



TECHNICAL DATA SHEET
TDS #: HT 2400
CYANOACRYLATE ADHESIVE
 REVISED: DECEMBER/2010

ADVANCE PERFORMANCE SERIES
HT 2400 CYANOACRYLATE ADHESIVE
 HIGH TEMPERATURE CYANOACRYLATE

DESCRIPTION:

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

PHYSICAL PROPERTIES:

Color: Clear
 Viscosity: 2400 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: 2×10^{15} to 10×10^{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.

NON WARRANTY: Information contained herein is based on test and information we believe to be reliable and accurate. It is offered in good faith for the benefit of the consumer. ASI shall not be liable for any injury, loss, or damage, in the use of its chemical products since the conditions of use are beyond our control. In every case we urge and recommend the user conduct tests to determine to their own satisfaction that the product is of acceptable quality and suitable for their particular purpose under their own operating conditions. Statements concerning the possible use of our products are not intended as recommendations or to use our products in the infringement of any patent. These products are for Industrial Use only.

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°C:	100%
ISOPROPANOL @ 22°C:	100%
ETHANOL @ 22°C:	100%
FREON TA @ 22°C%	100%
MOTOR OIL @ 40°C%	100%
POLYCARBONATE 40°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°C. For extended shelf life unopened containers of the product may be refrigerated.

Engineering Excellence

For technical information and support call 1-800-552-0299 or visit our website at

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