



Local Solutions For Individual Customers Worldwide

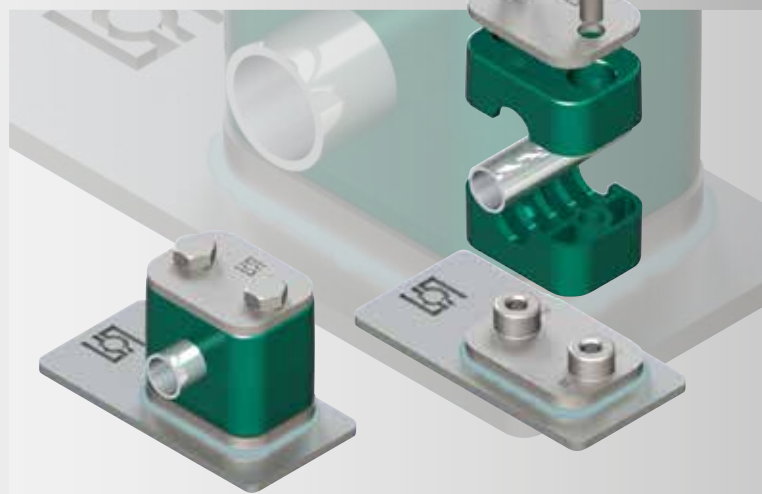
Wide range of applications –  
no welding required



STAUFF Bond Plate –  
with internal dynamic  
installation fixture



Designed for original STAUFF  
Pipe, Tube, Hose and Cable Clamps  
as well as STAUFF ACT Clamps



## **STAUFF Bond** Adhesive Bonded Fastening Solution for STAUFF Clamps

Product Overview

## Adhesively Bonding

The innovative STAUFF Bond system developed and optimised to the functions of original STAUFF Clamps in the Standard Series (DIN 3015, Part 1) allows the adhesive bonding to almost any industrial surface material, such as prepared or unprepared metals, thermoplastics and composites.

It enables assembly and service technicians such as tube fitters to replace expensive and sometimes complicated mechanical fastening methods for STAUFF Clamps such as welding, brazing, bolting and riveting. Successful tensile tests confirm the strength of STAUFF Bond.

A crucial benefit especially in safety-critical situations where welding is usually not considered to be an option.



Tensile testing of the STAUFF Bond Plate (type SBP) with adhesive (type CB420-50E)

## Characteristics of STAUFF Bond

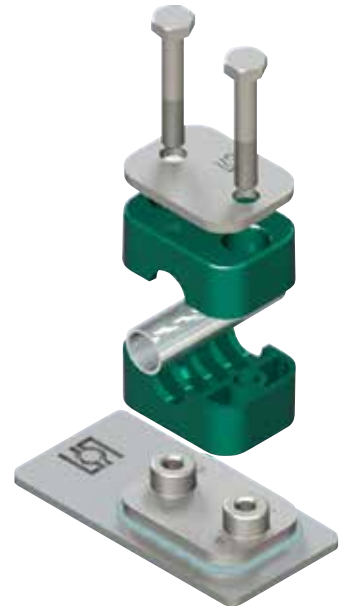
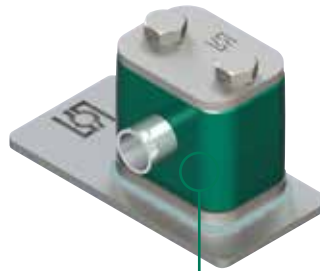
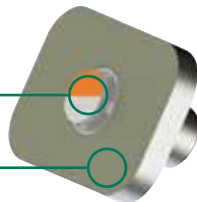
- Reduce cycle time and labor cost during installation
- Expensive tools and welding equipment no longer necessary
- No power supply or electrical power required for installation
- Can be used with a variety of surfaces, especially in safety-critical situations when welding is not an option
- Enhance structural design, strength and integrity
- Reduce number of holes drilled into the structure
- Prevent galvanic corrosion and potential leak paths
- Facilitate last minute changes and additions
- Simplify subsequent modification and repair

## STAUFF Bond System – from the original developer of the DIN 3015 STAUFF Clamp

- 1 STAUFF Bond Plate type SBP
- 2 Original STAUFF Clamps in the Standard Series
- 3 Adhesives
- 4 Dispensing Tools


1 Internal dynamic installation fixture

1 Primed area



2 Original STAUFF Clamps in different versions and special materials for the installation of pipes, tubes, hoses, cables and other components as well as STAUFF ACT Clamps

<p>3 Adhesives</p>  <p>Adhesive Cartridge Type CB420-50(E)</p>	<p>4 Dispensing Tools</p>    <p>Adhesive Dispenser Type SBD</p> <p>Dispenser Slide Type SBDS-81</p> <p>Mixing Tip Type SBMT</p>
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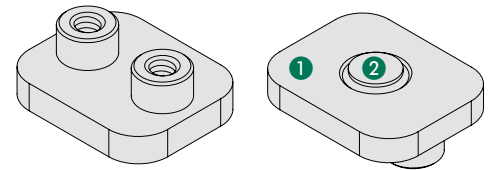
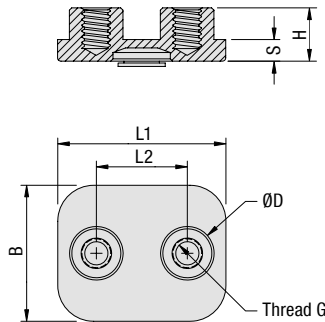


**Installation Video**

Convince yourself from the high productivity due to fast and easy handling and benefit from significant time and cost savings.

[www.stauff.com/en/bond](http://www.stauff.com/en/bond)

**STAUFF Bond Plate**  
**Standard Series (DIN 3015-1)**  
**Type SBP**



Top View

Bottom View

- 1 Adhesive to be applied to this primed area of the bond plate
- 2 Internal dynamic installation fixture providing constant positive pressure and holding the bond plate in position while the adhesive cures<sup>1</sup>

**Order Code**

**STAUFF Bond Plate**      **\*SBP\*2\*M\*W5**

- \* STAUFF Bond Plate      **SBP**
- \* STAUFF Group      **2**
- \* Thread code      Metric ISO thread      **M**  
    Unified coarse (UNC) thread      **U**
- \* Material code      Stainless Steel V4A -      **W5**  
    1.4408 (AISI 316)

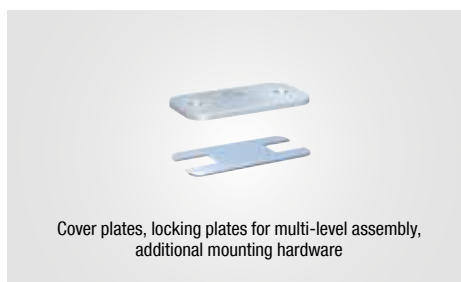
Please note: The bonding surface of the STAUFF Bond plate is primed with a two-component chemically cured waterborne primer (MIL-PRF-85582) that forms a film that is resistant to chemicals, solvents, moisture and abrasion.

Group STAUFF	DIN	Dimensions (mm/in)		Dimensions (mm/in)							Order Codes (Standard Options)	Packaging Unit (in Pieces)
		Diameter (mm/in)	Clamp Body	Thread G	L1	L2	B	S	H	ØD		
1A	1	6 ... 12	M6	36	20	30	5	11,3	11,8	<b>SBP 1A M W5</b>	25	
		.24 ... .48	1/4-20 UNC	1.42	.79	1.18	.20	.44	.46	<b>SBP 1A U W5</b>		
2	2	12,7 ... 18	M6	42	26	30	5	11,3	11,8	<b>SBP 2 M W5</b>	25	
		.50 ... .71	1/4-20 UNC	1.65	1.02	1.18	.20	.44	.46	<b>SBP 2 U W5</b>		
3	3	19 ... 25,4	M6	50	33	30	5	11,3	11,8	<b>SBP 3 M W5</b>	25	
		.75 ... 1.00	1/4-20 UNC	1.97	1.30	1.18	.20	.44	.46	<b>SBP 3 U W5</b>		
4	4	26,9 ... 32	M6	60	40	30	5	11,3	11,8	<b>SBP 4 M W5</b>	25	
		1.06 ... 1.26	1/4-20 UNC	2.36	1.57	1.18	.20	.44	.46	<b>SBP 4 U W5</b>		
5	5	32 ... 42	M6	71	52	30	5	11,3	11,8	<b>SBP 5 M W5</b>	25	
		1.26 ... 1.65	1/4-20 UNC	2.80	2.05	1.18	.20	.44	.46	<b>SBP 5 U W5</b>		
6 <sup>1</sup>	6	44,5 ... 54	M6	88	66	30	5	11,3	11,8	<b>SBP 6 M W5</b>	25	
		1.75 ... 2.12	1/4-20 UNC	3.46	2.60	1.18	.20	.44	.46	<b>SBP 6 U W5</b>		
7 <sup>1</sup>	7	57,2 ... 76,1	M6	122	94	30	5	11,3	11,8	<b>SBP 7 M W5</b>	10	
		2.25 ... 3.00	1/4-20 UNC	4.80	3.70	1.18	.20	.44	.46	<b>SBP 7 U W5</b>		
8 <sup>1</sup>	8	88,9 ... 102	M6	148	120	30	5	11,3	11,8	<b>SBP 8 M W5</b>	10	
		3.50 ... 4.00	1/4-20 UNC	5.83	4.72	1.18	.20	.44	.46	<b>SBP 8 U W5</b>		

<sup>1</sup> Please note: For STAUFF Group 6 to 8, STAUFF Bond Plates are equipped with each two internal installation fixtures.

**Original STAUFF Clamps for Quick, Easy and Safe Pipe, Tube, Hose and Cable Installation**

Clamp bodies manufactured from thermoplastics (PP / PA), thermoplastic elastomers (SA), aluminium (AL) or special materials as well as mounting hardware made of Steel or Stainless Steel



## Adhesive Cartridge Type CB420-50(E)



### Characteristics

The STAUFF Bond acrylic structural adhesive is a two-component thixotropic paste adhesive (mixing ratio of 10:1) packed in a suitable 50 ml / 1.69 oz dual cartridge.

It is capable of bonding a wide variety of prepared or unprepared metals, engineering thermoplastics and composites, and replacing commonly used mechanical fastening methods such as welding, brazing, bolting and riveting in various industries.

The STAUFF Bond adhesive cures quickly at room temperature and exhibits excellent environmental and chemical resistance.

### Processing instructions

#### Cure Time

15 to 18 minutes to 75% of ultimate strength and 24 hours to 100% of ultimate strength at room temperature of +24 °C / +75 °F.

#### Shelf Life

Minimum 9 months when stored in a dry place and in the original package at temperatures from +13 °C to +24 °C / +55 °F to +75 °F. Shelf life can be maximized by refrigeration at temperatures from +7 °C to +13 °C / +45 °F to +55 °F.

Do not freeze adhesive!

Find the Safety Data Sheet at: [www.stauff.com/en/bond/sds](http://www.stauff.com/en/bond/sds)

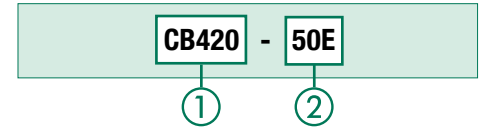
#### Temperature

Operating temperature range from -55 °C to +121 °C / -67 °F to +240 °F.

Pay attention to the expiry dates printed on the cartridges!

Alternative types of adhesives are available on request. Please consult STAUFF for further information.

### Order Code



#### ① Type

Adhesive Cartridge **CB420**

#### ② Execution

International **50**  
Europe (Delivery Standard Europe) **50E**

### Required Accessories

- Adhesive Dispenser, Dispenser Slide, Mixing Tip

Recommended number of STAUFF Bond Plates SBP to be installed with a single Adhesive Cartridge Type CB420-50(E)

STAUFF Group	1A	2	3	4	5	6	7	8
No. of Bond Plates	25	25	20	20	15	15	5	5

## Installation Guideline

### Surface Preparation

Thorough surface preparation is an essential part of adhesive bonding and at least as important as the actual installation.

Lightly abrade glossy surfaces to improve the adhesive bond strength. Just prior to adhesive application, clean surfaces with solvent using clean and lintless rags or paper towels. Do not use shop towels, rags or paper wipes contaminated with oil, soap or reclaimed solvents.

Clean one small area at a time, then dry with a clean cloth before the solvent evaporates to prevent re-deposition of contaminants. To maintain a clean solvent supply, always pour the solvent onto the washing cloth.

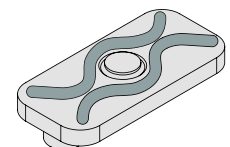
You may also want to clean the bottom of the bond plate prior to adhesive preparation. Use a clean cloth saturated with solvent to wipe the part with a single circular motion. Use caution not to disturb the internal fixture.

Safety note: Always wear gloves and protective glasses!

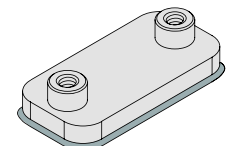
### Dispensing Directions

- Place the cartridge into the retaining lip on the dispensing gun. Mark the position of the cap of the cartridge, remove it by turning counter-clockwise and keep it for later use. When reclosing the cartridge, the cap must be used in the exact same position as it was before to avoid unwanted mixing and curing.
- Activate the dispensing gun slightly to extrude a small amount of adhesive onto scrap material to ensure adequate flow of both components. Attach the mixing tip to the adhesive cartridge and dispense a small line of adhesive onto scrap material to ensure adequate mixing.
- Remove the protective foil from the internal dynamic installation fixture(s) of the bond plate.
- Apply suitable amount of adhesive to the bonding surface of the bond plate (see drawing on the left), position the part in the desired location on the surface and press lightly on the center of the bond plate to actuate the installation fixture(s), which will provide constant positive pressure and hold the bond plate in position while the adhesive cures.

- A consistent bead of adhesive around the outside edges of the bond plate indicates proper installation and is a good visual quality assurance check.
- When not in use, remove and dispose the mixing tip and replace the cap to preserve remaining adhesive.



Indication, where and what amount of adhesive has to be applied to the bonding surface of the bond plate.



Consistent bead of adhesive around the outside edges of the bond plate indicates the proper installation.

Selection, proper application and correct installation of the products are the user's responsibility!

## Manual Adhesive Dispenser Type SBD

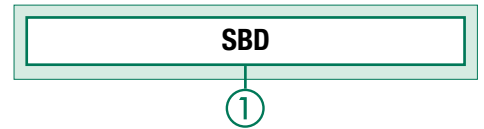


### Characteristics

The STAUFF Bond Manual Adhesive Dispenser has been designed for use with STAUFF Bond dual adhesive cartridges.

It is paired with a specific slide for dispensing adhesives with the correct mixing ratio.

### Order Code



#### ① Type

Manual Adhesive Dispenser **SDB**

### Required Accessories

- Dispenser Slide, Mixing Tip

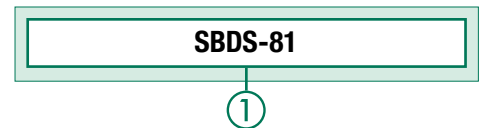
## Dispenser Slide Type SBDS-81



### Characteristics

The STAUFF Dispenser Slide is used in combination with the Manual Adhesive Dispenser and provides the required mixing ratio for the dispensing adhesives.

### Order Code



#### ① Type

Dispenser Slide **SBDS-81**

### Required Accessories

- Adhesive Dispenser, Mixing Tip

## Mixing Tip Type SBMT

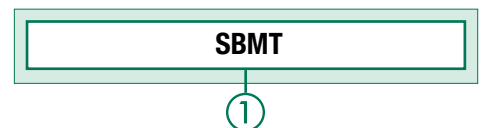


### Characteristics

The STAUFF Mixing Tip is designed to twist and lock onto the end of the adhesive cartridge. It does not only provide proper interleaving of pre-portioned components but additionally pre-phasing to ensure optimum mix uniformity.

To prevent pre-mix of the adhesive, the tip integrates a barrier separating the individual adhesive components until they reach the integral mixer. If open time of adhesive in the mixing tip exceeds the adhesive pot life, the adhesive will become cured in the tip, preventing further dispensing. Removal of the used tip and replacement with a fresh tip is as simple as twisting to remove the cured tip, wiping off the end of the cartridge, and twisting a new tip in place.

### Order Code



#### ① Type

Mixing Tip **SBMT**

### Required Accessories

- Adhesive Dispenser, Dispenser Slide