

ONEBOND 8760 FAST PUTTY RESIN

Description

ONEBOND 8760 is a rigid, UV stable, fast curing putty resin. ONEBOND 8760 cures at room temperature and can be applied underwater. ONEBOND 8760 can be drilled, sawed, sanded and painted 4 hours after application time. ONEBOND 8760 bonds well rigid substrates such as metals, plastics, ceramic, wood, composites, concrete, etc.

Typical component properties⁽¹⁾

	Unit	Resin (Component A) Bisphenol-A epoxy	Hardener (Component B) Mixture	Test Method
Appearance		Grey	Yellowish light grey	
Odor		Light	Light	
Density @+25°C	g/ml	1,17	1,15	
Viscosity @+25°C	cP	Putty	Putty	
Flash Point	TCC, °C	>200	>93	
	Unit	Mixture		
Appearance		Grey non sagging		
Density @+25°C	g/ml	1.2		
Mix Ratio by Volume	R:H	1:1		
Mix Ratio by Weight	R:H	1:1		

1: These are typical values and should not be construed as specifications.

Typical curing properties⁽¹⁾

	Unit	Mixture
Open time	Minutes	2 – 3
Tack-free time	Minutes	5
Sanding/Painting time	Minutes	30
Full cure time	Hours	24

1: These are typical values and should not be construed as specifications.

Typical properties of the cured material⁽¹⁾

	Unit	Mixture	Test Method
Tensile Strength	MPa	30	ASTM D-638
Elongation at Break	%	3	ASTM D-638
Hardness Shore A		N/A	ASTM 2240

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	Unit	Mixture
Stiffness	kN/m	
Glass Transition Temperature	°C	81
Temperature range	°C	<150
Maximum gap	mm	No limitations

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Fixture time

Substrate	Unit	Mixture
Plastics Polycarbonate, ABS, PVC, Phenolic Resin.	Hours	4
Metals Aluminum, Mild Steel, Cold Rolled Steel, Zinc.	Hours	4
Wood Pine, Beech, Oak, Fir, Teak, Balsa, Chipboard, Baywood.	Hours	4
Others Ceramic, Glass	Hours	4

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Lap Shear Strength⁽¹⁾

Substrate	Unit	Mixture	Test Method
Polycarbonate	N/mm ²		ISO 4587
ABS	N/mm ²		ISO 4587
PVC	N/mm ²	0,5 – 1 ⁽²⁾	ISO 4587
EPDM	N/mm ²		ISO 4587
PMMA	N/mm ²		ISO 4587
Mild Steel	N/mm ²		ISO 4587
Aluminum	N/mm ²	1,5 – 2 ⁽²⁾	ISO 4587
Pine wood	N/mm ²	1,5 – 2 ⁽²⁾	ISO 4587
Beach Wood	N/mm ²		ISO 4587

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2: Cohesive failure of the adhesive. 3: Substrate failure

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Handling

Clean and degrease the surface with ONEBOND Cleaner and allow drying before applying the adhesive.

The surface can be sanded with sand paper. After sanding, remove the dust, degrease the surface and clean the surface with water.

Put on the gloves to avoid skin contact with the adhesive.

This adhesive is hand mixed. Take the desired amount of adhesive from both bars (1:1 ratio) and mix both components thoroughly for approximately 15 seconds until a grey uniform paste is obtained.

Apply the product within 2 minutes after mixing (it is exothermic), applying pressure against the surface to be repaired.

Fingerprints can be removed before before hardening by rubbing the adhesive surface with a water.

The excess of uncured adhesive can be cleaned with ketone type solvents.

Storage

	Unit	Resin (Component A) Bisphenol-A epoxy	Hardener (Component B) Mercaptan
Recommended temperature	°C	5 - 25	5 - 25
Storage stability / Shelf life ⁽⁴⁾	Months	24	24

4: Stored in the original sealed containers at the recommended temperature.

Safety Considerations

Safety Data Sheets (SDS) are available from ONEBOND. SDS include information regarding the physical, health, and environmental health hazards, safety precautions, for products handling, storing and disposal. SDS are available in the language of the country or area of destination and may include locally applicable health and safety regulations. SDS are updated regularly and can be downloaded from www.onebondadhesives.com. ONEBOND encourages users to review the up-to-date SDS before handling or using any product.

Customer Notice

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