

### PRODUCT DESCRIPTION

**Modified cyanoacrylate | 1 part | solvent-free | room temperature curing**

- ▶ Bonding of materials with different coefficients of thermal expansion
- ▶ Delayed curing
- ▶ High strength at 120°C
- ▶ Impact and vibration resistant
- ▶ High temperature resistance

### CURING PROPERTIES

Curing takes place without heat supply or pressure. The classical one-component cyanoacrylates react with moisture, which is absorbed as a moisture film on the material surfaces, in a few seconds.

The curing speed depends on the gap width and the humidity level. A small gap width and a high humidity accelerate the setting process.

Cyanolit® attains high strength after a short period of curing. Full strength and reliability is obtained after 24h. Only after this time is the optimum media resistance achieved.

The following table describes the setting times on different substrates.

Substrate	Fixture time [s]	Tensile strength [MPa]
Steel	90	8.3
Aluminum	90	10.1
Brass	10	
Stainless steel	90	7.8
Steel/PVC	90	*8.1

**\*Substrate failure**

# TECHNICAL DATASHEET

## CYANOLIT® 402 X



### TECHNICAL DATA

Resin	Ethyl-2-cyanacrylat
Appearance	Transparent
Max. gap size [mm]	0.1
<b>Uncured Material</b>	
Viscosity [mPas]	70 – 100
Density [g/cm <sup>3</sup> ] <i>Test instruction P004</i>	1.1
Refractive index [nD20] <i>Test instruction P023</i>	1.492
<b>Cured Material</b>	
Typical operating temperature [°C]	-80 – 120

### TRANSPORT/STORAGE/SHELF LIFE

Package type	Transport	Storage	Shelf life*
Bottles	At room temperature max. 25°C	0°C – 10°C	At delivery min. 4.5 months max. 9 months
Pipettes			

**\*Store in original, unopened containers!**

### INSTRUCTIONS FOR USE

#### Surface preparation

The surfaces to be bonded should be free of dust, oil, grease, mold release, or other contaminants in order to obtain an optimal and reproducible bond. For cleaning we recommend the cleaner IP® from Hoenle, or a solution of Isopropyl Alcohol at 90% or higher concentration. Substrates with low surface energy (e.g. polyethylene, polypropylene) must be pretreated in order to achieve sufficient adhesion.

#### Application

Our products are supplied ready to use. Depending on packaging they can be applied by hand directly from the container or by using compatible dispensing systems and automation.

Cyanoacrylate adhesives react very quickly with humidity (20% – 80%) or the moisture film on the materials. It is therefore advisable to wear gloves and goggles when handling larger quantities. Cyanolit® is applied punctiform – one or more drops, depending on the size of the surface, onto one of the joining parts. The second joining part is fixed with slight pressure, whereby the adhesive is distributed into a thin film. Acid surfaces prevent or retard the curing, while basic surfaces (pH>7) accelerate curing.

The application can take place directly from the tip of the dosing bottle, but also with dosing devices. Since the achievable strength depends on the application quantity, an even dosage must be considered.

For assistance with dispensing and curing questions, please contact our Applications Engineering department. To obtain best results, the adhesive and substrates to be bonded may not be cold and should be allowed to warm to room temperature prior to processing.

#### Storage

Store uncured product in its original, closed container in a dry location. Any material removed from the original container must not be returned to the container as it could be contaminated. Hoenle cannot assume responsibility for products that were improperly stored, contaminated, or repackaged into other containers.

#### Handling and Clean-up

For safe handling information, consult this product's Material Safety Data Sheet (MSDS) prior to use. Uncured material may be wiped away from surfaces with organic solvents. Do not use solvents to remove material from eyes or skin!

### DISCLAIMER

The product is free of heavy metals, PFOS and Phthalates and is conform to the current EU-Directive RoHS.

**THE VALUES NOTED IN THIS TECHNICAL DATA SHEET ARE TYPICAL PROPERTIES AND ARE NOT MEANT TO BE USED AS PRODUCT SPECIFICATIONS.**

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