B406 Rubber & Plastic Bonder

### PRODUCT DESCRIPTION

B406 is designed for bonding plastics and elastomeric materials where a very fast fixture is required.

### APPLICATIONS

B406 bonds metals, plastics, wood, ceramics, rubber, leather, card, glass and many other materials.

### INSTRUCTIONS FOR USE

Clean and dry surfaces to be bonded. Apply adhesive sparingly to one surface and assemble parts. Hold or clamp parts together for 60 seconds. Leave for 1 hour to fully cure. Activators and primers may be used to aid bonding.

### LIQUID PROPERTIES

Ester base	Ethyl cyanoacrylate
Appearance	Clear liquid
Specific Gravity 25°C	1.043g/cm <sup>3</sup>
Shelf life	12 months unopened
Viscosity Brookfield - S p 1 @20rpm @25°C	25 - 35 cps

### STORAGE

Bondloc cyanoacrylates should ideally be stored in original sealed containers until used. Containers should be stored between 2°C and 10°C with a maximum storage temperature of 25°C. Avoid exposure to strong light and heat sources. Refrigeration can prolong shelf life.

### TEMPERATURE RESISTANCE

Tested on mild steel cured for 24 hours, conditioned to test temperature for 1 hour before pull-test.

### ENVIRO-CHEMICAL RESISTANCE

Exposed to conditions for 1000 hours at 22°C except for 98% RH which had an exposure of 42°C.

### CURED PERFORMANCE

#### Cured Speed

Defined as the time taken to develop a strength of 0.1N/mm<sup>2</sup> at 22°C and 50% relative humidity.

Balsa	<2 seconds
Nitrile	<5 seconds
Neoprene	<5 seconds
EPDM	<5 seconds
Steel (degreased)	20-40 seconds
Polycarbonate	10-20 seconds
ABS	<5 seconds

### SHEAR STRENGTH

Steel	15-25 N/mm <sup>2</sup>
Aluminum	7-10 N/mm <sup>2</sup>
Nitrile Rubber	5-10 N/mm <sup>2</sup>
Polycarbonate	5-10 N/mm <sup>2</sup>
ABS	6-10 N/mm <sup>2</sup>

### TENSILE STRENGTH

Nitrile Rubber	5-15 N/mm <sup>2</sup>
Neoprene	5-15 N/mm <sup>2</sup>
EPDM	2-6 N/mm <sup>2</sup>

### 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

Bottles.....20g, 50g, 500g  
Clam Packs.....20g

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