



C-BOND 254

RoHS
Compliant

TECHNICAL BULLETIN 230-3

COMPLIANT POLYURETHANE ADHESIVE

C-BOND 254 is a strong, versatile adhesive intended for the bonding of critical components such as radar absorber panels to the metal or composite skins of aircraft, naval vessels, or military vehicles. The adhesive combines toughness with the flexibility required for reliable bonds under severe conditions of temperature and vibration. Excellent adhesion can be obtained to almost all metal substrates, as well as to glass and many plastics.

C-BOND 254 is available in pre-measured kits ranging in size from one pint (approx. 1 lb.) to one gallon (approx. 9 lbs.). Each kit contains a two-part primer system and a two-part adhesive system. The materials should be mixed and applied in a well-ventilated space, with care taken to avoid inhaling vapors. Any contacted skin should be immediately washed with soap and water.

Surface Preparation: The bonding surfaces should be clean and dry, and free of oil or other contaminants. Wiping with naphtha, MEK, or other solvent is helpful. Allow any solvents to thoroughly dry before applying adhesive. Best results are achieved by sandblasting or chemical etching the surfaces before cleaning.

C-BOND 254 Primer: Mix parts A and B together thoroughly in equal amounts. The primer can be diluted with MEK if desired, and can be sprayed. Application is improved if the substrate is warmed to 100°F - 120°F. Apply the primer to a thickness of 1 to 3 mils. Allow to cure for at least 2 hours at room temperature or 30 minutes at 150°F.

C-BOND 254 Adhesive: Mix parts A and B together thoroughly in a ratio of 2:1. The adhesive has a pot life of about 2 hours at room temperature. Vacuum degassing after mixing is helpful. Apply to both primed surfaces and immediately join the parts. Allow the assembly to remain undisturbed for at least 24 hours at room temperature or 3 hours at 150°F.

TYPICAL PROPERTIES

Density:	1.02 g/cm ³
Hardness, Shore A:	45
Tensile at Break:	370 psi
Elongation at Break:	300%
Peel Adhesion:	200 lbs./ in.
Service Temp., °F (°C):	-55 to +120 (-70 to +250)

The information in this Technical Bulletin, although believed to be accurate, is not to be taken as a warranty for which Cuming Microwave assumes legal responsibility nor as permission or recommendation to practice any patented invention without license. It is offered for verification by the customer, who must make the final judgment of suitability for any application.

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05/31/07 Page 1 of 1