

FOR BONDING

ADVANTAGES

Nylon

Dissimilar Materials:

- Wood
- Metal
- Ceramics
- Rubber
- Other Plastics

- Long Pot Life
- Good outdoor weather-ability
- Impact & Vibration Resistance
- Chemical Resistance

GENERAL DESCRIPTION

Caseway BA-400 is a light amber, 2-part kit for adhering Nylon to itself and other dissimilar materials such as wood, metal, ceramics, rubber, and plastics. Ideal for applications requiring shock/vibration resistance, moisture-proof, and surfaces of widely different thermal expansion characteristics. Continuous service at -20°F to 250°F, even higher temperatures may be tolerated for short durations depending on application. Cured BA-400 resists moisture, alkalis and most acids.

TYPICAL PROPERTIES & CHARACTERISTICS

Color: Part-A: Clear (Slightly Opaque) Part-B: Amber	Working Time (pot life) 120 minutes (100 gram batches)
Coverage Area Pint Kit (32 fl oz total): 10sq/ft (@ .04 in thick) Quart Kit (64 fl oz total: 20 sq feet)	65 - 85% Bond Strength: 24-48 hours
Operating Range: -20°F to 250°F	Viscosity Part-A: Semi Viscous Part-B: High Viscous

*Typical Properties & Characteristics may vary depending on factors and conditions including but not limited to substrates, temperature, humidity, and user application. Additional technical information is available upon request.

DIRECTIONS FOR USE

*It is the responsibility of the user to test the material compatibility and method used to apply this product before actual application.

Preparation: The surfaces to be joined must be clean, dry, and free of oils and greases to obtain maximum adhesion. Humidity and temperature can greatly affect cure time. Do not use cleaning products that may introduce moisture, grease, or oil to the surfaces. Ensure tools and containers are not lined with a coating that may affect either component. Mixing with wood utensils or paper containers may cause moisture contamination. It is recommended to use a clean glass, polyethylene, or polypropylene container.

Significantly higher strength has been obtained when roughening Nylon and other plastics before adhesion. Some dissimilar materials may not be compatible for etching such as rubber or ceramics.

Mixing: Parts to be adhered should be prepared before mixing. Use equal parts of A & B by weight. Mix thoroughly, scraping down the sides of the container occasionally.

*Some applications may have better performance with different mixing ratios.

Application: It is recommended to apply using a brush or roller coat however a spatula may be used. Contact pressure is adequate for most applications.

Cure: Typical cure strength will reach 50% after 24 hours at 77°F. Complete cure at room temperature requires three days or four hours at 200°F. Properties of the room temperature cured formula may be improved by a post-cure of 30 minutes at 140-200°F.

AVAILABILITY

Component A: 12 months (365 days) from date of manufacture. Component B: 12 months (365 days) from date of manufacture.

AVAILABILITY

Available in pint kits (32 fl oz total), quart kits (64 fl oz).

Every order comes with a Certificate of Analysis.

STORAGE

Tightly cap and seal the container as best as possible. Store in the original containers at room temperature away from direct sunlight. Store locked up in an area not accessible to children.

SAFETY

This product is considered a hazardous material. Do not handle until all safety precautions have been read and understood. Read the product label & safety data sheet (SDS) for information on proper handling, health risks, firefighting methods, spill procedures, emergency contact information, precautionary information, disposal information & more. Safety data sheets are available at www.casewayproducts.com or by emailing support@casewayproducts.com

Wear protective gloves, protective clothing, eye protection, face protection. This product is intended for use by experienced individuals only.

* The information, suggestions, technical data, and advice provided on this sheet are based on test results, knowledge, and experience believed to be accurate and reliable. However, all information, suggestions, technical data, and advice are not to be considered a warranty and Caseway Industrial Products, Inc. assumes no liability for any direct, indirect punitive, incidental, special consequential damages, to property or life.