

Tuffbond[®] 326

Product Description

Hernon[®] Tuffbond[®] 326 is a two-component epoxy known for its low-viscosity, toughness, and long working life at ambient temperatures with shortened cure times at elevated temperatures. The resin offers a combination of high shear strength and hardness.

Tuffbond[®] 326 is particularly recommended for bonding metal, but glass, wood, concrete, and rubber are fine bonding candidates. It can also be used in potting and encapsulation applications.

Typical Applications

- Adhering to various metals for ammunition applications
- Potting electronic boards
- Encapsulating electrical and electronic components

Product Benefits

- High shear strength and hardness
- Outstanding resistance to abrasion
- Low viscosity
- Long working life at ambient temperatures

Typical Properties (Uncured)

Property	Part A	Part B
Base	Epoxy	Amine
Appearance	Clear	Clear-Light Yellow
Viscosity at 25°C, cP	3,000-12,000	50-200
Mixed Viscosity at 25°C, cP	1,000 – 5,000	
Specific Gravity	1.17	0.99
Mix Ratio by Weight	100	50

Typical Properties (Cured)

Property	Value
Results for mixing ratio Part A: Part B	2:1
Working Life at 22°C (20g), minutes	≤ 120
Durometer Hardness, Shore D	80-95
Heat Cure Schedule*	30 min. at 80 °C

* **Tuffbond[®] 326** Can be heated at Temperatures given to increase cure speed

Typical Cured Performance

Shear Strength

Lap-shear specimens tested according to ASTM D1002.
Cured 24 Hours at 22°C

Substrates	Shear Strength (psi)
Grit-blasted Steel	≥ 2000
Grit-blasted Aluminum	≥ 1500

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.

This product is not recommended for use in high humidity environments.

For safe handling information on this product, consult the Safety Data Sheet (SDS).

Storage

Tuffbond[®] 326 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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