

**HOLDEN**

Holden Limited
Engineering Department

MATERIAL SPECIFICATION

NUMBER : HN 1970
SHEET : 1 of 3
RELEASE : February, 1988
REVISION :

NAME: ADHESIVE – CYANOACRYLATE - BLACK

1. SCOPE

A single component, solvent free modified cyanoacrylate ester with a 2-5 minutes fixturing time. This adhesive offers temperature and environmental resistance over other cyanoacrylate adhesives. The material bonds to a wide variety of metals, plastics and rubbers.

2. GENERAL

Cured material shall be insoluble and resist water, humidity and other chemicals used in the assembly of automotive products. The cured material produces a bond that provides improved resistance to peel and cleavage loading.

3. PROPERTIES AND TEST REQUIREMENTS3.1 Liquid Adhesive

- 3.1.1 Colour - opaque black.
- 3.1.3 Specific gravity - 1.1 nominal.
- 3.1.3 Usable viscosity - 200 to 2,200 cP.
- 3.1.4 Flash point (ASTM D92) - 80C min.
- 3.1.5 Soluble in - MEK Aceton, Nitromethane

3.2 Cured Adhesive

- 3.2.1 Melting point - 165° C
- 3.2.2 Hardness - 82 SHORE D
- 3.2.3 Cure time - 48 hours max.
- 3.2.4 Service temperature range - -54° to 104° C
- 3.2.5 Soluble in - Dimethyl Formanide, Nitromethane

3.3 Bond Properties. Tensile Shear Strength. Steel/Steel mPa min. (ASTM D 1002).

- 3.3.1 48 hours room temperature cure - 13.8
- 3.3.2 Hot strength - 24 hour RTC
Then 24 hour at 121° C and tested at 121° C - 6.9
- 3.3.3 Heat ageing, 24 hour RTC then 24 hours @ 121° C tested at room temperature - 20.6.
- 3.3.4 Humidity resistance 48 hours RTC then 100 hours at 38° C and 100% humidity - 13.8.

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3. PROPERTIES AND TEST REQUIREMENTS

3.4 180° peel strength. Steel/steel N/m min.
25 mm x 200 mm x .125 mm steel foil 24 hour RTC then 4 hours at 121° C,
tested at room temperature - 3,450.

3.5 Storage stability - four months minimum from time of receipt when stored
under refrigerated conditions (4° C).

4. APPROVAL)
CERTIFICATION)- Refer clauses A, B, C and G, HN 1000.
INSPECTION AND REJECTION)

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