

ADBOND 5022-2 Cyanoacrylate Adhesive

DESCRIPTION

ADBOND 5022-2 is a high viscosity, cyanoacrylate adhesive with slower cure speed compare to other cyanoacrylate. This adhesive develops strong bonds on wide variety of metals, plastics, and elastomeric compounds.

PHYSICAL PROPERTIES

Uncured	
Color	clear
Base	Ethyl
Viscosity	1500 cPs @ 25°C (77°F)
Setting time	Polycarbonate : 15 – 50 seconds Steel : 25 – 35 seconds Aluminum : 10 – 20 seconds Neoprene : < 5 seconds ABS : 10 – 30 seconds PVC : 10 – 30 seconds Phenolics : 10 – 15 seconds Nitrile Rubber : 5 – 7 seconds
Shelf life	12 months

Cured	
Gap filling	0.017 inch (0.45 mm)
Tensile shear strength	2175 – 3191 psi (15 – 22 N/mm ²)
Service Temperature range	-60°C – 80°C (-76°F – 176°F)
Melting point temperature	160°C – 170°C (320°F – 338°F)
Full cure	24 hours
Shear strength (D1002)	value
PVC	870 – 1305 psi (6 – 9 N/mm ²)
Acrylic	1450 – 2175 psi (10 – 15 N/mm ²)
Neoprene rubber	1450 – 2175 psi (10 – 15 N/mm ²)
ABS	1160 – 2030 psi (8 – 14 N/mm ²)
Polycarbonate	725 – 1450 psi (5 – 10 N/mm ²)
Coefficient of thermal conductivity (ASTM C177)	0.1 W.m ⁻¹ k ⁻¹
Glass transition temperature (ASTM E228)	125°C (257°F)
Coefficient of thermal expansion (ASTM D696)	90 x 10 ⁻⁶ K ⁻¹
Coefficient of thermal conductivity (ASTM C177)	0,1 W.m-1K-1
Dielectric strength (ASTM D149)	625 v/mil

**ADBOND 5022-2
Cyanoacrylate Adhesive****APPLICATIONS**

- Specially formulated to bond various plastics, metals and elastomers.
- Rough or irregular surfaces.
- Applications requiring alignment time of up to 15 seconds.
- Meets MIL-A-46050C type II class III

BONDS

Acrylic, PVC, Polysulfone, ABS, Polycarbonate, PEEK, PET, Rubber, Polyimide, PTEG, Latex' Metals.

DIRECTIONS FOR USE

- Make sure the surfaces to be bonded are clean, dry, dust and grease free. Best result will be achieved with surfaces that have been lightly abraded immediately prior to bonding.
- If using accelerator ADBOND 5051 apply to one component surface only. Apply thin film of adhesive to the other surface and bring the pieces together immediately. Hold for a few seconds without disturbing the joints.
- Thin bond lines favor high cure speed. Increasing the bond gap will slow down the rate of cure.
- Wipe off excess adhesive from the top of the container and recap ADBOND 5022-2. If left uncapped, may deteriorate by contamination from moisture in the air.
- Because ADBOND 5022-2 condenses by polymerisation, sometimes whitening will occur on the surface of the container or bonded materials. Should this happen, wipe surfaces well with ADSOLV DM60060

STORAGE

ADBOND 5022-2 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 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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