

Tuffbond® 313

Product Description

Hernon® Tuffbond® 313 adhesive/sealant is a two component, 100% solid system, one to one ratio, room temperature cure system. Tuffbond® 313 is recommended for bonding metals, wood, ceramics, etc., and can be used for potting and encapsulation of electrical and electronic components.

Typical Applications

- Marine coating
- Underwater coating
- Potting electronic boards
- Encapsulating electrical and electronic components

Product Benefits

- Good mechanical properties.
- Outstanding resistance to abrasion.
- Non-critical mixing.

Typical Properties (Uncured)

Property	Part A	Part B
Base	Epoxy	Amine
Appearance	White	Light Yellow
Viscosity at 25°C, cP	18,000 to 26,000	18,000 to 26,000
Mix Ratio by Weight	1	1
Specific Gravity	1.17	0.97

Typical Properties (Cured)

Property	Value
Working Life at 22°C (100g), minutes	40 to 60
Hardness, Shore D, ASTM D2240	70-80
Shear Strength – GB Steel, psi ASTM D1002	2500 - 4000
Dielectric Constant at 1kHz	3.38
Dissipation Factor at 1kHz	0.15089
Dielectric Strength, V/m	5-7

Strength Properties at Different Temperatures

0.25 mm gap and ½ inch overlap on grit-blasted steel
Tested at temperatures indicated, according to ASTM D1002.

Temperature	Shear Strength (psi)
23°C (room temperature)	1,000 – 1,500
-55°C	1,300 – 2,000
80°C	150 – 400
155°C	150 – 400

General Information

This product is not recommended for use in pure oxygen and/or oxygen rich systems and should not be selected as a sealant for chlorine or other strong oxidizing materials.

For safe handling information on this product, consult the Safety Data Sheet (SDS).

Storage

Tuffbond® 313 should be stored in a cool, dry location in unopened containers at a temperature between 45°F to 85°F (7°C to 29°C) unless otherwise labeled. Optimal storage is at the lower half of this temperature range. To prevent contamination of unused material, do not return any material to its original container.

Dispensing Equipment

Hernon® offers a complete line of semi and fully automated dispensing equipment. Contact **Hernon® Sales** for additional information.

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