

Tuffbond[®] 312-1

Product Description

Hernon[®] Tuffbond[®] 312-1 is a slow curing epoxy adhesive. This flexible epoxy product has 2 components which need to be mixed well.

Typical Propertiets (Uncured)

| Property | Part A | Part B |
|---|----------------|----------------|
| Base | Epoxy | Amine |
| Appearance | Amber | Black |
| Viscosity at 25°C, HBT, spindle TB, 10 rpm (cP) ASTM D2556 | 80,000-140,000 | 70,000-140,000 |
| Specific Gravity | 1.21 | 1.05 |

Typical Properties (Cured)

| Property | Value |
|---------------------------------|---------------|
| Working Life at 22°C (20g) | 3-4 hours |
| Durometer Hardness*, ASTM D2240 | 60-75 Shore A |
| Glass Transition temperature | 8.3 °C |

*Mix ratio for A:B is 1:1 by volume, hardness was measured after 168 hours RT cure.

Typical Cured Performance

Shear Strength on lap-shear specimens tested according to ASTM D1002.

| Cure Time at 22°C | Substrate | Shear Strength (psi) |
|-------------------|---------------|----------------------|
| 24 hours | G/B steel | ≥ 300 |
| 24 hours | PVC | ≥ 300 |
| 24 hours | Polycarbonate | ≥ 300 |

General Information

This product is not recommended for use in pure oxygen and/or oxygen rich systems and should not be selected as a sealant for chlorine or other strong oxidizing materials.

For safe handling information on this product, consult the Safety Data Sheet (SDS).

Storage

Tuffbond[®] 312-1 should be stored in a cool, dry location in unopened containers at a temperature between 45°F to 85°F (7°C to 29°C) unless otherwise labeled. Optimal storage is at the lower half of this temperature range. To prevent contamination of unused material, do not return any material to its original container.

Dispensing Equipment

Hernon[®] offers a complete line of semi and fully automated dispensing equipment. Contact **Hernon[®] Sales** for additional information.

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