

# ADHESIVE<sup>®</sup>



R&D

## BT 400 Cyanoacrylate Adhesive

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### LIQUID PROPERTIES

|  |              |
|--|--------------|
| Ester Base cyanoacrylate                         | ethyl-2-     |
| Appearance                                       | Black liquid |
| Flashpoint                                       | >81°C        |
| Density  | 1.05         |
| Shelf Life unopened                              | 6 months,    |
| Viscosity (Brookfield) @ 25°C (Spindle 1, 20rpm) | 350 - 450cP  |

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### POLYMER PROPERTIES

|                    |                    |
|--------------------|--------------------|
| Appearance         | Black resin        |
| Softening Point    | 160°C              |
| Full Cure Time     | 24 hours           |
| Solubility acetone | DMF, acetonitrile, |

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### CURED PERFORMANCE

#### *Cure Speed*

|                               |               |
|-------------------------------|---------------|
| Balsa / Balsa                 | 10-30 seconds |
| Nitrile / Nitrile             | <15 seconds   |
| Neoprene / Neoprene           | <15 seconds   |
| EPDM / EPDM                   | <20 seconds   |
| Steel / Steel                 | 10-30 seconds |
| Polycarbonate / Polycarbonate | 20-50 seconds |

#### *Shear Strength*

|                    |                       |
|--------------------|-----------------------|
| Grit Blasted Steel | >20 N/mm <sup>2</sup> |
| Etched Aluminium   | >12 N/mm <sup>2</sup> |
| Nitrile Rubber     | >5 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>  |

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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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