BB470
TOOLING BOARD ADHESIVE

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

COMPATIBILITY

BB470 an 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 (Tg) 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^2 @ 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 ^{O}C to + 40 ^{O}C. After use, tightly reseal.

The resin component may crystallize during storage. If crystallized, vent container and heat to + 55 ^{O}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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