

# CLICK BOND

CB359 is a two component structural adhesive which exhibits high peel and high tensile lap shear strength. This adhesive has excellent resistance to water, salt spray, and most organic fluids. A variety of substrates such as metals, thermoplastics, and composites may be bonded using CB359 structural adhesive. CB359 is offered in a two:one cartridge with a static mixer.

<b>AEROSPACE SPECIFICATIONS</b>
Boeing – DPM3279-5

- High shear strength
- High peel strength
- Non sag
- Available in a dual pack cartridge with a static mixer.
- Good environmental resistance
- Bondline thickness
- Easy mix

Appearance: Part A: Yellow Part B: Blue  
 Cure time at 75°F: 24 hours - handling strength. 5 – 7 days - full cure.  
 Work time at 75°F: 60 minutes (small quantities). Accelerated cure: 1 hour (180°F) – full cure.  
 Mix Ratio: 2:1 (A:B) by volume.

Shear Strength: (ASTM D1002)	Peel Strength: (ASTM D1876)	Compressive Strength: (ASTM D695)	Service Temperature Range:
4500 psi	60 pli	7700 psi	-67°F to 200°F

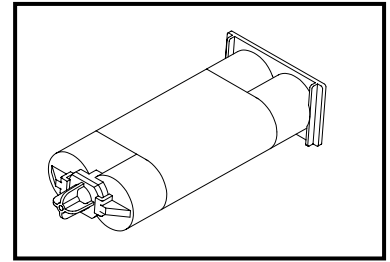
CB359 should be stored in a cool (below 72°F), dry place when not used for a long period of time. CB359 has a minimum shelf life of 6 months when stored in the original package at 72°F. Shelf life may be extended to one year by refrigeration at between 35°F and 50°F.

Surface preparation is an important part of adhesive bonding. Lightly abrade glossy surfaces to improve the adhesive bond. Just prior to adhesive application, clean surfaces with solvent using clean rags or paper towels. Do not use shop towels, rags or paper wipes contaminated with oil, soap, or reclaimed solvents. Wash one small area at a time, then dry with a clean cloth before the solvent evaporates to prevent redeposition of contaminants. To maintain a clean solvent supply, always pour the solvent on the washing cloth.

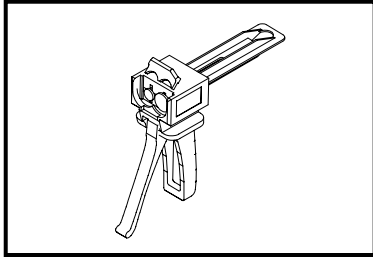
Dispense 2 parts of component A and one part of component B. Mix until a uniform color is obtained (or use a disposable mixing nozzle). Apply to one of the surfaces to be bonded. To assure maximum bond strength, surfaces must be mated within 10 minutes. Use sufficient material to insure 100% joint fill when parts are mated. All adhesive application, part positioning, and clamping should occur before the 60 min. working time of the mix has expired. Movement of the parts after working time has expired can result in bond strengths lower than normal. Insure that the assembly remains undisturbed for 24 hours to allow adhesive cure to progress to the handling strength stage where the fixtures or clamps may be removed.

## CB359-50

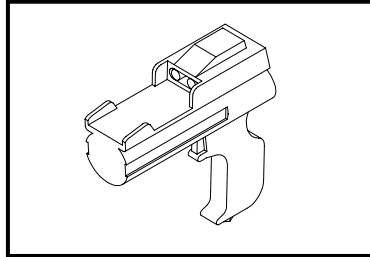
Standard 50 ml dual pack syringe cartridges improve efficiency by reducing installation time. CLICK BOND® dispensing tools with static mixing tips provide quick and accurate mixing and application of CB359 adhesive.



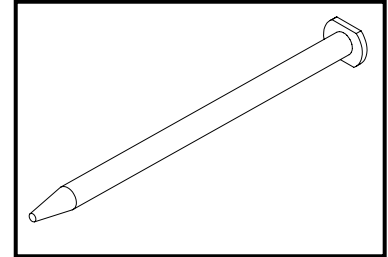
## CB100-21 MANUAL DISPENSER



## CB110 PNEUMATIC DISPENSER



## CB106 MIXING TIP



1. Place cartridge into retaining lip on CB110 air powered tool or CB100-21 hand actuated tool.
2. Remove end cap by turning counterclockwise.
3. Activate the tool slightly to extrude a small amount of adhesive onto scrap material to insure adequate flow of both components.
4. Attach the mixing tip.
5. Dispense a small line of adhesive onto scrap material to insure adequate mixing.
6. Apply adhesive to part, joint surfaces, and hold under pressure for 24 hours minimum at 75°F.
7. When not in use, remove and dispose of tip and replace endcap to preserve remaining adhesive.

Before using this product, read the Material Safety Data Sheets carefully. For industrial use only.

### GENERAL:

Use this product with adequate ventilation. Do not get in eyes or on skin. Avoid breathing the vapors. Wash thoroughly with soap and water after handling. Empty containers retain product residue and vapors so obey all precautions when handling empty containers.

### PART A

**WARNING!** As with most epoxy adhesives, the uncured adhesive may cause eye and skin irritation such as allergic dermatitis. Contains epoxy resins.

### PART B

**DANGER!** Causes severe skin and eye burns. Do not get in eyes, on skin or on clothes. Vapors may be irritating to the respiratory tract.

For complete cautionary information refer to the Material Safety Data Sheet (MSDS). Copies are available from the Click Bond Customer Service Department upon request.

Values stated in this bulletin represent typical values as not all tests are run on each lot of material produced. For formalized product specification for specific product end uses, contact the Customer Service Department. Information provided herein is based upon tests believed to be reliable. Inasmuch as Click Bond has no control over the exact manner in which others may use this information, it does not guarantee the results to be obtained. Nor does the Company make any express or implied warranty of merchantability, or fitness for a particular purpose concerning the effects or results of such use.

Contact the Click Bond Customer Service Department:  
**PHONE (775) 885-8000 FAX (775) 883-0191**

**CB359 Data Sheet – Effective MAY01**

**Click Bond, Inc.**  
2151 Lockheed Way  
Carson City, NV 89706-0713