Aquatard TF Data Sheet

Specification notes

Product: Aquaseal mBond 395

Supplier:

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...for technical, specification & application advice;

...or

...for more information on our other repair, maintenance, engineering and construction specialist products.
mBOND 395
High Strength Marine Adhesive

DESCRIPTION

mBOND 395 is a high strength marine grade adhesive based on advanced MS Polymer technology specifically designed for structural and dynamically stressed bonding applications in the boat and ship building and maintenance industries.

Offers outstanding initial grab and anti-vibration bonding and bedding properties.

mBOND 395 is the performance adhesive choice for demanding sealing and bonding applications throughout the boat structure.

FEATURES & BENEFITS

- Universal application even on wet/humid surfaces
- High initial grab
- High UV and salt water resistance
- Virtually odourless
- Free of solvents, silicones and isocyanates
- VOC free – non hazardous
- Overpaintable
- High anti-vibration and sound deadening properties
- Permanently elastic
- Outstanding adhesion to marine substrates
- No shrinkage
- Grinding compatible

RECOMMENDED FOR

- Bonding hatches, portholes, cleats, winches, deck fittings, electricals and light casings etc.
- Bonding sheer rails
- Bonding frames
- Bonding dynamically stressed panels
- Bonding and bedding of floor plates
- Bonding Consoles / Mouldings
- Skylights
- Winches
- Signs
- Braces
- Profiles
- Plates
- Fittings
- Nosings
- Fibreglass deck to fibreglass hull

SPECIFICATION COMPLIANCE

DNV, IMO Wheelmark Certified—Registration Number 0575

COLOURS

White, Black
PACKAGING
310ml Rigid Cartridges
600ml Foil Packs

STORAGE
Store in cool, dry conditions between +5° and 25°C.

SHELF LIFE
18 Months from Date Of Manufacture.

HEALTH & SAFETY
Data sheet available on request.

PREPARATION
All surfaces must be clean, sound and dust free, glossy surfaces such as gel coat should be lightly abraded within the area to be bonded. Wood substrates should be abraded with 80-120 grit paper and thoroughly cleaned/vacuumed. Surfaces must be de-greased using Everbuild surface cleaner, isopropanol or a similar alcohol based cleaner and allowed to evaporate.

mBOND 395 will bond successfully to damp surfaces if required but standing water should be avoided unless making an emergency/temporary repair.

PRIMING
On many applications mBOND 395 will be entirely successful without the need for priming surfaces, however, due to the variety of materials available we recommend a test is carried out beforehand.

Where priming is desired use Marine Primer No. 10 for wood and Primer No. 20 for metals, plastics, GRP, gel coat and other non-porous surfaces.

APPLICATION
Before applying the adhesive careful consideration should be given to the weight loading being placed on the item to be bonded and if on a vertical surface as to whether it will need temporary support during curing. This will be entirely dependent on the weight of the item and the bond interface area. In general the greater the surface area available for the bond interface the less support will be required. A conventional Gaffa/Duct tape is ideal for temporary support.

A prime benefit of using mBOND 395 is the damping / sound deadening properties which also makes it ideal for applications behind many mechanically fixed items such as winches, cleats, catches and deck fittings. On such items it is advisable to mask surrounding areas to assist in cleaning up the excess adhesive that is squeezed out when the bolts/screws are tightened.

The optimum application method on most items to be bonded is to apply adhesive in a 6-8mm bead using a triangular cut nozzle so that the adhesive has a peak to bed the item to the surface. Adhesive can be applied to the substrate or item to be bonded depending on the difficulty in positioning. Generally with heavy items it is best to apply adhesive to the substrate having first marked the area to be bonded. With lighter items it is usually considered quicker to apply the adhesives to the items being bonded.

mBOND 395 will successfully fill gaps up to 6mm where required.

The ideal application configuration is to apply stripes across the area to be bonded at suitable intervals.

Items must be fixed and excess adhesive cleaned up within 10 minutes of application, a slight twisting action when bedding the item down into the adhesive helps initial grab.

When using a sealant to finish up around an item bonded always tool down, a wetted spatula or finger in combination with Everbuild Wonder Wipes is the ideal method of tooling down.
CLEAN UP

Can be cleaned up with Aquaseal Marine Wipes or a cloth dampened with white spirit. Once cured cleaning is by physical removal.

PAINTING

Can be over painted with most paints when fully cured after circa 72 hours but always check paint compatibility with a small test before proceeding.

LIMITATIONS

- Use in overhead applications—Always use in conjunction with mechanical fixings
- Use in conjunction with mechanical fixings for large mirrors (>0.5m² total area)
- For heavy items, provide temporary support until adhesive has dried.
- Do not seal mirror edges/plastic sheeting until adhesive has cured.
- Overpaintability: check compatibility with specific paint first before over painting large areas.
- Do not use on surfaces that bleed oils or plasticizers.
- It is the user’s responsibility to determine suitability for use. If in doubt, please contact Technical Services Department for advice.
- Not for use as part of a structural glazing system.

SPECIFIC DATA

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<th>Property</th>
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<tr>
<td>Skin / Tooling Time</td>
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<tr>
<td>Cure Time (@23°C / 50% HR)</td>
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