

## ADBOND 5022-1 Medium viscosity cyanoacrylate structural adhesive

### DESCRIPTION

ADBOND 5022-1 general purpose medium setting adhesive is designed to bond a wide variety of similar or dissimilar substrates. The product is a versatile adhesive offering good climatic thermal and impact resistance. Its elasticity makes it ideal for bonding dissimilar materials. Handling strength in 15 to 30 seconds. ADBOND 5022-1 is capable of filling gaps up to 0.008”.

### PHYSICAL PROPERTIES

Color	clear
Viscosity	1500 cPs @ 25°C
Base	Ethyl
Adhesion strength	2700 – 4300 psi
Temperature resistance	-54°C to 93°C (-65°F to 200°F)
Handling time	15 seconds
Full strength	24 – 48 hours
MIL A 46050	Type II classe 1
Specific gravity	1.09
Shelf life	12 months

Cured	
ASTM D1002	Value
Grit blasted steel	3770 psi
Etched aluminium	3770 psi
ABS *	>885 psi
PVC *	>640 psi
Polycarbonate *	>825 psi
Phenolic *	160 psi
Neoprene rubber *	>1600 psi
Nitrile rubber *	>1600 psi
ASTM D2095	Value
Grit blasted steel	3000 psi

\*substrate failure

### DIRECTIONS FOR USE

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).

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4. Wipe off excess adhesive from the top of the container and recap ADBOND 5022-1. If left uncapped, it may deteriorate by contamination from moisture in the air.
5. Because ADBOND 5022-1 condenses by polymerisation, sometimes whitening will occur on the surface of the container or bonded materials. Should this happen, wipe surfaces well with ADSOLVE DM60060.
6. Initial setting can be accelerated using the ADBOND 5051 Activator. However this procedure can reduce the adhesion strength.

**STORAGE**

ADBOND 5022-1 is ideally stored in a cold, dry location in unopened containers. Optimal storage is under 10°C (50°F). To prevent contamination of unused product, do not return any material to its original container.

**CAUTION**

Use with proper ventilation. Avoid contact with eyes and skin. Always consult Safety Data Sheet (SDS) before using the adhesive. For industrial use only. For more information, please contact your technical representative.

**IMPORTANT****READ CAREFULLY**

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