



The Glue People

Trade Grade Products Ltd
Unit 2, Thorne Way
Woolsbridge Industrial Park
Three Legged Cross
Wimborne, Dorset, BH21 6FB

Tel 01202 820177
Fax 01202 814011



HV 416

High viscosity cyanoacrylate adhesive.

General Description

Tradelock cyanoacrylate adhesives are single part, fast curing adhesives that bond in seconds. They will economically bond metals, rubber, ceramics and most plastics to themselves or each other.

There are three adhesives in the range which differ mainly in viscosity:

	High	Medium	Low
Tradelock	B416	B424	B420

Application

Surfaces to be bonded should be clean, dry and free from dust, grease, oil and loose material. Adhesive must be at room temperature before use.

Apply one drop for every 6cm² of substrate. Join together the two surfaces to be bonded and press with enough pressure to ensure the drops of adhesive spread between the two surfaces. Allow adhesive to cure thoroughly before packaging for transportation or subjecting to normal working stresses. Full bond strength will be reached after 12 hours, although handling strength takes only 1 – 60 seconds.

Physical Data

Base	Ethyl cyanoacrylate monomer
Colour	Clear
10 second stick	70 kg/cm ²
Viscosity	1500 cps
Stability @ 82°C	3 days +
Tensile shear 24 hours	200 kg/cm ²
Specific gravity	1.05
Flash point (C.O.C.)	> 85°C
Shelf life	6 months @ 15°C

Bond Characteristics

Temperature. Between –20°C and +80°C the bond strength (shear) varies hardly at all. Above and below these temperatures there is a reduction of up to 50% of specification.

Moisture / Humidity. Excellent resistance.

Shock / Vibration. Excellent resistance.

General

For safe handling information on this product, consult the material safety data sheets, (MSDS).

Whitening may occur on very humid days. Correct this by means of local heating.

Storage

Products shall be ideally stored in a cool, dry location, out of direct sunlight, in unopened containers at a temperature between 8° to 28°C (46° to 82°F). Optimal storage is at the lower half of this temperature range. To prevent contamination of unused product, do not return any material to its original container. For specific shelf-life information, contact Trade Grade Products at the above address.

Important Notice

Data contained in this document is for information only and is believed to be reliable. Trade Grade Products Ltd (TGP) cannot assume responsibility for results obtained by others over whose methods we have no control. It is the user's responsibility to determine suitability of the product for any specific purpose and TGP is pleased to provide a sample upon request.

Before using this product ensure that you have been supplied with and have read carefully the following information.

- The hazard label (complying with latest CDG/CPL regulations) applied to the container.
- Material Safety Data Sheet, Tradelock HV.