



Hangzhou Margarita Trading Company

杭州玛格丽塔贸易有限公司

No: 0433
Date:2017-2-27

www.margadata.com

TECHNICAL DATA SHEET

Cyanoacrylate Adhesive

For Rubber, Plastic & Metal

DESCRIPTION

H1500 is a normal type Cyanoacrylate adhesive with fast setting, high flow ability, and good penetration characteristics. It has been specially formulated to achieve the strongest possible bond between well-mated, non-porous surfaces, such as rubber, metals, plastics, glass, etc xxxxxx is a one-component, solvent-free system and does not require the use of a catalyst, heat or clamps. When a thin layer of **H1500** applied between two surfaces comes into contact with atmospheric moisture, a rapid polymerization occurs producing the ultimate bond.

PHYSICAL PROPERTIES

Liquid State		Cured State	
Base materials:	Ethyl Cyanoacrylate and PMMA	Color	Clear
Color	clear	Specific Gravity(20°C)	1.10~1.32
Specific Gravity(20°C)	1.052~1.060	Softening Point(°C)	80 (176 °F)
Refractive Index (n_D^{20})	1.439	Refractive Index(n_D^{20})	1.490
Flash Point (°C)	80(176°F)	Dielectric Constant(at 10MHz)	3.51
Shelf Life	> 12 Months	Dielectric Loss(at 10MHz)	0.067
Boiling Point(°C)	65/6mm Hg	Soluble in Acetone, Dimethyl formamide, romethame, Dimethyl sulfoxide	
Viscosity(cps).....		1500CPS	

DIRECTIONS FOR USE

杭州市江干区采荷嘉业大厦 5 幢 1608 室
No.1608 , Building Number 5 , Cai He Jia Ye Tower,
Jianggan District , Hangzhou City, Zhejiang Province, China
Telephone and Fax: 0086-571-86483272 Mobile: 0086-13071802370
QQ: 1541483609



Hangzhou Margarita Trading Company

杭州玛格丽塔贸易有限公司

www.margadata.com

1. Make sure the surfaces to be bonded are clean and dry(preferable to solvent-wipe plastics , glass, and rubber, and to acid-treat metals).
2. Dispense a drop or drops to one surface only. Apply only enough to leave a thin film after compression.
3. Press parts together and hold firmly for a few seconds. Good contact is essential. An adequate bond develops in less than one minute.(Maximum strength is achieved in 24 to 48 hours).
4. Wipe off excess adhesive from the top of the container and recap **H1500** if left uncapped, may deteriorate by contamination from moisture in the air.
5. Because **H1500** condenses by polymerization, sometimes a whitening will occur on the surface of the container or the bonded materials. Should this happen, wipe surfaces well with acetone.

BOND STRENGTH

(TENSILE SHEAR STRENGTH, CURED FOR 24 HOURS AT 20-25°C (68-77°F)

KG/CM ²		KG/CM ²	
Rigid PVC to Rigid PVC	△40-60	SBR to SBR	△5-10
ABS to ABS	△50-70	Steel to Steel	140-200
Polycarbonate to Polycarbonate	△80-110	Stainless steel to Stainless steel	150-180
Polystyrene to Polystyrene	△30-45	Aluminum to Aluminum	130-190
Natural rubber to Natural rubber	△5-9	Copper to Copper	130-170
*Neoprene to Neoprene	△5-9	Steel to Rigid PVC	△50-60
NBR to NBR.....	△5-9	Stainless steel to Neoprene	△5-10
ABS to SBR.....	△5-10		



Hangzhou Margarita Trading Company

杭州玛格丽塔贸易有限公司

www.margadata.com

H1500 Seconds		Seconds	
ABS to ABS	9	NBR to NBR	10
Wood to Wood	20-30	Stainless steel to Stainless steel	10
ABS to Stainless steel	5-15	ABS to NBR	10
NBR to Stainless steel	5-10	Wood to ABS	15

PRECAUTION

1. Use with proper ventilation. Avoid contact with skin and eyes.
2. If contact with skin occurs, rinse with warm water or dissolve gradually with solvent such as acetone, dimethylformamide, or nitromethane. Do not try to remove forcibly.
3. If adhesive gets into eye, keep eye open and rinse thoroughly. Seek medical attention immediately.
4. Keep well out of reach of children.
5. Keep adhesive in a cool, dry place 20-25°C (68-77°F). For long term storage, refrigeration (5°C or 40°F) is recommended.