

 High Temperature

Super Glue HT 1000

WIKO Super Glue High-Temperature is developed for special applications and used for operations where universal superglue does not provide an optimal result. WIKO Super Glue High Performance is very resistant to moisture and does not soak through paper or cardboard.

Trading units	Item no.:
10g bottle	SGHT1000.F10
20g bottle	SGHT1000.F20
50g bottle	SGHT1000.F50
500g bottle	SGHT1000.F500

Physical Properties (Liquid state)

Chemical base:	Ethyl cyanoacrylate monomer
Appearance:	Colourless liquid
Density:	1.06 g/ml
Viscosity:	800 – 1200 mPas 25 °C Brookfield LV Spindel 62; 20 U/min

Polymeric Properties

Softening point:	145°C
Hardness (Rockwell):	M58
Full cure time:	24 Stunden
Solubility:	DMF, Acetonitril, Aceton

Temperature Range

Temperature range:	- 40°C bis + 120°C
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Cure Speed (approx..23°C / 50 % rel. humidity)

Balsa wood:	6 – 12 seconds
Nitril rubber:	5 – 8 seconds
EPDM:	7 – 10 seconds
Neoprene:	7 – 10 seconds
Steel:	25 – 40 seconds
Polycarbonate:	15 – 25 seconds
ABS:	10 – 15 seconds
Aluminium:	20 – 30 seconds

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Shear Strength

Steel:	15 – 25 N/mm ²
Aluminium:	7 – 10 N/mm ²
Polycarbonate:	5 – 10 N/mm ²
Nitrile rubber:	5 – 10 N/mm ²
ABS:	6 – 10 N/mm ²

Tensile Strength

Nitrile rubber:	5 – 15 N/mm ²
EPDM:	2 – 6 N/mm ²
Neoprene:	5 – 15 N/mm ²

Storage

The product has a storage life of at least 12 months if stored at ideal conditions (dark and dry) and a temperature between +2°C and +15°C. If the product is stored at normal temperatures between +16°C to 22°C, the storage life is at least 6 months. The product should be protected from direct sunlight or heat radiation.

Before the application, the unopened product should reach room temperature in order to optimise the adhesive strength and to protect the product against intruding air humidity.

The information contained in this data sheet, especially the suggestions for processing and application of products, is based on our experience and newest expertise. Due to the facts that materials can be very diverse and that we have no influence on the working conditions, we recommend to perform sufficient tests to validate the compatibility of the products. Our company shall neither be held liable for this information nor for a verbal or written consultation. Additionally, please consider the information of our safety data sheets.