

Technical Data Sheet Tuffbond[®] 319

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Product Description

Hernon[®] Tuffbond[®] 319 is a two-component modified epoxy adhesive. It provides a very fast room temperature cure, and exhibits very good moisture, chemical, and heat resistance.

Tuffbond[®] 319 is specially formulated for rapid in-line assembly of loud speakers. It is also recommended for bonding metals, wood, ceramics, etc., and can be used for potting and encapsulation of electrical and electronic components.

Typical Applications

- Bonding voice coil to cone
- Bonding pole piece to magnet
- Bonding alnico magnet to base
- Rapid curing structural and electrical repair kit
- Rapid curing laminates and "gel" coat
- Potting electronic boards
- Encapsulating electrical and electronic components

Typical Properties (Uncured)

Property	Part A	Part B
Base	Epoxy	Amine
Appearance	Clear	Clear
Viscosity at 25°C, cP	22,500	22,500
Specific Gravity	1.18	0.98
Mix Ratio by Weight	100	100

Typical Properties (Cured)

Property	Value
Working Life at 22°C (100g), minutes	15
Operating Temp., °F	-65 to 180
Shear Str. on Al, 24 hour cure at 22°C	2400 psi
Shear Str. on Al, 30 day cure at 22°C	2600 psi

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 Material Safety Data Sheet (MSDS).

Storage

Tuffbond[®] 319 should be stored in a cool, dry location in unopened containers at a temperature between 46°F to 82°F (8°C to 28°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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