

TECHNICAL DATA SHEET

**High Temperature Cyanoacrylates: HT5, HT30, HT100, HT500, HT1000, HT1500,
HT2400, HT4000**

Product Description: This advanced performance series of Cyanoacrylates are a family of products that have been designed and manufactured to meet the higher demands of today's product performance requirements. This family of Cyanoacrylates has excellent high end temperature resistance. They are ideal for applications that have a high degree of temperature cycling and/or extended operation at elevated temperatures.

<u>Physical Properties:</u>	HT5	HT30	HT100	HT500	HT1000	HT1500	HT2400	HT4000
(Uncured Properties)								
Base Compound	----- Modified Ethyl Cyanoacrylate -----							
Appearance	----- Colorless, transparent liquid -----							
Viscosity @ 20°C	5cps	30cps	100cps	500cps	1000cps	1500cps	2400cps	4000cps
Flash Point (TCC)	----- 200°F -----							
Density	----- 1.05 to 1.10 -----							
Shelf Life	----- Six Months -----							
Soluble in	----- Nitromethane -----							
 (Cured Properties)								
Softening Range	----- 300°F to 325°F -----							
Melting Point	----- 350°F to 375°F -----							
Hardness (Shore A)	----- 80 -----							
Weatherability	----- No change observed after 200 hours -----							
Solubility	----- Nitromethane -----							
Fixture Time (Sec)	<7	<12	<14	<14	<18	<18	<18	<20
Full Cure	----- 24 Hours -----							
Tensile Shear	----- 2700 – 4200 psi -----							
Gap fill (Inches)	.002	.003	.006	.008	.008	.008	.008	.008
Temp. Range	----- -60°F to +275°F -----							

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Preparation:

For best results and optimum adhesive performance, surfaces should be clean and free from contaminants. Contaminants can be removed by using suitable solvents. When using a cleaning solvent, first check for material compatibility particularly in the case of plastics. An easy method for removing contaminants is by using a clean cloth and wiping the surface with acetone or alcohol.

Application:

The advanced performance series of High Temperature Cyanoacrylates should be applied in small amounts to one surface only. The parts should then be mated together under slight pressure. This causes the adhesive to spread out into a thin film and assures optimum adhesive performance. The pressure need only be applied for several seconds. The advanced performance series cures rapidly allowing for bonded parts to be handled within 20 to 50 seconds for most applications. Full cure is normally within 24 hours. In cases where Accelerator is used, fixturing will normally occur in less than 5 seconds with full cure in 8 hours.

Shelf Life:

All of the High Temperature series products have a shelf life of six months when stored at 40°F. Shelf life at room temperature (72°F) is a minimum of three months. When stored in a refrigerator, allow the adhesive to gradually warm to room temperature prior to use. Avoid heat, direct sunlight and high moisture areas when storing. Avoid contaminating open containers

Handling Precautions:

All High Temperature series products are non-toxic and so do not constitute a health hazard. Normal precautions should be observed. Use in areas where there is adequate ventilation. **KEEP AWAY FROM CHILDREN.**

Accidental skin bonding may occur. Use warm, soapy water to separate skin or use Debonder. Gradually work skin free. Do not use excessive force to pull bonded area apart: this will only result in the tearing of skin and/or cause irritation which is unnecessary.

Should eye contact occur flush with water and see a physician. Do not force the bonded area apart. When the corneal surface and eyelid are bonded together treat with a suitable anti-irritant ointment and allow the eye to remain closed. Bond separation will occur naturally within 48 hours with no damage.