

**CB394 EPOXY**  
STRUCTURAL ADHESIVE

**CLICK BOND**

**CB394 EPOXY**  
STRUCTURAL ADHESIVE

**PRODUCT DESCRIPTION**

CB394 is a two part structural paste adhesive which cures at room temperature and possesses excellent strength to 350°F/177°C and higher. Its thixotropic nature and excellent high temperature compressive strength also make it ideal for potting, filling, and liquid shim applications. CB394 adhesive meets the specifications of MMM-A-132 Rev. A, Type I, Class 3.

**PRODUCT FEATURES**

**AEROSPACE SPECIFICATIONS**

MMM-A-132 Rev. A, Type I, Class 3

- Room temperature cure.
- Long pot life.
- Potting material.
- Low toxicity.
- 350°F/177°C Performance.
- Good gap filling capabilities.
- Outstanding mechanical properties.
- Room temperature storage.

**UNCURED PROPERTIES**

Appearance: Part A: Gray.  
Part B: Black.

Mix Ratio: 4:1 (A:B) by volume.

Cure time at 75°F: 8 hours - handling strength.  
3 – 5 days - full cure.

Accelerated cure: 1 hour (150°F/66°C) – full cure.

Pot Life at 75°F: 90 minutes (ASTM D2471).

**CURED PROPERTIES**

Shear Strength:  
(ASTM D1002)

4200 psi

T Peel Strength:  
(ASTM D1876)

5 pli

Bell Peel Strength:  
(ASTM D3167)

20 pli

Service Temperature Range:

-423°F to 350°F

**STORAGE AND SHELF LIFE**

CB394 should be stored in a cool (below 77°F), dry place when not used for a long period of time. CB394 has a minimum shelf life of 1 year when stored in the original package between 40°F and 77°F.

**SURFACE PREPARATION**

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.

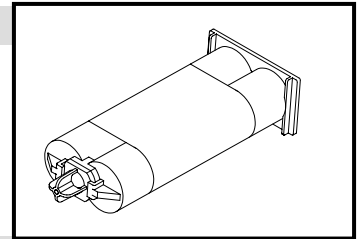
**MIXING AND APPLYING ADHESIVE**

Dispense 4 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 90 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 8 hours to allow adhesive cure to progress to the handling strength stage where the fixtures or clamps may be removed.

## ADHESIVE PACKAGING – 43 ml CARTRIDGES

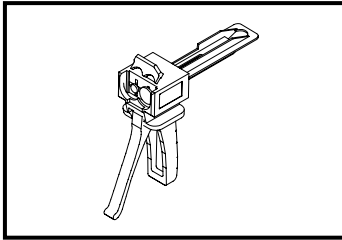
### CB394-43

Standard 43 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 CB394 adhesive.

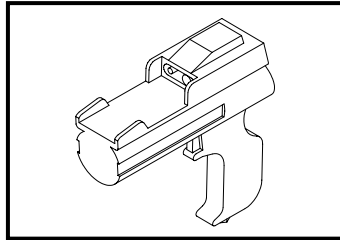


## DISPENSING TOOLS AND MIXING TIPS FOR CB394 ADHESIVE

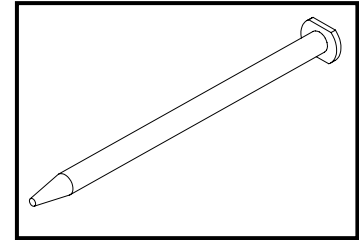
### CB100-41 MANUAL DISPENSER



### CB112 PNEUMATIC DISPENSER



### CB106 MIXING TIP



## DIRECTIONS FOR DISPENSING CB394 DUAL PACK 43 ml CARTRIDGES

1. Place cartridge into retaining lip on CB112 air powered tool or CB100-41 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 8 hours minimum at 75°F.
7. When not in use, remove and dispose of tip and replace endcap to preserve remaining adhesive.

## IMPORTANT PRODUCT PERFORMANCE AND CAUTIONARY INFORMATION

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 after handling. Empty containers retain product residue and vapors so obey all precautions when handling empty containers.

Heat buildup during or after mixing is normal. Do not mix quantities greater than 450 grams as dangerous heat buildup can occur causing uncontrolled decomposition of the mixed adhesive. TOXIC FUMES CAN OCCUR, RESULTING IN PERSONAL INJURY. Mixing smaller quantities will minimize the heat buildup.

### PART A

**WARNING!** As with most epoxy based systems, the uncured adhesive may cause eye and skin irritation or allergic dermatitis. Contains epoxy resins.

### PART B

**DANGER!** Causes severe skin and eye burns. Contains tetraethylenepentamine. 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.

## ORDERING AND FURTHER TECHNICAL INFORMATION

Contact the Click Bond Customer Service Department:

**PHONE (775) 885-8000 FAX (775) 883-0191**

**CB394 Data Sheet – Effective JUN99**

**Click Bond, Inc.**

2151 Lockheed Way  
Carson City, NV 89706-0713