

BD8005-Structural Acrylic Adhesive

Low surface energy Plastic Bonder

1. DESCRIPTION

BD8005 is a two-part structural acrylic adhesive, designed for bonding of various plastic substrates, including low surface energy plastics like polyethylene and polypropylene, without any surface preparation. Combined at a ratio of 10:1, BD8005 has a working time of 2 to 5 minutes and achieves handling strength in 3 hours at room temperature curing.

Company Identification: Big Dog Adhesives LLC.

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2. CHARACTERISTICS:

Room Temperature Cure	Properties
• Working Time	2 - 5 minutes (at 75°F/ 24°C)
• Color	off white
• Fixture Time	8 hours (at 75°F/ 24°C)
• Can be Moved In	4 hours
• Mixed Density	1.02 Kg/l
• Hardness (shore D)	58-65

3. CHEMICAL RESISTANCE:

Resistance to:

- IPA
- Pump oil
- Gasoline
- Toluene

4. PHYSICAL PROPERTIES:

Uncured:	Resin	Activator
• Viscosity(cps)	15,000 – 20,000	30,000 -40,000
• Color	off white	Clear-translucent
• Density (lbs/gal)	0.98	1
• Mix Ratio (wt or vol)	10	1.0

5. MECHANICAL PROPERTIES:

Lap Shear Strength (ASTM D1002)	Substrate	Results	Failure Type
• Strength, psi	LDPE	350+	Substrate
• Strength, psi	ABS	950+	Substrate
• Strength, psi	Cold roll Steel	1000+	Cohesive
• Strength, Psi	Aluminum	1800+	Cohesive

6. HANDLING AND APPLICATION:

Keep containers closed after use. Wear gloves and safety glasses to avoid skin and eye contact. Wash with soap and water after skin contact. In case of eye contact, flush with water for 15 minutes and get medical attention. Harmful if swallowed. Keep out of the reach of children. Refer to the BD8005 Safety Data Sheet for more complete safety instruction.

All the substrates to be bonded should be clean and free from dust and oils to ensure maximum strength and environmental resistance. To assure maximum bond strength, surfaces must be mated together within the specified working time, and all clamps affixed within that time. Use sufficient material to ensure that the joint is completely filled when parts are mated and clamped. Avoid over clamping parts, which may cause a dry joint or a joint starved of adhesive. All adhesive application, part positioning, fixturing, and clamping should occur before the working time of the adhesive has expired. After the indicated working time, parts must remain undisturbed until the fixture time is completed.

7. HANDLING AND STORAGE

The shelf life of BD8005 is six (6) months from the date of shipment if stored unopened in the original containers. Storage of BD8005 adhesive in refrigerated compartments will extend the shelf life even more. Be sure to bring BD8005 adhesive to room temperature for 24 hours before use, otherwise longer cure and fixture times may be expected. Long-term storage at temperatures above room temperature will shorten the shelf life of BD8005 adhesives considerably. Storage in the dual cartridges or in bulk at 5 °C or below is recommended.

ADDITIONAL INFORMATION

NOTE: Information contained herein is based on tests we believe to be reliable and accurate. It is offered in good faith for the benefit of the consumer. The Company shall not be liable for any injury, loss, or damage in the use or handling of its chemical products since conditions and use are beyond our control. In every case, we urge and recommend the user conduct tests to determine to their own satisfaction that the product is of acceptable quality and suitability for their particular purpose under their own operating conditions. Statements concerning possible use of our products are not intended as recommendations to use our products in the infringement of any patent, or for any particular purpose or application. These products are intended for industrial use only.
