

CYANO-HV HIGH TEMPERATURE & IMPACTS INSTANT ADHESIVE

Item #	EAN	Product
829209	366033848289	Cyano-HT

Description

High viscosity universal instant cyanoacrylate adhesive, special high temperature, impact and moisture resistant. For the assembly of materials such as plastics or elastomers requiring high tensile and/or shear strength (metal-to-metal, metal-to-rubber and metal-to-plastic bonds).

Made in Germany.

Physical properties

(a) Cyanoacrylate Monomer (Liquid):	
Base compound	Ethyl-2-cyanoacrylate
Colour	Black
Viscosity at 20°C cone-plate @ 0.5 rpm @ 160 rpm	6000 +/- 2000 mPa.s 2000 - 4000 mPa.s
Density at 20°C	1,06 g/cm ³
Flashpoint	85 °C
Shelf life	9 months
(b) Cyanoacrylate Polymer (Polymerised):	
Traction resistance on NBR # = Material breakage	# 61 N/cm ²
Shear resistance on Steel	28 N/mm ²
Temperature range	-55°C / + 140 °C
Solubility	Acetone-Nitromethane-Ethylacetate
Setting time (seconds)	
Metal (Steel)	30 – 90
Plastic (ABS)	7 – 13
Elastomer (EPDM)	6 – 16
Wood (Beech)	>40



Standards & certifications

- ISO 10993-5: Tests for in vitro cytotoxicity (biocompatibility).
- RoHS conform.

Instructions

The surfaces to be glued must be clean and dry. Apply one or more drops to a single surface. Apply just enough to leave a thin layer after compression. Press the pieces together and hold them firmly for a few seconds. Good contact is essential. A proper bond develops in less than a minute and maximum strength is achieved in 24 hours. Wipe off excess adhesive from the top of the container and reseal. **Spartex Activator 829218** can be used to accelerate curing, to fill large gaps, for use with inactive materials.

Solvent resistance

Solvent	Example	Resistance
Alcohol	Ethanol, Methanol	+++
Ester (aromatic)	Ethylacetate	---
Ketone (aromatic)	Acetone, Benzophenone	---
Aliphatic hydrocarbon (alkanes)	Petrol, Heptanes, Hexane	++
Aromatic hydrocarbons	Benzyl, Toluol, Xylol	++
Halogenated hydrocarbons	Methylenchloride, Chloroform, Chlorobenzol	---
Weak aqueous acid	Nitrite, muriatic acid, sulphuric acid, phosphoric	+++ (- - - if concentrated)
Weak aqueous base	sodium hydroxide solution, caustic potash	+++ (- - - if concentrated)
Water		++
Iso-propanol		+++
Acetone		---
Mineral oil		++

Potential danger of cyanoacrylates

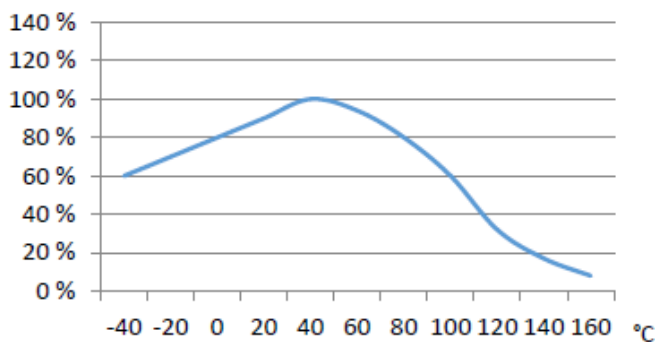
Use in well-ventilated areas only. Install appropriate exhaust systems in the workshop. Apply the material economically and use the dosing system whenever possible. Keep a constant relative humidity of 50 - 65%; for lower figures, polymerisation will be delayed and monomer glue fumes will appear. If necessary: wear suitable, non-sucking gloves (e.g. no cotton). Keep the adhesive out of the reach of children.

Curing performance

Ambient surface moisture initiates the curing process. Handling strength is reached in a short time, and will vary based on environmental conditions, bond line gap, and other factors. Product will continue to cure for at least 24 hours before full strength and solvent resistance is developed.

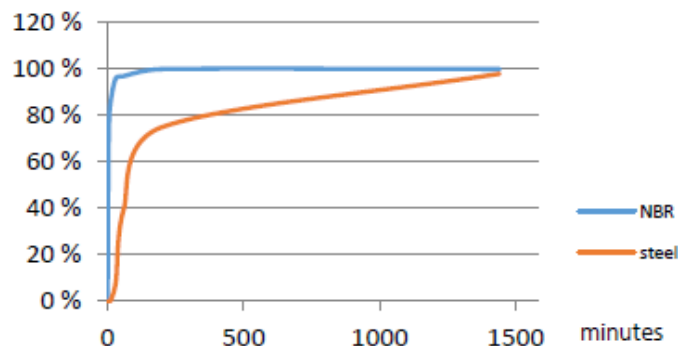
Hot strength depending on temperature

on steel, in % of traction resistance



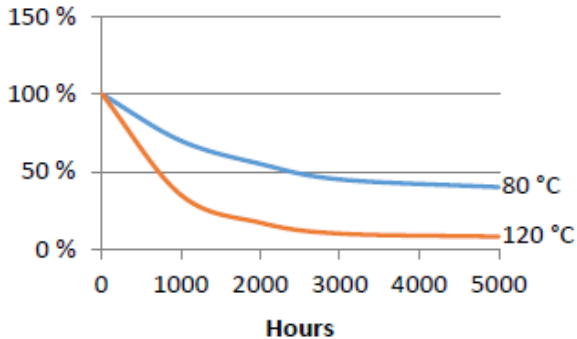
Curing through time

in % of traction resistance

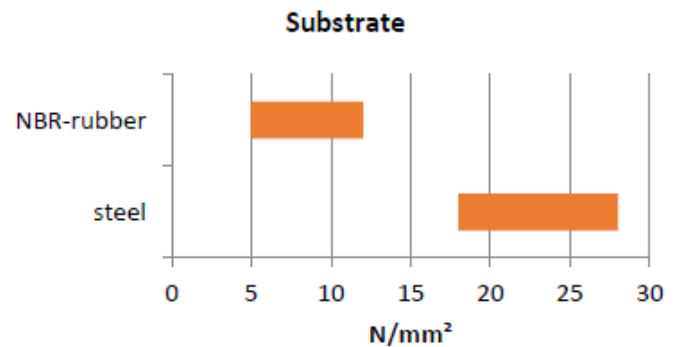


Heat aging

tested at 20°C in % of traction resistance

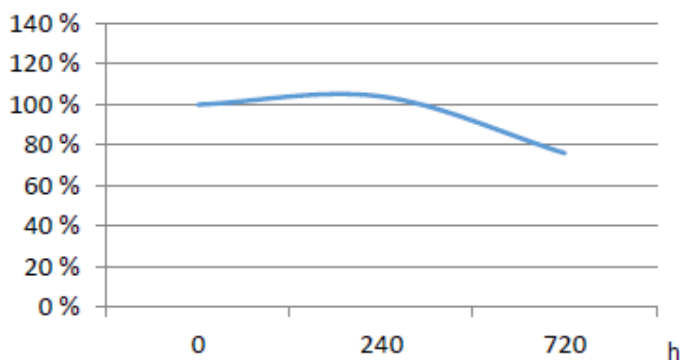


Adhesive resistance



Durability after Alternating Climate Storage

tested with stainless steel



Conditions	
Temperature range	-20 - 80 °C
Cycles	60
Holding time at start temperature	0 h
Heating up phase	3 h
Keeping warm phase	3 h
Cooling down phase	3 h
Holding time at final temperature	3 h

Conditionnement et stockage

- Bottle of 20g
- The dosing tip is screwed directly onto the thread of the bottle.
- Store in a cool, dry and dark place. The storage temperature should be between 15.5 and 25 °C without direct exposure to light or heat. Do not refrigerate.

Note

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