

**ADBOND 5023HV-1**  
**High viscosity cyanoacrylate structural adhesive**

**DESCRIPTION**

ADBOND 5023HV-1 general purpose slow 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 30 to 60 seconds. ADBOND 5023HV-1 is capable of filling gaps up to 0.010”.

**PHYSICAL PROPERTIES**

Uncured	
Color	clear
Viscosity	2200 – 3000 cPs @ 25°C
Base	Ethyl
Softening point	120°C
Handling time	60 seconds
Maximum strength time	24 – 48 heures
Specific gravity	1.05
Shelf Life	12 months

Cured	
ASTM D1002	Valeur
Grit blasted steel	2700 – 2987 psi
Stainless steel	2276 – 2987 psi
Etched aluminum	2418 – 2700 psi
Copper	2133 – 2233 psi
ABS *	711 – 995 psi
PVC *	570 – 853 psi
Polycarbonate *	1138 – 1706 psi
Polystyrene *	427 – 640 psi
Neoprene *	71 – 128 psi
NBR *	71 – 128 psi
SBR *	71 – 142 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 5023HV-1. If left uncapped, it may deteriorate by contamination from moisture in the air.
5. Because ADBOND 5023HV-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 5023HV-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 SDS (Safety Data Sheet) before using the adhesive. For industrial use only. For more information, please contact your technical representative.

**IMPORTANT****READ CAREFULLY**

The information and recommendations contained herein are derived from our research and information from other reliable sources. This data applies only to our products and not when used with other products. We believe in the reliability of our information. However, no guarantee is offered to that effect. It is the responsibility of the buyer to verify this data according to their own operating conditions to ensure that they conform to the purpose for which the product is intended, even before using it.

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