

ADHESIVES

Structural adhesives that excel in the most challenging environments.



ADHESIVES

Click Bond's total solution approach to adhesive-bonded fastening takes our product line beyond the hardware. We continually research emerging adhesive technologies and partner with industry-leading chemical manufacturers to provide an assortment of industry-leading acrylic and epoxy structural adhesives, as well as polysulfide sealants.

Each is tailored for its suitability for high strength adhesive-bonded fastener installation to metallic, composite, and thermoplastic substrates. These materials are particularly selected for their durability under exposure to a wide range of demanding environments including heat and cold, high humidity, and immersion in fuels and fluids.

Our adhesives are qualified to multiple aerospace OEM specifications and are packaged in convenient twin-pack cartridges that minimize errors in component ratio and mix consistency. A complementary range of dispensers, ratio slides, and disposable static mixing tips are available to facilitate adhesive application.

All Click Bond adhesive-bonded fasteners include an installation fixture that allows accurate positioning and clamps the fastener under positive pressure while the adhesive cures, optimizing bond strength and consistency of results.



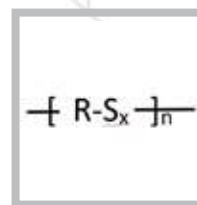
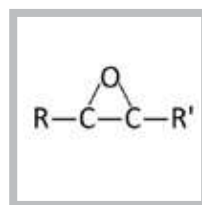
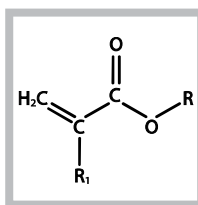
Click Bond packages a selection of leading structural adhesives in convenient twin-pack cartridges. This packaging method, incorporating the use of a disposable static mixing tip, simplifies adhesive preparation and dispensing while eliminating component ratio errors and inconsistency associated with manual measurement and mixing.

Features

- Resealable cartridges reduce adhesive waste
- Static mixing tips ensure consistent and thorough component blending
- Dispensing tools and slides available for various component ratios
- Industry standard adhesives from Hysol, Lord, and 3M available
- Convenient 40 or 50 ml cartridges for production
- Adhesive available in small packets in kits, convenient for repair and small jobs
- Kits with Click Bond fasteners and adhesives available

Adhesive Products

Structural adhesives are available to address high temperature, fuel and fluid immersion, high shock, and low outgas requirements. A representative of Click Bond Sales will help you determine the right adhesive for your application.



Adhesive Cartridges & Kits

All our structural adhesives are available in convenient twin-pack cartridges. A wide range of kits are also available that include adhesive packets, fasteners, and all required surface prep materials, suitable for repair or field installations.



Adhesive Dispensers & Accessories

A range of dispensing equipment, designed for use with twin-pack cartridges, is available. Using this dispensing method in conjunction with static mixing tips simplifies adhesive preparation, while eliminating component ratio errors associated with hand mixing.



Adhesive Products

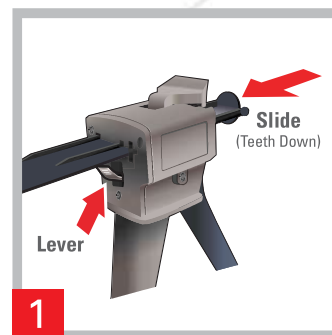
Part Number	Adhesive Type	Features	Working Time	Handling Strength
CB200	Acrylic Structural Adhesive	<ul style="list-style-type: none"> Bonds a wide variety of metals, engineering plastics, and composites Cures quickly at room temperature. Bonds irregular shapes and inaccessible surfaces Excellent environmental and chemical resistance Water resistant 	5 min	30 min
CB250	Acrylic Structural Adhesive	<ul style="list-style-type: none"> Bonds ABS, PVC, acrylic, styrene, metals, wood, and ceramics High shear, peel, and impact strength Cures quickly at room temperature Bonds gaps from 0.003 - 0.125 inches Excellent environmental resistance 	5 min	30 min
CB300	Epoxy Structural Adhesive	<ul style="list-style-type: none"> Bonds to most substrates including metal, wood, concrete, ceramics and many plastics Recommended for fast patching, fixturing, and other repairs requiring quick handling strength Excellent fast-setting general purpose adhesive 	3 min	15 - 30 min
CB301	Epoxy Structural Adhesive	<ul style="list-style-type: none"> Bonds a wide variety of metals Good peel and shear strength 	5 min	24 hrs
CB309	Epoxy Structural Adhesive	<ul style="list-style-type: none"> Bonds metals, FRP, wood, rubber, and other materials Excellent environmental and chemical resistance Ideal for gap filling and use on vertical surfaces 	90 - 120min	8 - 16 hrs
CB359	Epoxy Structural Adhesive	<ul style="list-style-type: none"> Bonds a wide variety of metals, thermoplastics, wood, concrete and composites High peel, tensile, and lap shear strength Low outgassing Excellent resistance to water, salt spray, and organic fluids 	60 min	24 hrs
CB394	High Temperature Epoxy Structural Adhesive	<ul style="list-style-type: none"> Bonds metals, many thermoplastics, and thermoset composites Excellent strength to 350°F / 177°C and higher Low outgassing Ideal for potting, filling, and liquid shim applications 	90 min	24 hrs
CB420 CB420E*	Acrylic Structural Adhesive	<ul style="list-style-type: none"> Bonds ABS, acrylics, aluminum, FRP, PVC, carbon steel, and stainless steel Cures quickly at room temperature High strength, excellent fatigue endurance, outstanding impact resistance, and superior toughness Excellent environmental and chemical resistance 	4 - 6 min	15 - 18 min
CB440	Polysulfide Sealant	<ul style="list-style-type: none"> Designed for fillet sealing of fuel tanks and other sealing applications Maintains excellent elastomeric properties after prolonged exposure to both jet fuel and aviation gas Excellent flexibility for high-shock environments Cures at room temperature Excellent resistance to water, salt water, alcohols, petroleum-base and synthetic lubricating oils, and petroleum-base hydraulic fluids 	30 min	10 hrs

* REACH compliant version developed for European market.

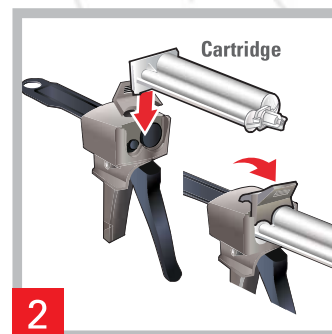
Note: All times measured at 75°F (24°C) and are significantly affected by temperature. Refer to adhesive data sheet for more details.

Full Cure	Strength		Service Temp Range
	Shear (ASTM D1002)	Peel (ASTM D1876)	
24 hrs	4400 psi (30.3 MPa)	21 pli (3.7 kN/m)	-67°F - 250°F (-55°C - 121°C)
24 hrs	3500 psi (24.1 MPa)	37 pli (6.5 kN/m)	-67°F - 250°F (-55°C - 121°C)
60 min	3000 psi (20.7 MPa)	1.8 pli (0.3 kN/m)	-40°F - 180°F (-40°C - 82°C)
7 days	4500 psi (31.0 MPa)	50 pli (8.8 kN/m)	-67°F - 250°F (-55°C - 121°C)
24 - 48 hrs	1550 psi (10.7 MPa)	2.2 pli (0.4 kN/m)	-30°F - 250°F (-34°C - 121°C)
5 - 7 days or 1 hr at 180°F (82°C)	4500 psi (31.0 MPa)	60 pli (10.5 kN/m)	-67°F - 200°F (-55°C to 93°C)
3 - 5 days or 1 hr at 150°F (65°C)	4200 psi (30.0 MPa)	5 pli (0.9 kN/m)	-67°F - 350°F
24 hrs	3050 psi (21.0 MPa)	28 pli (4.9 kN/m)	-40°F - 250°F (-40°C - 121°C)
30 hrs	N/A	25 pli (4.4 kN/m)	-65°F - 250°F (-54°C - 121°C), with intermittent excursions up to 275°F (135°C)

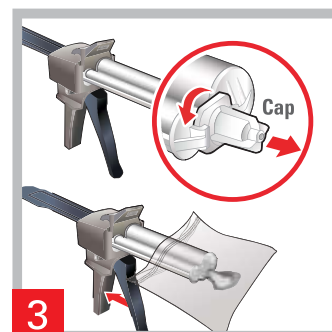
Easy Dispenser Assembly



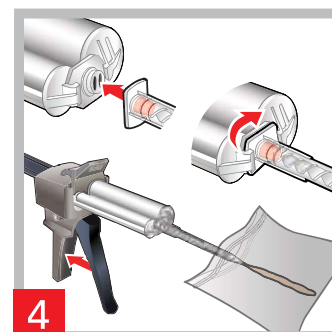
1 Insert Slide



2 Insert Cartridge



3 Remove End Cap and Check



4 Attach Mixing Tip and Check

Adhesive Cartridges & Kits

Part Number	Adhesive Type
CB91	CB200 3.5g Acrylic Adhesive Kit
CB92	CB200 3.5g Acrylic Adhesive Kit with Surface Prep Materials
CB93	CB300 4.0g Epoxy Adhesive Kit
CB94	CB300 4.0g Epoxy Adhesive Kit with Surface Prep Materials
CB95	CB200 40ml Acrylic Adhesive Cartridge with Mixing Tip
CB96	CB440 5.0g Sealant Kit with Surface Prep Materials
CB97	CB301 50ml Epoxy Adhesive Cartridge with Mixing Tip
CB98	CB200 40ml Acrylic Adhesive Cartridge with Mixing Tips and Surface Prep Materials
CB200-40	CB200 40ml Acrylic Adhesive Cartridge
CB250-50	CB250 50ml Acrylic Adhesive Cartridge
CB301-50	CB301 50ml Epoxy Adhesive Cartridge
CB309-50	CB309 50ml Epoxy Adhesive Cartridge
CB359-50	CB359 50ml Epoxy Adhesive Cartridge
CB394-43	CB394 43ml Epoxy Adhesive Cartridge
CB420-50	CB420 35ml Acrylic Adhesive Cartridge
CB420-50E	CB420E 35ml Acrylic Adhesive Cartridge (REACH compliant version)



Adhesive Dispensers & Accessories

Part Number	Description
CB11	Adhesive Dispenser Slide, 1:1 Ratio, for use with CB100 Adhesive Dispenser used with CB250-50 & CB309-50 Adhesive Cartridges
CB21	Adhesive Dispenser Slide, 2:1 Ratio, for use with CB100 Adhesive Dispenser used with CB301-50 & CB359-50 Adhesive Cartridges
CB41	Adhesive Dispenser Slide, 4:1 Ratio, for use with CB100 Adhesive Dispenser used with CB394-43 Adhesive Cartridge
CB81	Adhesive Dispenser Slide, 8:1 Ratio, for use with CB100 Adhesive Dispenser used with CB200-40, CB420-50 & CB420-50E Adhesive Cartridges
CB100	Adhesive Dispenser
CB106	Adhesive Dispenser Mixing Tip for all Click Bond Adhesive Cartridges
CB904	Disposable Abrasive Pad
CB911	Solvent Wipe



Our Work is Measured Against the Highest Standards

Click Bond is certified to the latest revisions of the ISO 9001 and AS9100 manufacturing process, and ISO 14001 environmental management standards.

As a provider of solutions supporting industry's highest performance applications, we recognize the criticality of delivering the highest quality products and that the ability to do so requires the highest quality processes. Quality is a commitment and responsibility shared between Click Bond, our supplier partners, and our customers.

Our team of internal auditors regularly reviews every aspect of Click Bond operations to verify that our company's systems and processes meet or exceed the requirements of these rigorous standards. Their reviews are validated by regular third party registrar and customer audits.

Click Bond's commitment to these standards is a source of pride. They provide critical oversight of the quality of our processes and, by extension, that of our products. Each demands continual improvement in our operations, stimulating innovation, quality, and delivery of increasing value to our customers.

Click Bond will consistently design, produce, and sell good product; comply with the requirements of AS9100 and ISO 14001; and continually improve the quality and environmental management system.

- Click Bond Quality Policy

