



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

Hardness

Minutes from time mixed

	<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)

