

## Technical Data Sheet Tuffbond<sup>®</sup> 308

April 2019

Page 1 of 1

### Product Description

Hernon<sup>®</sup> Tuffbond<sup>®</sup> 308 is a specially formulated, low chlorine, single component epoxy system which cures at temperatures of 212°F (100°C) and above. Tuffbond<sup>®</sup> 308 is suitable for potting and encapsulation of electrical and electronic components. It has excellent storage stability and produces tough, flexible bonds with superior shear strengths when used on metals, ceramics and many plastics. Optimum strength can be obtained after ten to fifteen minutes cure at 300°F (149°C).

### Product Benefits

- Low chlorine content
- Excellent adhesion
- One part - no mixing
- Good mechanical properties
- Tough, flexible bonds
- Suitable for potting electronic boards and encapsulating electrical and electronic components

### Typical Properties (Uncured)

Property	Value
Resin	Epoxy
Color	White
Viscosity @ 25°C, cP	96,000 to 128,000
Specific gravity	1.14

### Curing Characteristics

Tuffbond<sup>®</sup> 308 can be cured by infra-red or convection oven. Cure time will depend on the bond-line temperature.

Bond-line Temp., °C (°F)	Cure Time, minutes
150 (300)	10 – 15 mins

### Typical Cured Performance

Shear Strength on lap-shear specimens tested according to ASTM D1002.  
Cured 10 minutes at 150°C

Substrate	Shear Strength (psi)
GB Steel	4500 – 5500

### 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> 308 must be stored under refrigeration at a temperature of 45 ± 5°F for extended shelf life. 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.

These suggestions and data are based on information we believe to be reliable and accurate, but no guarantee of their accuracy is made. HERNON MANUFACTURING<sup>®</sup>, INC. shall not be liable for any damage, loss or injury, direct or consequential arising out of the use or the inability to use the product. In every case, we urge and recommend that purchasers, before using any product in full scale production, make their own tests to determine whether the product is of satisfactory quality and suitability for their operations, and the user assumes all risk and liability whatsoever, in connection therewith. Hernon's Quality Management System for the design and manufacture of high-performance adhesives and sealants is registered to the ISO 9001 Quality Standard.