

## Tuffbond® 313

### Product Description

**Hernon® Tuffbond® 313** adhesive/sealant is a two component, 100% solid system, one to one ratio, room temperature cure system. **Tuffbond® 313** is recommended for bonding metals, wood, ceramics, etc., and can be used for potting and encapsulation of electrical and electronic components.

### Typical Applications

- Marine coating
- Underwater coating
- Potting electronic boards
- Encapsulating electrical and electronic components

### Product Benefits

- Good mechanical properties.
- Outstanding resistance to abrasion.
- Non-critical mixing.

### Typical Properties (Uncured)

Property	Part A	Part B
Base	Epoxy	Amine
Appearance	White	Light Yellow
Viscosity at 25°C, cP	18,000 to 26,000	18,000 to 26,000
Mix Ratio by Weight	1	1
Specific Gravity	1.17	0.97

### Typical Properties (Cured)

Property	Value
Working Life at 22°C (100g), minutes	40 to 60
Hardness, Shore D, ASTM D2240	70-80
Shear Strength – GB Steel, psi ASTM D1002	2500 - 4000
Dielectric Constant at 1kHz	3.38
Dissipation Factor at 1kHz	0.15089

### Strength Properties at Different Temperatures

0.25 mm gap and ½ inch overlap on grit-blasted steel  
Tested at temperatures indicated, according to ASTM D1002.

Temperature	Shear Strength (psi)
23°C (room temperature)	1,000 – 1,500
-55°C	1,300 – 2,000
80°C	150 – 400
155°C	150 – 400

### 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® 313** 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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