

**RoHS
Compliant**

Description

This 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. B3298 is rapid setting, shows excellent environmental resistance and has a gap fill capability of 5mm.

Applications

This is suitable for bonding composites, thermoplastics and metals.

Specifications

	Adhesive Part A	Activator Part B
Colour	Off white	Off white or Black
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°C to 27°C	
Working Time	4 mins to 6 mins	
Fixture Time	12 mins to 15 mins	
Full Cure Time @ 23°C	24 hours	
Operating Temperature	-50°C to 120°C	
Recommended application Temp	18°C to 24°C	
Gap Fill	0.25mm to 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)

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.

Part Number Table

Description	Part Number
Structural Bonder, High Strength, 50ml	MP-SB98-50

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