



Adhesives & Sealants

BONDFLEX 390 FC

Technical Data Sheet

Reviewed: 06.06.2015



DESCRIPTION

BONDFLEX 390 FC is a high quality, one-component elastic polyurethane sealant and adhesive, suitable for a wide range of sealing and bonding applications in building and shipbuilding industries.

ADVANTAGES

- Excellent adhesion
- Stays elastic after curing
- Excellent resistance against all atmospheric conditions
- Excellent resistance to many chemicals
- Rapid polymerization
- Can be painted

APPLICATIONS

- All sealing and bonding applications in building and metal industries
- Sealing and bonding applications in shipbuilding industry
- Structural bonding in vibrating constructions
- Sealing and bonding applications in automotive industry
- All kinds of structural bonding and sealing applications
- All sealing and bonding applications in building and metal industries
- Sealing and bonding applications in shipbuilding industry
- Structural bonding in vibrating constructions
- Sealing and bonding applications in automotive industry

ural bonding and sealing applications

INSTRUCTIONS FOR USE

1. Surfaces must be clean, free of dust and grease.
2. In very warm and moist climates we recommend the use of PRIMER PU for applications on porous surfaces.
3. Use caulking gun
4. Repair with **BONDFLEX 390 FC**.
5. Finish with soapy water before skin formation.
6. Cured material may be painted with most paints. When painted with oxidative drying paints disturbances in the drying of the paints may occur.

A suitability test is recommended

Not recommended for applications on PVC & glass

JOINT SIZE

Minimum thickness: 2mm (bonding)
5mm (joints)

Maximum thickness: 10mm (bonding)
30mm (joints)

Minimum Depth: 5mm (joints)

Recommendation: joints $\leq 12\text{mm}$ depth = width
Joints $> 12\text{mm}$ 2 X depth = width

CLEANING

Clean all equipment with white spirit immediately after use

TECHNICAL CHARACTERISTICS

Base: Polyurethane

Colour: White, Black and Gray

Consistency: Paste

Curing System: Moisture Cure

Skin formation (20°C/ 65% R.H.): Ca. 15 min

Curing Rate (20°C/ 65% R.H.): 3mm /24h

Hardness (DIN 53505): 40 ± 5 Shore A

Specific gravity (DIN 53479): 1,30 gr/ml

Temperature Resistance: -30°C to +90°C

Elastical Recovery (ISO 7389): $> 80\%$

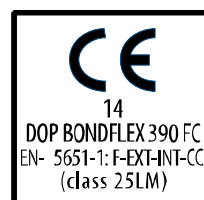
Maximum allowed Distortion: 20%

Elasticity Modulus 100% (DIN 53504): 0,80 N/mm²

Maximum Tension (DIN 53504): 1,70 N/mm²

Elongation at Break (DIN 53504): 700%

Application temperature: +5°C - +35°C



STORAGE

In a cool and dry place at temperatures between +5°C - +25°C

SHELF LIFE

12 months in unopened packaging in the above mentioned storage conditions

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PACKAGING

Cartridges 310 ml white, gray, black

Sausages 600 ml white, black

PACKAGING	CODE	BARCODE
310ml white	04205	5204094042051
310ml gray	04208	5204094042082
310ml black	04206	5204094042068
600 ml white	04207	5204094042075
600 ml black	04209	5204094042044

HEALTH AND SAFETY INFORMATION



Acute Tox. 4: H312 - Harmful in contact with skin **Resp. Sens.**

1: H334 - May cause allergy or asthma symptoms or breathing difficulties if inhaled **P261**: Avoid breathing dust/fume / gas / mist / vapours / spray **P302+P352**: IF ON SKIN: Wash with plenty of soap and water **P304+P341**: IF INHALED: If breathing is difficult, remove victim to fresh air and keep at rest in a position comfortable for breathing **P312**: Call a POISON CENTER or doctor / physician if you feel unwell **P322**: Specific measures need to be taken (see this label) **P363**: Wash contaminated clothing before reuse **EUH204**: Contains isocyanates. May produce an allergic reaction **EUH208**: Contains 4,4'-methylenediphenyl diisocyanate. May produce an allergic reaction. Substances that contribute to the classification: 4,4'-methylenediphenyl diisocyanate (CAS: 101-68-8); Xylene (mixture of isomers) (CAS: 1330-20-7)

The directives contained in this technical data sheet are the result of our long experience from real life applications and the research testing of our research and development laboratory and have been submitted in good faith. Because of the diversity of the materials and substrates and the great number of possible applications, which are beyond our control, we cannot accept any responsibility for the results obtained. In every case it is recommended to carry out preliminary experiments. We are liable only for our products for being free from faults and of consistent quality. Users are responsible for complying with local legislation and for obtaining any required approvals or authorizations. The present edition of this technical datasheet automatically cancels any previous ones concerning the same product.



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