



TECHNICAL DATA SHEET

TDS# 2729

DATE: JUNE 2013

BACON INDUSTRIES

FLEXOBOND 329

FLEXOBOND 329 is a two part non flowing urethane system which does not contain TDI, lead or mercury. This system gels rapidly, and cures to a tough rubbery solid with good adhesion to many substrates. FLEXOBOND 329 can be used as a fairing compound, adhesive or encapsulant. This material is capable of filling large gaps when required. FLEXOBOND 329 may be cured at either ambient or elevated temperatures. It generally can be handled (cautiously) in less than six hours from the initiation of ambient cure.

RECOMMENDED MIXING AND HANDLING PARAMETERS

| | |
|--|---------------|
| Resin | Flexobond 329 |
| Activator | Activator 329 |
| Parts by weight of activator required per hundred of resin | 25.6 |
| Work life at Room Temperature (10 g), minutes | 60 |
| Gel Time at Room Temperature (10 g), minutes | 75 |

| | <u>Hardness</u> | |
|-----------|--------------------------------|----------------|
| | <u>Minutes from time mixed</u> | |
| | <u>Shore A</u> | <u>Shore D</u> |
| 0 hours | soft paste | soft paste |
| 1 hour | soft | soft |
| 2 hours | soft (gelled) | soft (gelled) |
| 3-6 hours | firm (gelled) | firm (gelled) |
| 1 day | 73 | 21 |
| 7 days | 90 | 36 |

| | |
|--------------------------|-------|
| Recommended cure, hr/°F: | 2/212 |
| Alternate cure, hr/°F: | 24/77 |

TYPICAL PROPERTIES OF CURED ADHESIVE:

| | |
|-------------------------------------|-------|
| Color | Black |
| Specific Gravity | 1.1 |
| Lap Shear Strength to aluminum, psi | 1500 |

| Hardness | <u>After Recommended Cure</u> | <u>After Alternate Cure</u> |
|----------|-------------------------------|-----------------------------|
| Shore A: | 72 | 73 |
| Shore D: | 22 | 21 |

(over)

SOLVENT RESISTANCE

Passes Pencil Hardness test per MIL-C-27227.

FOR INDUSTRIAL USE ONLY! WARNING! VAPOR HAZARDOUS!

CAUTION: FLEXOBOND 329 may cause skin irritation. Use with adequate ventilation. Avoid contact with skin or clothing. In case of contact, flush immediately with plenty of water. Keep containers tightly closed when not in use.

WARNING: Activator BA-329 contains diisocyanate which is a strong skin sensitizer and may cause severe irritation to mucous membranes. Avoid contact with skin and eyes and avoid breathing vapors. Use with adequate ventilation. In case of skin contact, wash promptly with 99% isopropyl alcohol (rubbing alcohol is NOT suitable) to remove resin, then soap and water.

SHELF LIFE:

The Shelf Life of FLEXOBOND 329 is greater than one year when stored below 95°F in closed containers. If crystallized, preheat material (loosen cover) to 160°F. Allow material to cool to room temperature before mixing. The Shelf Life of Activator BA-329 is greater than one year when stored below 95°F. The ideal storage temperature for Activator BA-329 is between 80°F and 95°F. Below 80°F, Activator BA-329 may crystallize and, if crystallized, must be decrystallized before use. If crystallized (loosen cover), preheat to 140°F until clarity is obtained. Excessive heating degrades material. The total of all periods of time at 140°F should not exceed three hours. These materials are moisture sensitive and should be tightly capped. Back filling partially empty containers with dry nitrogen is recommended.

AVAILABILITY:

FLEXOBOND 329 is available in Three Ounce ONE-SHOT Kits (not requiring weighing) and in Five Ounce Preweighed Kits (which require weighing). FLEXOBOND 329 is available also in pint and quart kits which require weighing. The quart kits contain a quart friction top can of FLEXOBOND 329 plus one-half pint oblong can of Activator BA-329. The pint kits contain a pint friction top can plus a one-half pint oblong can. The quart and pint kits contain totals of two pounds and one pound respectively. The materials are available in gallon and five gallon kits by special order.