



HF8004

PRODUCT DESCRIPTION

Product HF8004 is two-component methacrylate adhesive designed for structural bonding.

TYPICAL APPLICATIONS

Typical applications include structural bonding of plastic and rigid components that must withstand vibrations and impacts such as in portable devices

PROPERTIES OF UNCURED

| Typical Uncured Properties | Part A | Part B | Mixed |
|-------------------------------|-----------|--------|------------|
| Open Time @ 70 ° F in Minutes | N/A | N/A | 5-7 |
| Appearance | off white | blue | light blue |
| Viscosity, cP | 32500 | 45000 | 36500 |
| Mix Ratio: By Weight | | | |
| By Volume | NA | NA | 10:1 |

AVERAGE PROPERTIES OF CURED MATERIAL

Physical Properties

When parts A and B are mixed, this product cures rapidly to a solid polymer. Note: Values on this sheet were obtained from an accelerated cure schedule. Results are not typical and may vary.

| Property | Average Value |
|--|---------------|
| Tensile strength, ASTM D882, N/mm ² | 25 |
| Modulus, ASTM D882, N/mm ² | 1303 |
| Elongation, Maximum % | 45% |
| Glass Transition Temperature, °C | 84 |



Typical Curing Performance

Data not available at this time

Preliminary Performance of Cured Material

Adhesive Properties:

Value

Cured for 20 min. at 80°C, then RT for 24 hours

Lap Shear Strength on IXEF, MPa

14.0

STM-700

Cross Lap Strength on IXEF, Mpa

3-4

STM-830

USE AND APPLICATION

This product is not recommended for use in pure oxygen and/or oxygen rich systems and should not be selected as a sealant for chlorine or other strong oxidizing materials.

For safe handling information on this product, consult the Material Safety Data Sheet (MSDS).

Storage

Store product in cool, dry location, in unopened containers at a temperature between 2 °C and 8°C unless otherwise labeled. 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.

Data Ranges

The data contained herein may be reported as a typical value and/or range. Values are based on actual test data and are verified on a periodic basis.