

PACER
TECHNOLOGY

INDUSTRIAL • PRIVATE LABEL

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Fax: (909) 987-0490<http://pacertechindustrial.supergluecorp.com>**HI – High Impact Cyanoacrylates**

Pacer Technology HI Series cyanoacrylate adhesives offer excellent toughness and impact resistance compared to competitive formulations. Pacer's HI Series adhesives provide outstanding performance for metal-to-metal structural bonding applications. HI Series is available in three viscosity ranges to meet most application requirements.

LIQUID STATE	HI-50	HI-150	HI-500
Base Chemical	Ethyl Hybrid Cyanoacrylate		
Color	Clear, Translucent liquid		
Viscosity, cP	30-70	100-200	400-600
Flashpoint, °F (COC)	185	185	185
Vapor Pressure, mmHg @ 70°C	8	8	8
Specific Gravity (@25°C)	1.07	1.07	1.08
Gap Fill, Typical, inches	.004	.005	.008
Soluble in:	Acetone, MEK, Nitromethane		

CURED STATE	HI-50	HI-150	HI-500
Tensile Strength, steel (psi)	5000 (±10%)	5000 (±10%)	5000 (±10%)
Impact Strength, (ft.lbs/in ²) Steel, (ASTM D950-54)	10-15	15-20	20-25
Rockwell Hardness, M	75	75	75
Outgassing (@ 10 ⁻⁶ mmHg, 72°F)	0	0	0
Temperature Range	-65F to +180F (-54C to +82C)		
Soluble in:	Pacer X-9 Debonder, Acetone, Nitromethane		

	HI-50	HI-150	HI-500
Tensile Shear Strength, (psi)			
Steel	2700 (±10%)	2700 (±10%)	2700 (±10%)
Aluminum	1600 (±10%)	1600 (±10%)	1600 (±10%)
ABS	SF*	SF*	SF*
PVC	SF*	SF*	SF*
EPDM	100 (±10%)	100 (±10%)	100 (±10%)

* Substrate failure

STORAGE AND SHELF LIFE:

Refrigerate unopened cyanoacrylate @ 40F (4C) for optimum results. Allow adhesive to reach room temperature before opening. Once opened, store in a cool, dry location. Stored under these conditions, a one-year shelf life can be expected.



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APPLICATION AND CURE CHARACTERISTICS:

For best results, parts should be clean, free from oil and grease or other contaminants. Apply adhesive to one surface to be bonded and mate the other surface to it carefully and without delay. For best results, use a minimal amount of adhesive. In general, one free-falling drop covers one square inch of bond area. Avoid over-application, as excess adhesive is difficult to remove from unwanted areas. Fixture time occurs in 1-5 minutes with 80% of full strength developing in 15-30 minutes. Fixture time and full cure rates are dependent upon temperature, relative humidity, bondline thickness, and substrates being bonded. To speed full cure through larger gaps, Pacer accelerators for instant adhesives are compatible and can be used. Post application of accelerators to exposed adhesive may cause a white frosting (chlorosis) of the exposed adhesive onto parts, which can usually be removed using Pacer X-9 Debonder and a cotton swab. Overall cure strength can be decreased as a result of using accelerators. Testing on actual parts is recommended.

Specification Compliance	HI-50	HI-150	HI-500
MIL-A-46050C (Type/Class)	II/1	II/2	II/3
A-A-3097 (Commercial Spec)	II/1	II/2	II/3

SAFETY AND HANDLING PRECAUTIONS:

Cyanoacrylate adhesives bond skin in seconds. In case of skin contact, flush with water. If skin becomes bonded, peel (not pull) apart after immersion in warm, soapy water. In case of eye or mouth contact, flush with water and get immediate medical attention. Use with adequate ventilation. Vapors can irritate eyes and mucous membranes. Symptoms disappear after removal of individual from vapors. For more information, refer to Material Safety Data Sheet, available upon request.

In case of emergency, call CHEMTREC at (800) 424-9300 or call Pacer Technology at (800)-538-3091 (outside CA only), or 909-987-0550.

Size	HI-50	HI-150	HI-500
5 g			
20 g	FG05010	FG05020	FG05110
1 lb	FG05013	FG05023	FG05111

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