**Technical Datasheet**

**Holdtite ST3294**

**Product Description**

Holdtite ST3294 is a two component structural methacrylate adhesive, designed for the bonding of high strength metal and composite applications.

**Typical Applications**

Holdtite ST3294 is very versatile, and can bond a wide variety of substrates without the need for surface primers or conditioners. Typical examples shown below:

* Sign fabrication and installation
* Bonding automotive carbon fibre body panels
* Bonding magnets to motor housings
* Bonding dissimilar metals for trailer fabrication

**Instructions For Use**

1. Always consult MSDS before using ST3294 for the first time.
2. Carry out surface preparation where required. \*
3. Remove cap, and attach mixer nozzle.
4. Dispense sufficient adhesive to ensure equal mix.
5. Apply adhesive to one surface and assemble components carefully, clamping if required.
6. It is always easier to remove any excess adhesive prior to cure using a suitable cleaner \*
7. Allow the adhesive sufficient time to achieve handling strength before moving or unclamping components.

***\*Contact your Bondchem representitive for full***

***information and usage instructions.***

**Properties of Uncured Material**

|  |  |
| --- | --- |
| Resin | Methyl Methacrylate |
| Colour | Green/Pink |
| Appearance | Liquid |
| Viscosity Brookfield T Bar  | 4000cps  |
| Cure System | Exothermic |
| Open Time  | 2-3 Minutes @200C |
| Handling Strength | 4-5 Minutes@ 200C |

**Performance of Cured Material**

|  |  |
| --- | --- |
| ASTM D1002 Lapshear |  |
| Steel  | 27 Nmm2  |
| Aluminum | 14 Nmm2  |
| Polycarbonate | 12Nmm2 (Substrate Failure) |
| ABS | 8Nmm2 (Substrate Failure) |
| Temperature Range | -35°C to 180°C |

**Packaging**

Holdtite ST3294 is available in 25ml, 50ml and 400ml Nylon cartridges for use with a dispensing gun.

**Storage & Shelflife**

Holdtite ST3294 should be stored unopened in a cool dry location, out of direct sunlight. Stored correctly , this grade can offer a 12 month shelf life from manufacture.

**Health and Safety in Use**

**Holdtite ST3294 is a methyl methacrylate and should not be used without consulting the MSDS, which contains full information regarding the use of this product, including Transport, Disposal, Toxicological, Exposure Controls, Accidental Release and First Aid measures essential to the safe use of this product.**