

Technical Data Sheet Tuffbond[®] 304

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Product Description

Hernon[®] Tuffbond[®] 304 is a modified epoxy adhesive that provides a very fast room temperature cure. **Tuffbond[®] 304** exhibits very good moisture chemical and heat resistance. This very fast cure epoxy adhesive is specially formulated for rapid in-line assembly of loud speakers. **Tuffbond[®] 304** 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 4 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	Black	Light Amber
Viscosity at 25°C, cP	11,000 to 16,000	12,000 to 18,000
Mix Ratio by Weight	1	1
Specific Gravity	1.17	1.13

Typical Properties (Cured)

Property	Value
Working Life at 22°C (20g), minutes	4 – 7 mins
Durometer Hardness, Shore D	80 - 90

Typical Cured Performance

Room Temperature Cure

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

Cure Time at 22°C	Shear Strength (psi)
24 Hours	2500 - 3500

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[®] 304 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[®] offers a complete line of semi and fully automated dispensing equipment. Contact **Hernon[®] Sales** for additional information.

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