

Technical Data Sheet

TDS B415 CYANOACRYLATE ADHESIVE

Revised 03.08.10

BONDLOC[™]
FORMULAS THAT WORK

Bondloc B415 Cyanoacrylate Instant Adhesive

APPLICATIONS

B415 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, colourless
Specific Gravity 25°C	1.06 g/cm ³
Shelf life	12 months unopened
Viscosity @ 25°C	1200 - 1800

CURED PERFORMANCE

Cured speed

Defined as the time taken to develop a strength of 0.1N/mm² at 22°C and 50% relative humidity.

Balsa	<3 seconds
Nitrile	<5 seconds
Neoprene	<5 seconds
EPDM	<5 seconds
Steel	25-40 seconds
Polycarbonate	10-30 seconds
ABS	10-15 seconds

SHEAR STRENGTH

Steel	15-25 N/mm ²
Aluminium	7-10 N/mm ²
Nitrile Rubber	5-10 N/mm ²
Polycarbonate	5-10 N/mm ²
ABS	6-10 N/mm ²

TENSILE STRENGTH

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

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.

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.

PRESENTATION

Bottles.....10gm, 20gm, 50gm, 500gm

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 is 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.