

# ADHESIVE<sup>®</sup>

R&D

## High Temp HT 50 Cyanoacrylate Adhesive

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### LIQUID PROPERTIES

Ester Base	ethyl-2-
cyanoacrylate	
Appearance	Clear, colourless
Flashpoint	>81°C
Density	1.05
Shelf Life	6 months,
unopened	
Viscosity (Brookfield) @ 25°C	50 cP
(Spindle 1, 20rpm)	

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### POLYMER PROPERTIES

Appearance	Clear, colourless
Softening Point	c. 150°C
Refractive Index, $n_D^{20}$	1.45
Full Cure Time	24 hours
Solubility	DMF, acetonitrile,
acetone	

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### CURED PERFORMANCE

#### *Cure Speed*

Balsa / Balsa	10 - 20 seconds
Oak / Oak	NA
Nitrile / Nitrile	5 seconds
Neoprene / Neoprene	<7 seconds
EPDM / EPDM	<7 seconds
Steel / Steel	15-25 seconds
PVC / PVC	5-10 seconds
Polycarbonate / Polycarbonate	10-40 seconds

#### *Shear Strength*

Grit Blasted Steel	>15 N/mm <sup>2</sup>
Etched Aluminium	>11 N/mm <sup>2</sup>
Nitrile Rubber	>10 N/mm <sup>2</sup>
Polycarbonate	>12 N/mm <sup>2</sup>

#### *Tensile Strength*

Grit Blasted Steel	>18 N/mm <sup>2</sup>
Nitrile Rubber	>5 N/mm <sup>2</sup>
Neoprene Rubber	>5 N/mm <sup>2</sup>
EPDM Rubber	>2,5 N/mm <sup>2</sup>

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### PRODUCT STORAGE

Adhesive R&D cyanoacrylates should ideally be stored in original sealed containers until used. Containers should be stored between 10°C and 22°C; avoid exposure to strong light and heat sources. Refrigeration prolongs shelf life.

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### DISCLAIMER

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