

Technical Data Sheet Instantbond 115

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Page 1 of 1

Product Description

Hernon[®] Instantbond 115 is a single component, fast curing, clear, medium viscosity cyanoacrylate instant adhesive formulated for electronic applications. Instantbond 115 is designed for use with Hernon[®] accelerators to produce instant cures for tacking electronic components.

Typical Applications

- Tack jumper wires to coil forms.
- Tamper proofing adjustable components.
- Mounting standoffs, edge guides, and stiffeners to circuit boards.

Performance Requirements

Instantbond 115 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 liquid
Viscosity @ 25°C, cP	700
Specific gravity	1.10
Flash point	See MSDS

Typical Properties (Cured)

Cured 24 Hours @ 22°C

Physical Properties

Property	Value
Glass transition temperature, °C, ASTM E228	130
Temperature range, °C, (°F)	-55 to 82 (-65 to 180)
Gap Fill, mm (in.)	0.152 (0.006)

Typical Cured Performance

Shear Strength

Cured 2 minutes @ 22°C - tested according to ISO 4587

Substrate	Shear Strength N/mm ² (psi)
Steel (grit blasted)	≥ 5.4 (≥ 780)

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

1. Apply one coating of Hernon[®] EF[®] Accelerator 52 to the area to be bonded, by spray, brush or dipping. Prior to application, contaminated surfaces may need special cleaning or degreasing to remove any dissolvable contamination.

Note: Because the solvent base of EF[®] Accelerator 52 can affect certain plastics or coatings, checking all surfaces for compatibility is recommended.

2. Allow the accelerator time to evaporate under good ventilation until the surfaces are completely dry (approximately 15 to 30 seconds).
3. Apply Instantbond 115 immediately after solvent has dried.

Note: If Instantbond 115 is not applied to the accelerator within 45 seconds, accelerator should be reapplied.

4. Where possible, move surfaces in relation to each other for a few seconds on assembly to properly distribute the adhesive and for maximum activation.
5. Secure the assembly and await fixturing before any further handling.

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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