



The Glue People

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B350

Structural, UV Glass Cyanoacrylate

General Description

B350 Structural UV Glass Bonder is a highly reactive urethane methacrylate resin that is designed for all types of glass bonding which can be cured by UV light. The liquid is highly reactive to UV forming glass to glass or glass to metal bonds in seconds.

B350 Structural is also resistant to ageing once cured, exhibiting excellent strengths retention properties and resists the action of yellowing during long term exposure to the elements.

Curing Characteristics

UV365N is needed to cure B350. Some lamps provide a second cure at lower wavelengths which assist the cure.

Heat is generated by some high intensity (high powered) lamps. This can cause problems by over exposure and increased reactivity in the resin, building up excessive heat or stress.

Ideal conditions can be provided by optimising some of the work parameters. Low intensity lamps will give a slower cure and take longer to cure big gaps.

Examples are as follows for UV B350.

10mW / cm² > 25mm up to 5mm gap
Approximate time 80-100 seconds
> 1mm up to 0.5mm gap
Approximate time 40-60 seconds

50-100mW / cm² > 25mm up to 5mm gap
Approximate time 15-20 seconds
> 0.1mm up to 0.05mm gap
Approximate time 5-10 seconds

High intensity lamps are required to get dry to touch bonds. Glass thickness has an effect on cure time even on clear material causing reflection and a degree of absorption, opaque glass or tinted glass will give irregular results.

Bond strengths reduce at elevated temperatures, typically to 30% for cured materials tested at 120°C in comparison to its ambient results at 20°C.

Application

Suitable surface preparation is recommended ensuring grease/oil films or other contaminants such as those found in some glass cleaners are not present. The adhesive can be applied directly from the container. Ensure excess material outside of the joint can be removed by cutting. Light intensity, distance and UV waveband(s) all contribute to bonding.

Excessive / uneven cure area can lead to stress build up in large parts. Ensure good uniform of displacement of adhesive is made on parts and also that the UV light is evenly distributed over the parts. Heat can be generated by UV lamps. Always ensure safety with materials to be bonded to control the over heating of the parts.

Fully Cured State

Typical hardness	70-75 (shore D)
Tensile strength	25N / mm ²
Elasticity	Approx. 150%
Recommended gap max.	0.15mm
Operating temperature	-50°C to +125°C
Environmental resistance RH 98 C @ 20°C	Excellent
Solvent resistance	Good
Use on plastics	Test recommended

General Information

For safe handling information on this product, consult the material safety data sheets, (MSDS).

Storage

Products should be ideally stored in a cool, dry location in unopened containers at a temperature between 8° to 28°C (46° to 82°F) unless otherwise labeled. Optimal storage is at the lower half of this temperature range. To prevent contamination of unused product, do not return any material to its original container. For specific shelf-life information, contact Trade Grade Products at the above address.

Important Notice

This leaflet is for general guidance only and may contain inappropriate information under particular conditions of use. All recommendations and suggestions are therefore made without guarantee. Samples will be provided upon request to enable customers to satisfy themselves as to the suitability of the product for any specific purpose and to assess the product under their own working conditions.

Before using this product ensure that you have been supplied with and have read carefully the following information.

- The hazard label (complying with latest CDG/CPL regulations) applied to the container.
- Material Safety Data Sheet, Tradelock B350.