

Bondceram 1204 Performance Coating Adhesive

Creates a high strength and temperature resistant pure phenolic plastic coating. The coating adhesive cures to a hard amber plastic that can withstand up to 500°F continuous and 750°F peak temperature exposures. Used as a coating it also provides a surface with a chemically resistant hard plastic coating at those temperatures. It is a great assembly high temperature adhesive because the parts are coated then dried. The assembly then is carried out as a dry fit without bonding taking place until the heat curing is performed. Once heat cured it is a thermoset resin that then resists most chemicals including solvents and all environmental exposures. The 1204 provides a rigid bond or coating with little or no flexibility. This is used when the position or relationship of parts need to be kept exact. If a small amount of flexibility or shock resistance is required look into the companion product Bondceram 1210 a black nitrile rubberized version of the 1204.

Bondceram 1204 is an organic solvent diluted coating. The surfaces need to be clean and free from all lubricants etc. Bondceram 1204 is applied by any coating method rolling, painting, dipping or spraying. It is then to be air dried for at least 2 hours for the solvents to evaporate. Note solvents are flammable and flammable or explosive vapors may be generated during drying. Bondceram can also be quick dried in an oven at 150 to 180°F for 5 to 10 minutes but care not to create explosive solvent vapor in the oven is required. Bondceram 1204 once dried is a stable paint like coating that can be left indefinitely prior to heat curing. The heat curing of the thermoset phenolic resin is carried out at 425°F for 15 minutes. Care should be taken that there is sufficient “soak” time in the oven to make sure that the coating itself has been exposed to the correct temperatures. The finished and cured coating is stable at up to 500°F so prolonged heat curing is not a problem. During the heat curing the adhesive/coating first melts where it can also form an adhesive bond line. The now fluid plastic then reacts and becomes a durable plastic solid that does not melt again. The creation of a high temperature adhesive bond is best accomplished by providing a clamping action so that there is good contact between parts when the Bondceram 1204 is in its liquid phase. A spring or heavy weight is usually sufficient to provide this contact.

Max Temp	Min Temp	Const temp	Chemical Resist	Elect Resist
750°F	-256°F	500°F	Excellent	Excellent

	Quarts	Gallon	5 Gal.
	\$ 65	\$150	call