Adhesive Systems, Inc.

TECHNICAL DATA SHEET
TDS #: HP 300
CYANOACRYLATE ADHESIVE

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ADVANCE PERFORMANCE SERIES
HP 300 CYANOACRYLATE ADHESIVE

BLACK RUBBER TOUGHENED ADHESIVE

DESCRIPTION:

The HP Series is a highly engineered rubber toughened cyanoacrylate adhesive. It is elastomer modified providing excellent impact resistance, thermocycling properties, and heat aging properties. The TS Series is ideal for bonding dissimilar surfaces that are exposed to high and low end temperatures. High end temperature resistance up to 250^{0}F.

PHYSICAL PROPERTIES:

Color:	Black
Viscosity:	300
Specific Gravity:	1.10
Base:	ModifiedEthyl

PERFORMANCE PROPERTIES:

Substrate	*Fixture Time*	*Bond Strength*
Steel	< 12 Seconds	> 2100 psi
Aluminum	< 12 Seconds	> 1750 psi
Neoprene	< 5 Seconds	> 750 psi
ABS	< 10 Seconds	> 900 psi
PVC	< 5 Seconds	> 900 psi
Polycarbonate	< 10 Seconds	> 900 psi
Phenolic	< 10 Seconds	> 850 psi

NOTE: Method used, ISO 4587.

Tensile Strength:

Steel: > 1800 psi

NOTE: Method used, ISO 6922

ELECTRICAL PROPERTIES:

Dielectric Constant	ASTM D 150 Dissipation Factor
1 kHz	2 to 3.50/ < 0.02

Volume Resistivity ASTM D 257: 2 x 10^{15} to 10 x 10^{15}

FACTORS AFFECTING CURE SPEED:

GAP: Thin bond line results in faster cure speed. Larger gaps will lengthen cure speed.

HUMIDITY: Cure and fixture times can be influenced by the humidity conditions at the time of assembly. The higher the RH the faster cure and fixture times will be. Fixture time data based on our testing is conducted at 50% relative humidity.

What we bond:

ABS	*NBR*
Acrylic	*Neoprene*
Aluminum	*Nitrile*
Bakelite	*Nylon*
Brass	*Phenolic*
Chloroprene	*Polycarbonate*
Chrome	*Polyester*
Cooper	*Polystyrene*
EPDM	*Porcelain*
Fiberglass	*PVC*
Latex	*SBR*
Leather	*Steel*
Natural Rubber	*Valox*
	Wood

CHEMICAL/SOLVENT RESISTANCE:

% OF STRENGTH RETAINED AFTER AGING FOR 500 HOURS

GASOLINE @ 22^{0}C:	*100%*
ISOPROPANOL @ 22^{0}C:	*100%*
ETHANOL @ 22^{0}C:	*100%*
FREON TA @ 22^{0}C%	*100%*
MOTOR OIL @ 40^{0}C%	*100%*
POLYCARBONATE 40^{0}C @ 95% RH	*100%*

DIRECTIONS FOR USE:

For optimum results parts should be clean and free from any contamination on the bonding surface. If parts do not mate flush together use a higher viscosity product to compensate for the gap. Any excess adhesive can be removed using Remove Debonder.

STORAGE:

Store product in unopened containers, out of direct sunlight, in a dry location. Material should be stored at or below 22^{0}C. For extended shelf life unopened containers of the product may be refrigerated.

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