

## Technical Data Sheet Tuffbond<sup>®</sup> 315

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### Product Description

**Hernon<sup>®</sup> Tuffbond<sup>®</sup> 315** is a modified epoxy adhesive that provides a fast room temperature cure. **Tuffbond<sup>®</sup> 315** exhibits very good moisture chemical and heat resistance. This fast cure epoxy adhesive is specially formulated for rapid in-line assembly of loud speakers. **Tuffbond<sup>®</sup> 315** 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" coats
- Potting electronic boards
- Encapsulating electrical and electronic components

### Product Benefits

- Fast at room temperature (about 15 minutes)
- Low shrinkage
- 100% reactive, non-solvent system
- Easy mixing ratio of resin and hardener
- No fuming on gelation

### Typical Properties (Uncured)

Property	Part A	Part B
Base	Epoxy	Amine
Appearance	Clear	Yellow
Viscosity at 25°C, cP	11,000 to 16,000	6,000 to 12,000
Mix Ratio by Weight	1	1
Specific Gravity	1.17	0.97

### Typical Properties (Cured)

Property	Value
Working Life at 22°C (20g), minutes	≤ 15
Durometer Hardness, Shore D	80-85

### Typical Cured Performance

#### Room Temperature Cure

Shear Strength on Steel lap-shear specimens tested according to ASTM D1002.

Cure Time at 22°C	Shear Strength (psi)
24 Hours	2000 - 3000

### 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 Safety Data Sheet (SDS).**

#### Storage

**Tuffbond<sup>®</sup> 315** should be stored in a cool, dry location in unopened containers at a temperature between 45°F to 85°F (7°C to 29°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<sup>®</sup>** offers a complete line of semi and fully automated dispensing equipment. Contact **Hernon<sup>®</sup> Sales** for additional information.

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