

# BONDPRO 215

## EPOXY ADHESIVE



### PRODUCT DESCRIPTION

**BONDPRO 215** is a fast cure toughened epoxy adhesive offering outstanding performance in numerous bonding applications. It is ideally suited for assembly of components constructed from different materials.

- 60 Minutes working time at 18°C
- Cured solid in 4 hours
- Mix ratio by volume 1:1
- Bonds multiple substrates
- Black cured colour

### SUITABLE SUBSTRATES

**BONDPRO 215** offers strong adhesion to various substrates, including wood, metal, ceramics, certain plastics, and composites. It creates durable bonds with exceptional shear strength.

### HEALTH AND SAFETY

Gurit produces a separate full Safety Data Sheet for all hazardous products. Please ensure that you have the correct SDS to hand for the materials you are using before commencing work.

### STORAGE AND HANDLING

Storage should be in a warm dry place out of direct sunlight and protected from frost. The storage temperature should be kept constant between 10°C and 25°C, fluctuations in temperature can cause crystallization.

BONDPRO 215 Resin	14months at 10-25°C
BONDPRO 215 Hardener	14months at 10-25°C

### SURFACE PREPARATION

Ensure surfaces are clean, dry, and free of grease before applying the adhesive. Use an appropriate solvent, such as acetone or isopropanol, to degrease the surfaces. For metals like aluminium, copper, and their alloys, light abrasion with an emery cloth or similar material can help remove the oxide layer and improve adhesion.

### UNCURED COMPONENT PROPERTIES

	BONDPRO 215 RESIN	BONDPRO 215 HARDENER
<b>Appearance</b>	Black	Orange
<b>Viscosity @ 25°C</b>	245 +/- 30 P	30 +/- 5 P
<b>Density @ 21°C</b>	1.18	1.03

### APPLICATION PROPERTIES

<b>Mix Ratio by Volume</b>	1:1
<b>Gelation Time @ 21°C</b>	60 Minutes
<b>Handling Time @ 21°C</b>	240 Minutes
<b>Application Thickness @ 21°C</b>	0.5 – 5 mm
<b>Glass Transition DSC Tg°C</b>	70-75°C

### BONDING PERFORMANCE (Metals)

<b>Lap Shear Strength** (Steel)</b>	20 - 22 MPa
<b>Lap Shear Strength ** (Aluminium)</b>	20 - 22 MPa
<b>Cleavage Strength (Steel)*</b>	5 kN

\*BS 5350 Part C1 \*\*BS 5350 Part C5



## DIRECTIONS FOR USE

### Cartridge Application Instructions:

#### Prepare the Cartridge:

- Insert the cartridge into the application gun and align the plunger.
- Remove the cartridge cap and dispense a small amount until both components flow evenly.
- Attach the static mixer to the cartridge and begin dispensing, ensuring the adhesive is fully mixed (uniform black with no streaks).

#### Application:

- Apply the mixed adhesive to one of the substrates.

#### Assembly:

- Join the parts before the adhesive gels which is typically 30-50 minutes after mixing. The gelation time will depend on application thickness and ambient temperature.

#### Pot Life Considerations:

- Large quantities or higher temperatures will shorten the working time.

#### Curing Process:

- Apply clamping pressure for at least 3 hours or until the assembly reaches handling strength.
- Cure is achieved after 2 days at 21°C (73°F).

*For professional or industrial use only. This Technical Datasheet (TDS) provides general guidelines and does not serve as a formal specification.*

## BONDING PERFORMANCE (Plastics)

### Lap Shear Strength\*\*

Polycarbonate	2 - 3 MPa
ABS	2.5 - 3 MPa
Acrylic	2 - 2.5 MPa
Nylon 6	2.5 - 2.8 MPa
PVC	2.5 - 3 MPa
G10 Epoxy Laminate	13 - 14 MPa

\*\*BS 5350 Part C5

## STRENGTH DEVELOPMENT

Cure Time @ 21°C	Lap Shear Strength
24 Hours	8 MPa
48 Hours	13 MPa
72 Hours	17 MPa

## CURED MECHANICAL PROPERTIES

Tensile Strength* (ISO 527-2)	30-35 MPa
Tensile Modulus* (ISO 527-2)	1.8-2 GPa
Tensile Elongation* (ISO 527-2)	15-20%
3 Point Flexural Strength* (ISO 178)	55-60 MPa
3 Point Flexural Modulus* (ISO 178)	1.7-1.9 GPa
3 Point Flexural Strain* (ISO 178)	5%

\*Test temperature 23°C

## NOTICE

All advice, instruction or recommendation is given in good faith but the selling Gurit entity (the Company) only warrants that advice in writing is given with reasonable skill and care. No further duty or responsibility is accepted by the Company. All advice is given subject to the terms and conditions of sale (the Conditions) which are available on request from the Company or may be viewed at Gurit's Website: [www.gurit.com/terms-and-conditions.aspx](http://www.gurit.com/terms-and-conditions.aspx)

The Company strongly recommends that Customers make test panels in the final process conditions and conduct appropriate testing of any goods or materials supplied by the Company prior to final use to ensure that they are suitable for the Customer's planned application. Such testing should include testing under conditions as close as possible to those to which the final component may be subjected. The Company specifically excludes any warranty of fitness for purpose of the goods other than as set out in writing by the Company. Due to the varied nature of end-use applications, the Company does, in particular, not warrant that the test panels in the final process conditions and/or the final component pass any fire standards.

The Company reserves the right to change specifications and prices without notice and Customers should satisfy themselves that information relied on by the Customer is that which is currently published by the Company on its website. Any queries may be addressed to the Technical Services Department.

Gurit is continuously reviewing and updating literature. Please ensure that you have the current version by contacting your sales contact and quoting the revision number in the bottom left-hand corner of this page.

## CONTACT INFORMATION

Please see local contact information at [www.gurit.com](http://www.gurit.com)

[customer.support@gurit.com](mailto:customer.support@gurit.com)

All trademarks used or mentioned in this document are protected by law.

## 24-HOUR CHEMICAL EMERGENCY NUMBER

For advice on chemical emergencies, spillages, fires or exposures:

Europe: +44 1273 289451  
Americas: +1 646 844 7309  
APAC: +65 3158 1412

