

## B200 – Technical Data Sheet



Bondrite Adhesives Limited  
Unit 3H  
Sileby Road Industrial Estate  
Barrow-Upon-Soar  
Leicestershire LE12 8LP  
Tel: 01509 815550

### Description

**B200** is a low-viscosity, fast-curing, single -component cyanoacrylate adhesive, specifically formulated for difficult to bond substrates, particularly suitable for bonding plastic or rubber (EPDM) parts, where very fast fixing is required.

**B200** is a one-component, solvent-free system and does not require the use of a catalyst, heat or clamps. When a thin layer of **B200** applied between two surfaces comes into contact with atmospheric moisture, a rapid polymerization occurs producing the ultimate bond.

### Properties of Liquid State

Base	Ethyl Cyanoacrylate
Colour	Clear
Specific Gravity (20°C)	1.053~1.060
Refraction Index (n 20D)	1.439
Flash Point (°C)	>80°C
Shelf Life	12 months
Boiling Point (°C)	65/6mm Hg
Viscosity (cP)	10-30

### Properties of Cured State

Colour	Clear
Specific Gravity (20°C)	1.05~1.2
Working Temperature (°C)	-55 °C - 80°C
Refractive Index (n 20D)	1.49
Dielectric Constant (at 10MHz)	3.5
Dielectric Loss (at 10MHz)	0.067

Soluble in Acetone, Dimethyl formamide, Nitromethane, Dimethyl sulfoxide

### Directions for Use

1. Make sure the surfaces to be bonded are clean and dry (preferable to solvent-wipe plastics glass, and rubber, and to acid-treat metals).
2. Dispense a drop or drops to one surface only. Apply only enough to leave a thin film after compression.
3. Press parts together and hold firmly for a few seconds. Good contact is essential. In most cases, an adequate bond develops in less than one minute (see table 'Cure speed of **B200** for various materials' for more information). Maximum strength is achieved in 24 to 48 hours.
4. Wipe off excess adhesive from the top of the container and recap **B200**. If left uncapped, may deteriorate by contamination from moisture in the air.
5. Because **B200** polymerises on contact with moisture surfaces, sometimes whitening will occur on

the surface of the container or the bonded materials. Should this happen, wipe surfaces well with de-bonder.

### Cure speed of B200 for various materials

Materials bonded	Time to achieve adequate bond (s)
ABS to ABS	4-6
Wood to wood	>60
ABS to stainless steel	50-60
NBR to stainless steel	>60
NBR to NBR	3-5
Stainless steel to stainless steel	45-55
ABS to NBR	3-5
Wood to ABS	>60

### Bond strength of B200 for various materials

Materials bonded	Tensile Shear Strength (kg/cm <sup>2</sup> )
Rigid PVC to rigid PVC	4-6
ABS to ABS	>60
Polycarbonate to polycarbonate	50-60
Polystyrene to polystyrene	>60
Natural rubber to natural rubber	3-5
*Neoprene to neoprene	45-55
NBR to NBR	3-5
ABS to SBR	>60
SBR to SBR	5-10
Steel to Steel	190-210
Stainless steel to stainless steel	160-180
Aluminum to aluminum	170-190
Copper to copper	150-170
Steel to rigid PVC	50-60
Stainless steel to neoprene	5-10

## **Precaution**

1. Use with proper ventilation. Avoid contact with skin and eyes.
2. If contact with skin occurs, rinse with warm water or dissolve gradually with appropriate debonder. Do not try to remove forcibly.
3. If adhesive gets into eye, keep eye open and rinse thoroughly. Seek medical attention immediately.
4. Keep well out of reach of children.
5. Keep adhesive in a cool, dry place 20-25°C. For long term storage, refrigeration (5°C) is recommended.

### **Please consult the B200 Health & Safety Data Sheet for statutory regulation information.**

Information relating to the products of Bondrite Adhesive Limited is based on tests carried out under laboratory conditions. If any of our products are not used in accordance with our instructions or are used under conditions which vary from our laboratory, they may not perform in accordance with any information provided and Bondrite shall not have any liability in this case. Bondrite will accordingly provide samples of our products, on request and free of charge, for customers to carry out their own tests as to suitability of our product for their purposes and as used in their intended environment.

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