

## Tuffbond<sup>®</sup> 312

### Product Description

Hernon<sup>®</sup> Tuffbond<sup>®</sup> 312 is a slow curing epoxy adhesive. Epoxy system has 2 components which need to be mixed well.

### Typical Propertiets (Uncured)

Property	Part A	Part B
Base	Epoxy	Amine
Appearance	White- Lt Tan	Black
Viscosity at 25°C, HBT, spindle TB, 10 rpm (cP) ASTM D2556	90,000-130,000	80,000-120,000
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)
16 hours	G/B steel	≥ 200
24 hours	G/B steel	≥ 300
24 hours	PVC	441
24 hours	Polycarbonate	333
24 hours	FR4	1,500-2,500

### 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<sup>®</sup> 312** 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<sup>®</sup>** offers a complete line of semi and fully automated dispensing equipment. Contact **Hernon<sup>®</sup> Sales** for additional information.

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