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ASI Adhesive Systems, Inc.

TECHNICAL DATA SHEET
TDS #: HT 1500
CYANOACRYLATE ADHESIVE
REVISED: DECEMBER/2010

ADVANCE PERFORMANCE SERIES
HT 1500 CYANOACRYLATE ADHESIVE
HIGH TEMPERATURE CYANOACRYLATE

DESCRIPTION:
HT Series has excellent high end temperature resistance up to 275^{0}F. Ideal for applications that have a high degree temperature cycling and/or extended operation at elevated temperature.

PHYSICAL PROPERTIES:

Color:	**Clear**
Viscosity:	**1500 cps**
Specific Gravity:	**1.09**
Base:	**Modified Ethyl**

PERFORMANCE PROPERTIES:

Substrate	*Fixture Time*	*Bond Strength*
Steel	< 25 Seconds	> 2100 psi
Aluminum	< 25 Seconds	> 1750 psi
Neoprene	< 10 Seconds	> 750 psi
ABS	< 18 Seconds	> 900 psi
PVC	< 15 Seconds	> 900 psi
Polycarbonate	< 18 Seconds	> 900 psi
Phenolic	< 18 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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