

BB470 tooling board adhesive is specifically compatible with our range of medium-density polyurethane (PU) tooling boards, for bonding of boards.

## COMPATIBILITY

BB470 can be used for bonding of any of the following tooling boards:

- BP600
- BP700
- BP701
- BP750
- BP850

## FEATURES & BENEFITS

BB470 provides a high-strength adhesion and offers room temperature curing.

- Colour and density matched to BP700 and BP701
- Good adhesion to a wide range of materials
- Good open life
- High mechanical properties
- Room temperature curing

## TECHNICAL PROPERTIES

| PROPERTY                                                                        | VALUE    |
|---------------------------------------------------------------------------------|----------|
| COLOUR                                                                          | Brown    |
| HARDNESS, SHORE D (+/- 3), ISO 868                                              | 70       |
| RESIN DENSITY, G/CC (+/- 0.3)                                                   | 0.76     |
| HARDNER DENSITY, G/CC (+/- 0.3)                                                 | 1.03     |
| GLASS TRANSITION TEMPERATURE (T <sub>g</sub> ) DSC, POST CURED °C (+/- 5)       | 100      |
| RESIN VISCOCITY, 50°C, CPS (+/- 300)                                            | 1,600    |
| HARDENER VISCOCITY, 50°C, CPS (+/- 60)                                          | 220      |
| GEL TIME, 25 °C, 150G MASS, MINUTES (+/- 5)                                     | 45       |
| THIN FILM GEL TIME, 25 °C, HOURS                                                | 3 - 4    |
| APPROX. COVERAGE PER PACK (SUBSTRATE DEPENDENT, M <sup>2</sup> @ 1MM THICKNESS) | 7.5      |
| MIX RATIO BY WEIGHT, RESIN : HARDNER                                            | 100 : 20 |
| PACK SIZE, PART A, KG                                                           | 5        |
| PACK SIZE, PART B, KG                                                           | 1        |

## PACK SIZES

BB470 is a two part adhesive, available in a pack size of 5kg part A and 1kg part B.

## STORAGE OF MATERIAL

The product must be stored indoors, on a flat dry surface at a temperature between + 15 °C to + 40 °C. After use, tightly reseal.

The resin component may crystallize during storage. If crystallized, vent container and heat to + 55 °C to + 65 °C until crystals dissolve.

Stir well after product has liquefied.

## SHELF LIFE

24 months from date of manufacture.

## SUBSTRATE PREPERATION

All surfaces should be free of contamination. Any cleaning solutions must be allowed to evaporate before application of BB470.

## USAGE

Always use clean dry tools for mixing and applying.

Mix according to the mix ratio stated above (100:20 by weight).

Mix thoroughly and use immediately.

Material temperatures should not be below + 18°C when mixing.



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## CONTACT US

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