

## Technical Data Sheet Instantbond 117

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### Product Description

**Instantbond 117** is a high viscosity, state-of-the-art, single component, solventless, room temperature curing cyanoacrylate adhesive that polymerizes rapidly when pressed into a thin film between parts. The presence of surface moisture commences the cure of the adhesive. **Instantbond 117** develops handling strength within seconds and full functional strength in a few hours. **Instantbond 117** can bond a wide variety of surfaces including metals, thermoplastics, elastomers, ceramics, leather, cork, and paper, but is particularly suited for wire tacking applications. Notwithstanding the superior bonding capability of **Instantbond 117**, it is NOT recommended for long-term glass to glass bonding applications.

### Typical Applications

#### **Bonding**

Rubber bumpers  
Permanent locking of plastic  
Fasteners  
Speaker components  
Shock mounts  
Gears to shaft  
Wiper blades  
Acrylic windows  
Name plates  
Catheters  
Honing stones  
Security collars  
O-rings  
insulation pads

#### **Fixturing**

Filter caps  
Jumper wires  
Heat sinks  
Gaskets  
Golf club parts  
Tennis racquet parts  
P.C. boards  
Wire tacking

#### **Potting**

Transistors  
Tamper proofing  
Adjustable components  
Fiberglass molds

### Product Benefits

- Rapid Cure - forms a strong bond at room temperature in less than a minute with contact pressure.
- Surfaces - will bond almost any combination of similar or dissimilar materials.
- Easy Use - single component feature, eliminates any mixing.

### Performance Requirements

**Instantbond 117** 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	1300 -1700
Specific gravity	1.05
Flash point	See SDS

### Typical Properties (Cured)

Cured 24 Hours @ 22°C

### Physical Properties

Property	Value
Temperature range, °C, (°F)	-55 to 82 (-65 to 180)

### Typical Curing Performance

#### **Cure Speed vs. Substrate**

The rate of cure will depend on the substrate used. The table below shows the fixture time achieved on different materials at 22°C. Fixture time is defined as the time to develop a shear strength of 0.1 N/mm<sup>2</sup>.

Substrate	Fixture Time (seconds)
Steel (With EF Accelerator 72)	≤ 180
Polycarbonate	≤ 45
Phenolic	10 to 20

#### **Cure Speed vs. Bond Gap**

The rate of cure will depend on the bondline gap. Thin bond lines result in high cure speeds, increasing the bond gap will decrease the rate of cure.

#### **Cure Speed vs. Accelerator**

Where cure speed is unacceptably long due to large gaps, applying accelerator to the surface will improve cure speed. However, this can reduce ultimate strength of the bond and therefore testing is recommended to confirm effect.

### Typical Cured Performance

#### **Shear Strength**

Cured 24 Hours @ 22°C - tested according to ASTM D1002.

Substrate	Shear Strength N/mm <sup>2</sup> (psi)
Steel (grit blasted)	≥13.8 (≥2000)

### 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 Safety Data Sheet (SDS).**

#### **Directions for Use**

For best performance bond surfaces should be clean and free from grease. This product performs best in thin bond gaps (0.05 mm).

#### **Disassembly and Cleanup**

Liquid Cyanoacrylate should not be wiped with rags or tissue. The fabric will cause polymerization and large quantities of adhesive will heat or cure causing smoke and strong irritating vapors. Always flood with excess water to clean up spill conditions.

#### **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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