



## **Product Data Sheet**

### **PB Bond-240** **One Part Bonding Adhesive**

#### **DESCRIPTION:**

PB Bond-240 is an amber colored, one part, urethane adhesive that works well for indoor or outdoor applications. It cures from a liquid to a solid state with a slight amount of moisture. Use it to join Precision Board high density urethane sheets with butt bonds to make them longer or wider, and for laminating sheets together to make them thicker. Consistency of PB Bond-240 is similar to honey, making it easy to apply directly from the container. No mixing is required. Cure time: 4 hours before moving, full strength in 12 hours.

**Preparation** - Lightly spray the mating surfaces with water, or wipe the surfaces with a damp rag just prior to applying the PB Bond-240. This procedure assures there will be adequate moisture to effect total cure. PB Bond-240 will not cure properly without adding moisture.

**Application** - Apply a thin coat of PB Bond-240 to each surface to be joined. Only apply enough to change the color of Precision Board. Too much adhesive will be pushed out of the joint. Hold pieces in place by clamping or by setting something heavy on each side of the joint. Clean up wet adhesive with acetone. Keep container closed when not in use. Spread rate - Approximately 1/2 ounce per square foot.

**Butt Bonding** - After application, the adhesive will start to bubble and thicken in approximately 10 minutes. Keep the Precision Board pieces on edge during this time so that the PB Bond-240 will not run out of the joint before it sets. If the adhesive runs out, the joint may look solid but will be hollow inside, therefore extremely weak.

**Laminate Bonding** - When making laminate bonds, the moisture added will assure total reaction. If moisture is not added there will be spots of uncured adhesive where moisture was unable to penetrate. Even long term drying will not assure reaction since PB does not absorb moisture from the air and pass it through to the joint.

**Sandblasting** - When butt bonding pieces that will be sandblasted, apply the PB Bond lighter at the top part of the joint since it will be blasted away later. This makes blasting much easier. Thick glue lines are harder to blast through. Remove any excess ooze from the joint. Clamping is necessary to keep glue lines to a minimum.

#### **Tips For Easier Usage**

- Lightly spray or wipe mating pieces with water just prior to application.
- Apply just enough PB Bond-240 to change the color of Precision Board.
- Allow PB Bond to slightly bubble and thicken before pushing pieces together.
- Allow minimum 4 hours cure prior to moving bonded part. Full strength in 12 hours.
- Keep glue line as thin as possible for ease of sandblasting. Clamping is necessary.
- To blend joint into background after sanding, prime both joint and background with FSC-88 primer/filler.
- Drill small hole in cap to act as dispensing nozzle. After using, cover hole with tape.

**NOTE:** For questions regarding use of PB Bond-240, please contact Coastal Enterprises at (800) 845-0745.

**CAUTION:** For industrial use only. Use with adequate ventilation. Avoid prolonged contact with skin. Close container after each use. Do not take internally. Do not transfer contents to bottles or other unlabeled containers. Harmful or fatal if swallowed, do not induce vomiting. Call physician immediately.

**KEEP OUT OF REACH OF CHILDREN.**

**WARRANTY:** All recommendations for product use have been derived from experience and test data believed to be reliable. We warrant and guarantee the uniformity of our products within manufacturing tolerance. However, since the use of our products are beyond our direct control, they are furnished upon the condition that each party shall make his/her own tests to determine their suitability for his/her particular purpose. Except as stated herein, Coastal Enterprises Company makes no warranty or guarantee, expressed or implied, and disclaims all responsibility for results obtained, nor assumes any liability for any damages, whether arising out of negligence or breach of guarantee and is hereby expressly limited to replacement of product only. For additional information on product handling, please refer to PB Bond-240 MSDS.