

Technical Data Sheet Instantbond 120

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Product Description

Hernon[®] Instantbond 120 is a single-component cyanoacrylate adhesive suitable for applications where heat resistance is required. **Instantbond 120** resists thermal cycling and also exhibits superior resistance to humidity.

Product Benefits

- Single-component: no mixing
- Good heat, thermal cycling, and humidity resistance
- Cures at room temperature
- Easy to apply

Typical Applications

- Bonding parts that require a higher humidity resistance than regular cyanoacrylates
- Parts subjected to elevated temperatures
- Parts subjected to thermal cycling
- Most rubber, plastic or metal substrates

Performance Requirements

Instantbond 120 meets the requirements of MIL-A-46050C, Type II Class 3, and CID A-A-3097 Type II Class 3.

Typical Properties (Uncured)

Property	Value
Chemical Type	Ethyl Cyanoacrylate
Appearance	Clear-Colorless
Viscosity, cP	600-750
Specific gravity	1.05
Flash point	See MSDS

Typical Curing Performance

Cure Speed vs. Substrate

The rate of cure will depend on the substrate used. The table below shows the fixture time achieved on different materials at 22°C / 50% relative humidity. Fixture time is defined as the time to develop a shear strength of 0.1 N/mm².

Substrate	Fixture Time (seconds)
Steel, degreased	20 to 30
Aluminum	2 to 10
ABS	5 to 10
Phenolic	10 to 20

Cure Speed vs. Bond Gap

The rate of cure will depend on the bondline gap. Thin bond lines result in high cure speeds, increasing the bond gap will decrease the rate of cure.

Cure Speed vs. Accelerator

Where cure speed is unacceptably long due to large gaps, applying accelerator to the surface will improve cure speed. However, this can reduce ultimate strength of the bond and therefore testing is recommended to confirm effect.

Typical Properties (Cured)

Cured 24 Hours @ 22°C

Physical Properties

Property	Value
Temperature range, °C, (°F)	-40 to 100 (-40 to 212)
Gap Fill, mm (in.)	0.177 (0.007)

Typical Cured Performance

Shear Strength

Cured 24 Hours @ 22°C - tested according to ISO 4587

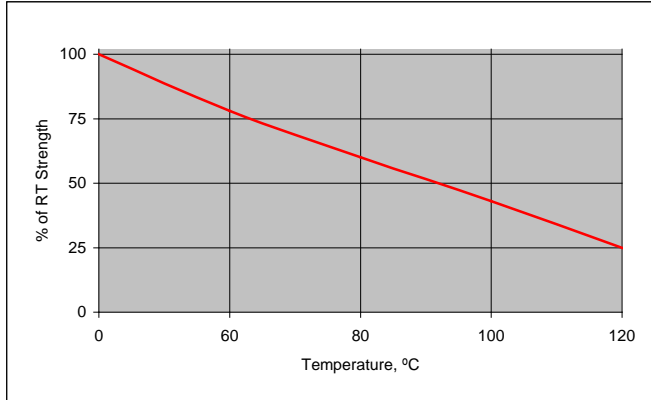
Substrate	Cure	Shear Strength N/mm ² (psi)
Steel (gritblasted)	24 hours at 22°C	≥ 13.8 (≥ 2000)
	24 hours at 22°C + 24 hours at 121°C tested at 121°C	≥ 6.9 (≥ 1000)
Polycarbonate	24 hours at 22°C	≥ 6.9 (≥ 1000)

Typical Environmental Resistance

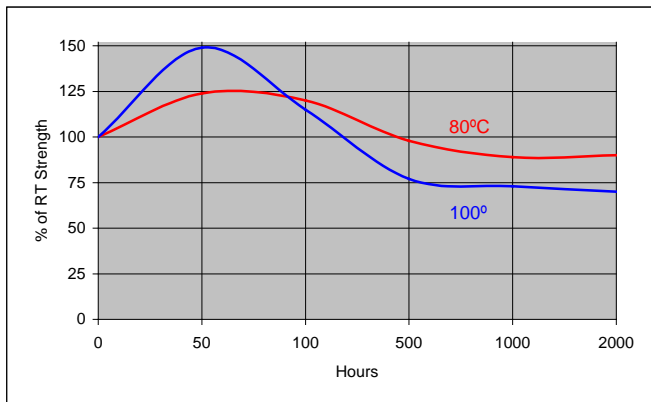
Cured for 1 week @ 22°C, Shear Strength, ISO 4587
Steel lap-shear specimens

Hot Strength

Tested at temperature

**Heat Aging**

Aged at temperature indicated and tested at 22°C

**General Information**

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).

Directions For Use

For best performance bond surfaces should be clean and free from grease. This product performs best in thin bond gaps (0.05 mm).

Disassembly and Cleanup

Liquid Cyanoacrylate should not be wiped with rags or tissue. The fabric will cause polymerization and large quantities of adhesive will heat or cure causing smoke and strong irritating vapors. Always flood with excess water to clean up spill conditions.

Storage

Cyanoacrylate adhesives must be stored under refrigeration at a temperature of 40°F ± 5°F for extended shelf life. Before opening, the containers must be warmed to room temperature, otherwise, water may condense into the bottle and cause hardening of the adhesive. To prevent contamination of unused adhesive, do not return product to its original container.

Dispensing Equipment

Hernon® offers a complete line of semi and fully automated dispensing equipment. Contact **Hernon® Sales** for additional information.

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