LOCTITE®

Design Guide for Bonding Plastics

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LOCTITE®
Design Guide for Bonding Plastics
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Table of Contents

The Problem

Plastics have become an integral part of everyday life. It would be difficult to identify a manufacturing process which does not use plastics in one form or another. Even products which appear to be composed exclusively of metals are usually coated, sealed, or adhesively joined using polymeric materials which improve the performance, appearance, and longevity of the metal products.

Plastics have achieved widespread acceptance due to the virtually limitless combinations of plastic types, fillers, and additives which can be compounded at relatively low costs and processed by a wide variety of methods. This gives plastic producers the ability to tailor their products to the specific needs of manufacturers with great precision. By properly selecting the plastic types, additives, and filler, as well as blends of different plastic types, the physical, chemical, and thermal properties of a plastic can be made to meet or exceed the performance requirements of almost any application.

However, while the limitless variety of plastics is an invaluable asset to a designer selecting a plastic, it is the designer's biggest limitation when selecting an adhesive. The countless adhesives available, coupled with the virtually limitless grades of plastics available, make it highly unlikely that there will be any specific bond strength data for the adhesive/plastic combination in the designer's application. Moreover, every year new grades of plastic are created, and old grades of plastic are discontinued or reformulated, making the acquisition of comprehensive bond strength data on specific grades virtually impossible.

The Solution

Bond Strength Information

This guide is designed to indicate the bondability of the 30 most commonly used plastic types, without performing the impossible task of actually testing each individual grade. For the first two volumes of this guide, this was accomplished using two basic approaches. For the first approach, 17 of the 30 plastics which were evaluated were compounded specifically to determine the effect different additives and fillers had on the bondability of these plastics. Once the designer identifies the tested formulations containing the same filler and additives as the particular grade in his design, he can then pinpoint the adhesives which performed the best on that material and will have a general idea of what bond strengths can be achieved. For the other 13 plastics, commercially available grades were selected to represent each major category available based on the major end-use applications of that plastic, the filler and additives typically used with that plastic, and/or the chemical structure of that plastic. Again, the bond strength information supplied can then be used as an indicator of the bondability of a material.

Volumes three and four of this guide are focused on increasing the number of adhesives tested on one grade of commercially available plastics. It can be inferred that the same strength trends seen in the original charts will hold true for the truncated tables found in this guide.

Adhesive Information

An adhesive cannot be selected for an application solely on the basis of bond strength information. Other factors such as the cure speed, environmental resistance, thermal resistance, and suitability for automation of an adhesive will play a critical role in determining the best adhesive for a specific application. To give a designer insight into these design parameters, an in-depth description of the seven adhesive types, namely cyanoacrylates, no-mix/static mix acrylics, hot melts, epoxies, polyurethanes, silicones and light curing acrylics, has been included in this guide. These adhesive sections contain a general description of each adhesive, a detailed discussion of the chemical structure and cure mechanism of each adhesive, and the benefits and limitations of using each adhesive.

Plastic Information

A manufacturer may have the flexibility to select the material which is best suited for the application in terms of performance and bondability. To aid the designer, an in-depth discussion of each of the plastic types is included. Information covered includes a general description of the plastic and its properties, as well as a list of trade names, suppliers, typical applications, and pricing information.

Surface Treatments

Some applications will require the use of plastics which are inherently difficult to bond. In these cases, the use of a surface treatment is necessary to effectively utilize the adhesive. In earlier versions of this guide, each individual material was evaluated using two of the more commonly used surface treatments, surface roughening and polyolefin primers. Again, due to the size of the updated adhesive matrix, no surface treatments were evaluated for the updated strength tables. The design engineer can use the earlier data and make correlations to the newer chemistries to get an idea of how surface treatments will affect the bond. In addition, the 12 most commonly used surface treatments are briefly described in the Surface Treatments section.

Bond Design Information

Finally, a manufacturer may have a design in which it is desired to incorporate an adhesively bonded joint. To effectively design that joint, the designer must know which parameters are critical to the bond strengths achieved by a bonded joint and the effect that changing these parameters will have. A bond design section which reviews the basics of designing an adhesively bonded single lap joint is included in an attempt to give the designer insight into this area. Although most "real world" bond geometries are more complex than single lap joints, this information can be extrapolated as a general indicator of the effects caused by changing bond geometries.

How To Use The Plastic Bonding Guide Chapters

Acetal Homopolymer

Thermoplastic

Trade Names

Manufacturer

General Description

General Properties

Typical Applications

14

Recycling Symbol A

Illustrates the appropriate recycling symbol for the indicated plastic type, when appropriate.

Typical Property Table B

Provides data on typical physical properties for each plastic.

Trade Names C

Lists common suppliers of each resin and the trade names for their products.

General Description D

Provides information concerning the chemical structure, typical cost and types of grades available for each plastic.

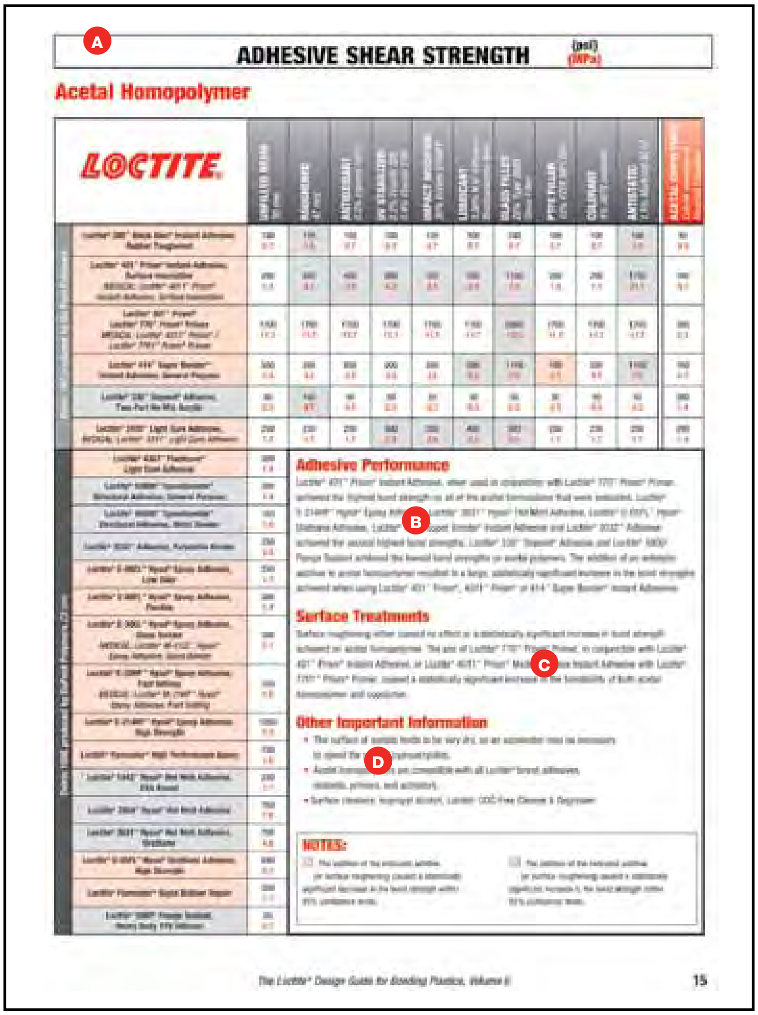
General Properties E

Describes the key characteristics of the plastic.

Typical Applications F

Lists markets where the plastic is used and the specific applications.

How To Use The Plastic Bonding Guide Chapters



ADHESIVE SHEAR STRENGTH (psi) (MPa)

Acetal Homopolymer

LOCTITE

Adhesive Performance

Surface Treatments

Other Important Information

NOTES:

The Loctite® Design Guide for Bonding Plastics, Volume 6 15

Ⓐ Adhesive Shear Strength Table

For a detailed explanation of the information contained in the Adhesive Shear Strength table, please turn to the next page.

Ⓑ Adhesive Performance

Summarizes the results of the adhesive shear strength evaluation table.

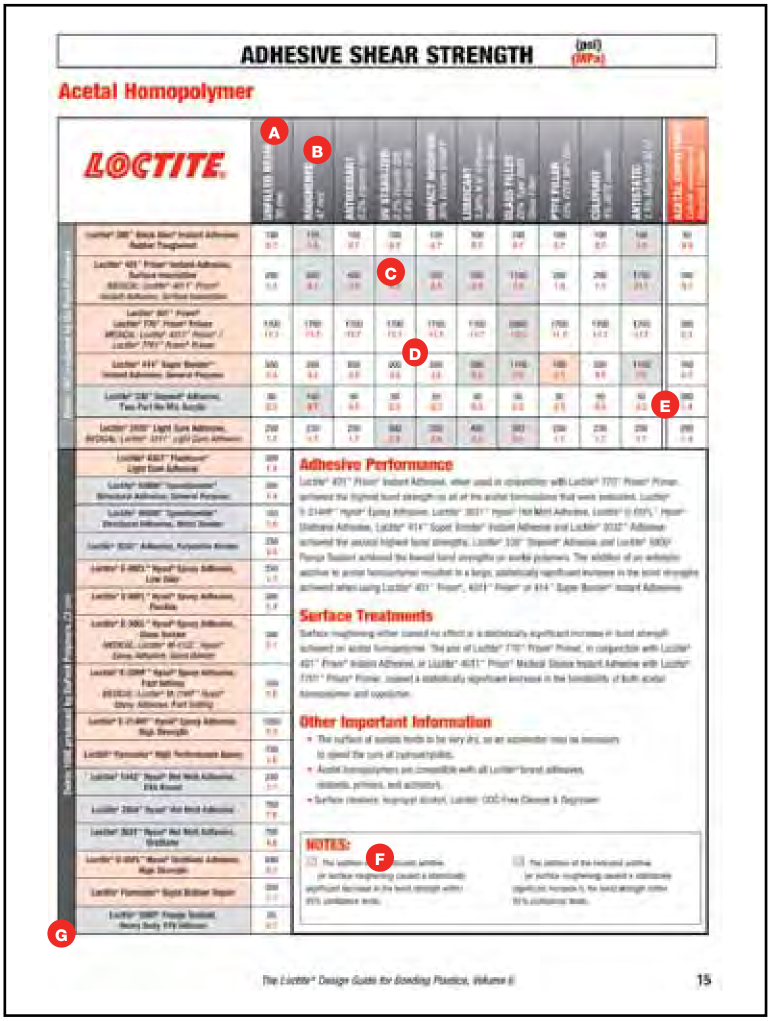
Ⓒ Surface Treatments

The effect of the polyolefin primer and surface roughening is summarized here. In addition, any information on common surface treatment methods is provided.

Ⓓ Other Important Information

Contains information on compatibility with cleaners and other miscellaneous information.

How To Use The Adhesive Shear Strength Table



ADHESIVE SHEAR STRENGTH (psi) (MPa)

Acetal Homopolymer

Adhesive Performance

Surface Treatments

Other Important Information

NOTES:

The Loctite® Design Guide for Bonding Plastics, Volume 6 15

A Unfilled Resin

The unfilled resin, used as the base resin for all of the compounded formulations, is listed at the top of the table next to each plastic type. Each individual formulation was then produced by compounding the unfilled resin with a single additive or filler, and was compared to the unfilled resin to determine if the additive or filler had a statistically significant effect on the bondability of the resin. The effect of the surface roughening was also evaluated on the unfilled resin and analyzed for statistical significance.

B Surface Roughness

The root-mean-squared (RMS) surface roughness of the material. This was evaluated on the unfilled plastic and the roughened unfilled plastic to show the effect of the roughening process.

C Shading

When a cell is shaded grey, the addition of the indicated additive or filler (or surface roughening) has resulted in a statistically significant increase in bondability of the formulation in comparison to the unfilled resin. A statistically significant decrease is denoted by red shading. If there was a change in the failure mode, the cell is also shaded accordingly.

D Single Line

A single line in the table indicates that the plastic evaluated below the line was compounded from the unfilled resin and compared to the unfilled resin for statistically significant changes in bondability.

E Double Line

A double line in the table indicates that the plastic evaluated to the right of this line is either a commercially available grade or a different plastic type than the unfilled resin, neither of which are compared to the unfilled resin for statistically significant changes in bondability.

F Notes

This section explains the superscripts and shading used in the table.

G Plastic Description

The plastic formulations were selected in two ways. For some plastics, commercially available grades were selected to represent each of the major categories of that plastic. For example, when testing ionomers, resins were selected for each of the major cation types, while for phenolics, grades were selected to represent each of the major end uses, such as electric, heat resistant, and chemical resistant grades. The remaining plastics were specifically compounded for the purpose of determining the effect of individual additives and fillers on the bondability of that material.

- **Commercially Available Grades**

If commercially available grades were evaluated, then the specific grades which were tested will be listed in the side bar of this table along with a short description of each grade.

- **Specialty Formulations**

If specialty formulations were compounded, then the additive or filler type, as well as the specific concentration and product used, will be listed in the side bar of this table.

Cyanoacrylate Adhesives

General Description

Cyanoacrylates are one-part, room-temperature-curing adhesives that are available in viscosities ranging from water-thin liquids to thixotropic gels. When pressed into a thin film between two surfaces, cyanoacrylates cure rapidly to form rigid thermoplastics with excellent adhesion to most substrates.

One of the benefits cyanoacrylates offer is the availability of a wide variety of specialty formulations with properties tailored to meet particularly challenging applications. For example, rubber-toughened cyanoacrylates offer high peel strength and impact resistance to complement the high shear and tensile strengths characteristic of cyanoacrylates. Thermally resistant cyanoacrylates are available which offer excellent bond strength retention after exposure to temperatures as high as 250°F for thousands of hours. Moreover, "Surface-insensitive" cyanoacrylates offer rapid fixture times and cure speeds on acidic surfaces, such as wood or dichromated metals, which could slow the cure of a cyanoacrylate. In some cases, the use of a general purpose cyanoacrylate adhesive was hampered by the appearance of a white haze around the bond line. This phenomenon is known as "blooming" or "frosting" and occurs when cyanoacrylate monomer volatizes, reacts with moisture in the air, and settles on the part. To eliminate this problem, "Low Odor/Low Bloom" cyanoacrylates were developed. They have a lower vapor pressure than standard cyanoacrylates and therefore are less likely to volatize. Ultraviolet curing (UV) cyanoacrylates are the latest advancement in cyanoacrylate technology. UV cyanoacrylates utilize proprietary photoinitiators to allow cyanoacrylates to surface cure in seconds when exposed to ultraviolet or visible light of the appropriate wavelength. Light Cure Technology makes cyanoacrylates cure even faster, overcome blooming, and limit or eliminate stress cracking. While advances in cyanoacrylate formulating technology have played a key role in offering additional benefits to the end user, there have also been important developments in cyanoacrylate primer and accelerator technology.

Accelerators speed the cure of cyanoacrylate adhesives and are primarily used to reduce cure/fixture times, to cure fillets on bond lines and/or excess adhesive. Accelerators consist of an active ingredient dispersed in a solvent. The accelerator is typically applied to a substrate surface prior to the application of the adhesive. Once the carrier solvent has evaporated, the cyanoacrylate can immediately be applied and its cure initiated by the active species that the accelerator has left behind. Depending on the particular solvent and active species present in the accelerator, the solvent can require 10 to 60 seconds to evaporate, and the active species can have an on-part life ranging from 1 minute to 72 hours. Accelerator can also be sprayed over a drop of free cyanoacrylate to rapidly cure it. This technique has been widely used for wire tacking in the electronics industry.

Another benefit offered by cyanoacrylates is the availability of primers which enable them to form strong bonds with polyolefins and other difficult-to-bond plastics such as fluoropolymers and acetal resins. Like the accelerators, polyolefin primers consist of an active ingredient dispersed in a solvent. Once the carrier solvent has evaporated, the surface is immediately ready for bonding, and the primer will have an on-part life ranging from minutes to hours. Depending on the plastic, bond strengths of up to 20 times the unprimed bond strength can be achieved.

Chemistry

Cyanoacrylate adhesives are cyanoacrylate esters, of which methyl and ethyl cyanoacrylates are the most common. Cyanoacrylates undergo anionic polymerization in the presence of a weak base, such as water, and are stabilized through the addition of a weak acid. When the adhesive contacts a surface, the water present on the surface neutralizes the acidic stabilizer in the adhesive, resulting in the rapid polymerization of the cyanoacrylate.

Advantages

- One-part system
- Solvent-free
- Rapid room temperature cure
- Excellent adhesion to many substrates
- Easy to dispense in automated systems
- Wide range of viscosities available
- Excellent bond strength in shear and tensile mode
- Primers available for polyolefins and difficult-to-bond plastics
- UV/Visible cure formulas available

Disadvantages

- Poor peel strength
- Limited gap cure
- Poor durability on glass
- Poor solvent resistance
- Low temperature resistance
- Bonds skin rapidly
- May stress crack some plastics

Epoxy Adhesives

General Description

Epoxy adhesives are typically two-part systems (resin and hardener) which cure at room temperature, although one-part pre-mixes which utilize a heat cure are also available, as are UV curable one and two component epoxies. The two components react stoichiometrically, so maintaining proper mix ratio is important to ensure consistent performance. Upon mixing, the curing reaction of the epoxy can release a great deal of heat and result in a significant temperature rise in the adhesive. In some applications, such as deep section potting, this heat rise can be sufficient to char the adhesive. Upon cure, epoxies form tough, rigid thermoset polymers with high adhesion to a wide variety of substrates and good environmental resistance. The viscosities of epoxy adhesives can range from a few thousand centipoise to thixotropic pastes.

The wide variety of chemical species that can react with the epoxide end group and the inherent stability of two-part adhesive systems lead to a wide variety of epoxy formulations available to the end-user. The performance properties of epoxies can be tailored to specific needs through a wide variety of techniques. Epoxy adhesives are typically rigid and formulating techniques must be employed to produce flexible epoxies. These techniques include the use of non-reactive plasticizers, the incorporation of rubber into the epoxy, and the use of epoxy resins with flexible backbones. The properties of epoxy adhesives are also varied through the use of fillers. For example, quartz fillers can impart improved impact resistance, ceramic fillers can offer improved abrasion resistance, and silver can be used to produce epoxies which are electrically conductive.

Chemistry

Epoxy adhesives polymerize to form thermoset polymers when covalent bonds between the epoxy resin and the hardener are formed through the reaction of the epoxide ring with the ring-opening species on the hardener. Amines, amides, mercaptans, and anhydrides are some of the types of hardener that are commonly used. Catalysts can be employed to accelerate the reaction rate between the epoxy resin and hardener. In addition, heat will also accelerate the reaction.
If heat is used to accelerate the cure of the epoxy, the increase in temperature can result in a drop of viscosity and an increased flow of the adhesive. In addition, curing the epoxy at a higher temperature will usually result in a stiffer material with a higher crosslink density and glass transition temperature.

Advantages

- High cohesive strength
- High adhesion to a wide variety of substrates
- Good toughness
- Cure can be accelerated with heat
- Excellent depth of cure
- Good environmental resistance

Disadvantages

- Two-part systems require mixing
- One-part systems require heat cure
- Long cure and fixture times
- Limited pot life and work time
- Exotherm may be problematic

Hot Melt Adhesives

General Description

Hot melt adhesives are one-part, solvent-free thermoplastic adhesives that are solid at room temperature and a low to medium viscosity (750 to 10,000 cP) adhesive at dispense temperatures (typically greater than 195°C). After dispense, hot melt adhesives rapidly cool to form a strong bond. In the cured or cooled state, hot melt adhesives can vary in physical properties from soft rubbery and very tacky to hard and rigid. Hot melts have excellent long term durability and resistance to moisture, chemicals, oils, and temperature extremes.

The latest advancement in hot melt technology is the reactive polyurethane adhesive (PUR). PURs initially behave like standard hot melts. That is, heat is added to the soften the urethane prepolymer and it is dispensed hot. Once the PUR cools, it reacts with moisture to crosslink into a tough thermoset polyurethane adhesive that cannot be remelted by adding heat.

Chemistry

Chemistries include ethylene vinyl acetate (EVA), polyolefin and polyamide based hot melts. EVA hot melts are the “original” hot melt and are thought of as the low cost, low performance hot melt. EVAs provide good adhesion to steel aluminum, rubber, and many plastics. Typical EVA hot melt applications include box and carton sealing. EVA hot melts can be formulated to carry a FDA approval for use in food packaging. Out of all available hot melts, EVAs typically have the poorest high temperature resistance.

Polyamide hot melts are a higher cost, higher performing adhesive with excellent high temperature resistance (up to 300°F). Specialty formulations are available that carry a UL-94V-0 rating (flame resistance). Polyamide hot melts have a tendency to absorb moisture from the air and require special packaging and storage considerations.

Polyolefin hot melts are specially formulated for adhesion to polyolefin (polypropylene, polyethylene, etc.) plastics. Compared to other chemistries, they have longer open times and they have excellent resistance against polar solvents.

Reactive polyurethanes are supplied as an urethane prepolymer, behaving much like a standard hot melt until it cools. Once the PUR cools, it reacts with moisture over time (a few days) to crosslink into a tough thermoset polyurethane.

Advantages

- One-part, solvent-free
- Fast fixturing
- High adhesion to plastics
- Wide variety of formulations available
- Low volumetric cost

Disadvantages

- Hot dispense point
- Operator safety – hot dispense point
- Poor adhesion on metals
- Cools quickly
- Equipment is required
- Thermoplastic parts may deform
- Charring in reservoir
- Moisture sensitivity

Light Curing Acrylic Adhesives

General Description

Light curing acrylic adhesives are supplied as one-part, solvent-free liquids with viscosities ranging from 50 cP to thixotropic gels. Upon exposure to ultraviolet or visible light of the proper intensity and spectral output, these adhesives cure rapidly to form thermoset polymers with excellent adhesion to a wide variety of substrates. The cure times of light curing acrylic adhesives are dependent on many parameters; however, cure times of 2 to 60 seconds are typical and cure depths in excess of 0.5" (13 mm) are possible. Formulations of light curing acrylic adhesives are available which vary in cured properties from very rigid, glassy materials to soft, flexible elastomers.

Light curing acrylic adhesives cure rapidly on demand, which minimizes work in progress and offers virtually unlimited repositioning time. In addition, the wide range of viscosities available facilitates the selection of a product for automated dispensing. These qualities make light curing acrylics ideally suited for automated bonding processes.

Chemistry

Light curing acrylic adhesives are composed of a blend of monomers, oligomers, and polymers containing the acrylate functionality to which a photoinitiator is added. Upon exposure to light of the proper intensity and spectral output, the photoinitiator decomposes to yield free radicals. The free radicals then initiate polymerization of the adhesive through the acrylate groups to yield a thermoset polymer.

When the adhesive is cured in contact with air, the free radicals created by the decomposition of the photoinitiator can be scavenged by oxygen prior to initiating polymerization. This can lead to incomplete cure of the adhesive at the adhesive/oxygen interface, yielding a tacky surface. To minimize the possibility of forming a tacky surface, the irradiance of light reaching the adhesive can be increased, the spectral output of the light source can be matched to the absorbance spectrum of the photoinitiator, and/or the adhesive can be covered with an inert gas blanket during cure.

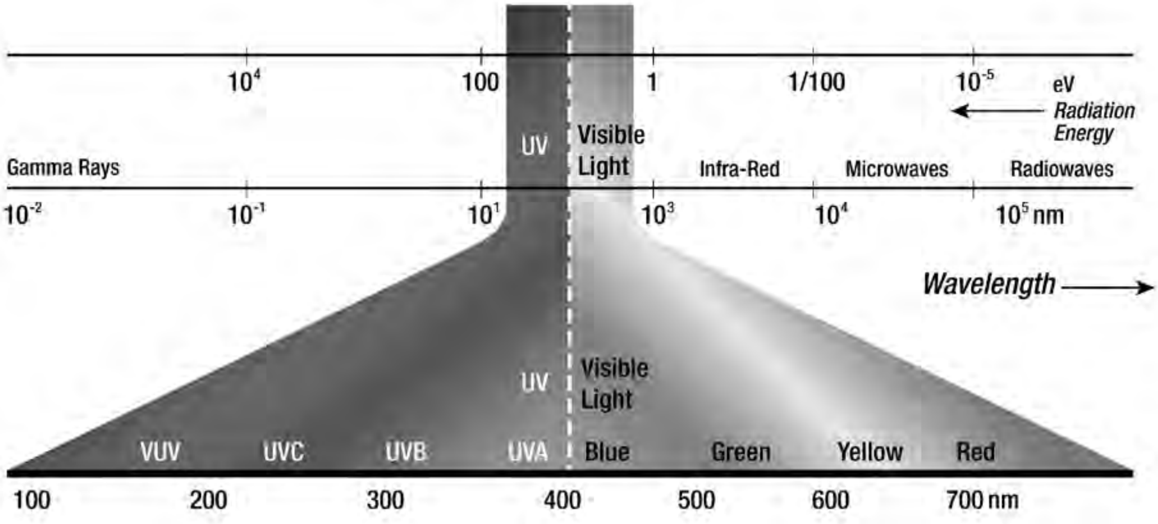
Advantages

- Cure on demand
- Good environmental resistance
- Wide range of viscosities available
- Solvent-free
- Good gap filling
- One-part
- Dispensing is easily automated
- Clear bond lines
- Rapid fixture and complete cure
- Wide range of physical properties
- UV/Visible cure systems available
- Fluorescent dyes can be added to ease inspection/detection

Disadvantages

- Light must be able to reach bond line
- Oxygen can inhibit cure
- Equipment expense for light source
- Ozone created by high intensity light source must be vented

The Electromagnetic Spectrum



Polyurethane Adhesives

General Description

Polyurethane adhesives are supplied as one- and two-part systems which range in viscosity from self-leveling liquids to non-slumping pastes. They cure to form thermoset polymers with good solvent and chemical resistance. They are extremely versatile and can range in cured form from extremely soft elastomers to rigid, extremely hard plastics. Polyurethanes offer a good blend of cohesive strength and flexibility which makes them very tough, durable adhesives.

Polyurethanes bond well to most unconditioned substrates, but may require the use of solvent-based primers to achieve high bond strengths. They offer good toughness at low temperatures, but typically degrade in strength after long-term exposure over 302°F (150°C). Since the cure of one-part, moisture-curing polyurethanes is dependent on moisture diffusing through the polymer, the maximum depth of cure that can be achieved in a reasonable time is limited at approximately 0.375" (9.5 mm). Two-part systems, on the other hand, offer unlimited depth of cure.

Chemistry

One-part polyurethane adhesives can react with moisture to polymerize. Another cure mechanism involves the evolution of species that inhibit the cure of the polyurethane. In either case, cure is dependent on a chemical species diffusing through the polyurethane matrix, so the depth of cure is limited. Two-part polyurethanes, which generally cure through the reaction of an isocyanate and a polyol, avoid this limitation and offer superior depth of cure. In either case, the polyurethane polymer forms rigid and soft domains that give the polymer its balance of flexibility and high strength.

Advantages

- Extremely tough
- Good resistance to solvents
- High cohesive strength
- Good impact resistance
- Good abrasion resistance

Disadvantages

- Limited depth of cure for one-part polyurethanes
- Mixing required for two-part polyurethanes
- Primer may be needed for adhesion to some substrates
- Limited high temperature use

Silicone Adhesives

General Description

Silicone adhesives are typically supplied as one-part systems that range in viscosity from self-leveling liquids to non-slumping pastes. They cure to soft thermoset elastomers with excellent property retention over a wide temperature range.

Silicones have good adhesion to many substrates, but are limited in their utility as structural adhesives by their low cohesive strength. Silicone adhesives are typically cured via reaction with ambient humidity, although formulations are also available which can be cured by heat, mixing of two components, or exposure to ultraviolet light. Since the cure of moisture-curing silicones is dependent on moisture diffusing through the silicone matrix, the cure rate is strongly affected by the ambient relative humidity and the maximum depth of cure is limited to 0.375 to 0.500". At 50% RH, moisture cure silicones will cure to a tack-free surface in 5 to 60 minutes, depending on the type used.

Complete cure through thick sections of silicone can take up to 72 hours. It should be noted that adhesive strength may continue to develop for 1 to 2 weeks after the silicone has been applied. This occurs because the reaction between the reactive groups on the silicone polymer and the reactive groups on the substrate surface is slower than the crosslinking reaction of the silicone groups with themselves.

Moisture curing silicones are categorized by the by-product given off as they react with moisture. For example, acetoxy cure silicones give off acetic acid. Alkoxy cure silicones give off alcohols (typically methanol or ethanol), and oxime curing silicones evolve methyl ethyl ketoxime. Acetoxy cure silicones are known for their ability to cure rapidly and develop good adhesion to many substrates. Their largest limitation is the potential for the by-product acetic acid to promote corrosion. Alkoxy cure silicones, on the other hand, do not have this limitation because the alcohol by-products are noncorrosive. This makes them well suited for electronic and medical applications where acetic acid could be a problem. Unfortunately, alkoxy cure silicones typically have lower adhesion and take longer to cure than acetoxy cure silicones.

Oxime cure silicones offer cure speeds and adhesion that rival, and in some cases surpass, that of acetoxy cure silicones. In addition, the oxime they evolve will not corrode ferric substrates, although it can stain copper or brass. Consequently, oxime silicones have found widespread use in automotive gasketing applications. The chief limitation of all moisture curing silicones is the difficulty associated with accelerating the cure rate. This concern was addressed through the development of UV cure silicones. Ultraviolet light curing silicones generally also have a secondary moisture cure mechanism to insure that any silicone which is not irradiated with ultraviolet light will still cure. Upon exposure to ultraviolet light of the proper wavelength and intensity, they will form a tack-free surface and cure to a polymer with up to 80% of its ultimate physical strength in less than a minute. Initial adhesion can be good, but because ultimate bond strength is dependent on the moisture cure portion of the silicone, full bond strength can take 1 to 2 weeks to develop. Silicones with a secondary acetoxy cure show good bond strength while those with a secondary alkoxy cure are lower.

Chemistry

Silicone formulations are available which can be cured through moisture, heat, mixing two components, and exposure to ultraviolet light. The silicones used for adhesives are typically the one-part moisture curing and UV curing silicones. All silicones have a chemical backbone made up of silicone to oxygen bonds, known as siloxane bonds. It is the high energy of this bond that gives silicones their unique high temperature performance properties.

Advantages

- One-part systems available
- Solvent-free
- Room temperature cure
- Excellent adhesion to many substrates
- Extremely flexible
- UV curing and two-part formulations available

Disadvantages

- Low cohesive strength
- Moisture cure systems have limited depth of cure
- Swelled by non-polar solvents

No-Mix and Static Mix Acrylic Adhesives

General Description

Acrylic adhesives consist of a resin and an activator/hardener. The resin component is a solvent-free, high-viscosity liquid, typically in the range of 10,000 to 100,000 cP, while the activator component can be a solvent dispersion of the cure catalyst (no-mix) or a high viscosity mix of the cure catalyst and performance additives.

If the carrier solvent present in the activator solvent dispersion is undesirable, the pure catalyst is also available as a solvent-free activator. However, when using a solvent-free activator, the amount of activator applied must be tightly controlled, as excessive activator will detrimentally affect the performance of the adhesive. With static mix acrylics, the viscosity of the resin and hardener are formulated to be very similar in order to ensure good mixing through the static mix tip. A primer may also be incorporated into the resin or hardener in order to enhance the bond strength on some substrates.

The resin base of no-mix acrylic adhesives can also be heat cured. A typical heat cure cycle is 10 minutes at 300°F (149°C). Heat curing normally offers higher bond strengths and shorter cure times. However, heating the adhesive lowers the resin's viscosity and may result in some adhesive flow out of large gaps. In some instances, it is desired to use a combination of these two cure methods, fixturing the assembly with activator prior to heat cure.

Application Method

When an activator is used, the adhesive is cured in the following manner:

- ✓ The resin is applied to one of the substrate surfaces.
- ✓ The activator is typically applied to the other surface.
- ✓ The activator's carrier solvent is allowed to flash off.
- ✓ The two surfaces are mated together.
- ✓ The catalyst from the activator then initiates the polymerization of the resin.

Typically, these systems develop fixture strength in two minutes and full strength in four to 24 hours. The activator serves only as a catalyst for the polymerization of the resin, so when using an activator, the ratio of activator to resin is not critical. However, this is not the case for solventless activators, because the activator is so concentrated that excess activator can prevent the adhesive from forming an intimate bond with the substrate. Since polymerization is initiated at the interface between the activator and resin, the cure depth is limited. Typically, the maximum cure-through-depth is 0.30" (0.76 mm) from this interface.

Static mix acrylic adhesives are dispersed using hand-held applicators and the appropriate static mix tip (typically 24 elements). Static mix acrylics offer unlimited depth of cure but due to the exothermic nature of the reaction, caution must be exercised. The exotherm may deform temperature sensitive substrates or cause "read-through" on the opposite surface.

Chemistry

The resin base consists of an elastomer dissolved in acrylic monomers. Peroxides are then blended in to provide the resin with a source of free radicals. The elastomers form a rubbery phase which gives the adhesive its toughness, and the acrylic monomers form the thermoset polymer matrix which gives the adhesive its environmental resistance and strength.

The type of cure catalyst used in the activator will vary depending on the cure chemistry of the adhesive. In no-mix acrylics, the catalyst(s) are often diluted in a solvent, although in some cases, they are supplied in solventless formulations. In static mix acrylics, the catalyst is blended in with a portion of the elastomer in order to match the viscosity of the resin. Upon contact of the cure catalyst(s) with the resin base, the peroxide in the resin base decomposes to yield free radicals. These radicals then initiate polymerization through the acrylate groups on the monomer in the resin base.

Advantages

- No mixing required (no-mix acrylics only)
- Good environmental resistance
- High peel and impact strength
- Bonds to lightly contaminated surfaces
- Fast fixture and cure
- Room temperature cure
- Good adhesion to many substrates
- Cure can be accelerated with heat

Disadvantages

- Higher viscosity systems can make automated dispensing difficult
- Activator may contain solvents (no-mix acrylics only)
- Unpleasant odor
- Limited cure-through depth (no-mix acrylics only)
- High exotherm (static mix acrylics)
- Short worklife of some formulations (static mix acrylics)

Why Bond Plastics With Loctite® Brand Adhesives?

Advantages Over Other Assembly Methods

According to the “Engineer’s Guide To Plastics,” published by Materials Engineering, adhesives are the most versatile assembly method for plastics. They are listed as being capable of joining 36 types of plastics compared to 28 types for mechanical fasteners, the next most versatile method. Methods such as heat staking and ultrasonic welding are limited by comparison, being suitable for 15 and 18 plastics, respectively.

Advantages Versus Mechanical Fasteners

Mechanical fasteners are quick and easy to use, but have a number of significant drawbacks.

- They create stresses in the plastic which may lead to distortion or cracking. Adhesives do not.
- There are extra components which must be purchased and inventoried. Adhesives require no extra components.
- They require altering the design of the product to include bosses and holes. Adhesives require no special features.
- Their appearance often interferes with the styling of the product. Adhesives are invisible inside a bonded joint.
- They concentrate all of the holding power at the fastener location, causing the applied load to be carried by a small area of plastic. Adhesives spread the load evenly over the entire joint area.

Advantages Versus Ultrasonic Welding

Ultrasonic welding can be an excellent method for certain types of assemblies. There are, however, a number of factors which limit its usefulness.

- Ultrasonic welding is not usable for thermosets. Adhesives are.
- Joining of plastics to metal, glass, or other materials is not feasible in most cases. Adhesives do this easily.
- The design of joints is restricted to geometries which are favorable to the process. Ideally, they should have a small, uniform contact area to concentrate the ultrasonic energy. Adhesives can accommodate irregular bond lines.
- The capability of joining different thermoplastics in the same assembly is limited to those which are chemically compatible and have similar melting points. Adhesives are not restricted in this way.
- Ultrasonic welding requires investment in machinery as well as special tooling for each part. Most adhesives require no machinery or tooling.

Advantages Versus Solvent Welding

Solvent welding can be a useful, low-cost method of assembling plastics. However, its usefulness is limited by a number of disadvantages.

- Solvent welding cannot be used with dissimilar materials such as metals or glass. Adhesives do the job.
- Solvents will not work with thermoset plastics. Adhesives will.
- Solvents are more likely to cause stress cracking than are adhesives.
- The time between the application of the solvent and the joining of the parts is critical. The joints are weak if too much solvent remains in the bond area or if too much solvent has flashed off prior to assembly. Adhesives have a much less critical open time.

Advantages Versus Solvent Cements

Solvent cements are low cost materials which have been traditionally used to join plastics. Their primary advantage is low cost, yet their limitations are numerous.

- They have poor resistance to heat and solvents.
- They produce solvent fumes which may be toxic or flammable.
- The open time of the bonded joint is critical.
- They require an extensive drying time.
- Solvent trapped inside the joint may lead to porosity or weakness.
- Solvent cementing is not capable of joining parts with significant gaps between them. Adhesives tolerate much larger gaps.
- Solvent bonds can take weeks to achieve full strength.

Acetal Homopolymer

Thermoplastic ♹ OTHER

Trade Names	Manufacturer
• Celcon	Hoechst Celanese
• Delrin	E.I. DuPont
• Iupital	Mitsubishi Gas
• Kemlex	Ferro Corporation
• Tenac	Asahi Chemical
• Ultraform	BASF

General Description

Acetal homopolymer is a highly crystalline thermoplastic produced by polymerizing formaldehyde and capping each end of the polymer chain with acetate groups. The polymer is properly called polyoxymethylene (POM) and has a backbone comprised of repeating $-CH_2O-$ units. Acetal copolymer is manufactured by copolymerizing trioxane with relatively small amounts of a comonomer. The comonomer randomly distributes carbon-carbon bonds in the polymer chain which helps to stabilize the resin against environmental degradation. The relatively low cost of acetals, in addition to their good balance of mechanical, chemical and electrical properties, makes them well suited for replacing metal and other structural materials. Specialty grades available include glass-filled, low friction/low wear, antistatic and conductive, mineral-coupled, UV stabilized, pigmented, toughened (elastomer modified), and abrasion resistant grades. In 2004, the price of acetal homopolymer ranged approximately from $1.25 to $2.00 per pound at truckload quantities.

General Properties

Acetals exhibit high physical strength, as well as excellent creep and impact resistance. Due to their extremely low water absorption rate, the electrical properties and dimensional stability of acetal resins are minimally affected by atmospheric moisture. The dielectric constant of an acetal resin varies only slightly over a wide frequency range, its dielectric strength is high, and a volume resistivity of 1015 ohm-cm makes it a good electrical insulator. Acetals are resistant to solvents, ethers, oils, greases, gasoline, and other organic compounds, and are especially well suited for use with methanol-based fuels. They are resistant to moderate strength acids, but are not recommended for use with strong acids. Acetal homopolymer is very resistant to wear due to its hard surface and low coefficient of friction (0.1 to 0.3). Acetal homopolymer is UL94 HB rated for flammability, and has continuous service temperatures in the range of 212°F (100°C) to 221°F (105°C).

Typical Properties of Acetal Homopolymer

	American Engineering	SI
Processing Temperature	350°F to 420°F	117°C to 216°C
Linear Mold Shrinkage	0.001 to 0.025 in./in.	0.001 to 0.025 cm/cm
Melting Point	325°F to 355°F	163°C to 179°C
Density	84.3 to 96.1 lb./ft.^{3}	1.35 to 1.54 g/cm^3
Tensile Strength, Yield	6.0 to 10.0 lb./in.^{2} x 10^3	4.2 to 7.0 kg/cm^2 x 10^2
Tensile Strength, Break	5.8 to 10.0 lb./in.^{2} x 10^3	4.2 to 7.0 kg/cm^2 x 10^2
Elongation, Break	5.0 to 80.0%	5.0 to 80.0%
Tensile Modulus	3.0 to 5.0 lb./in.^{2} x 10^5	2.1 to 3.5 kg/cm^2 x 10^4
Flexural Strength, Yield	7.1 to 15.6 lb./in.^{2} x 10^3	5.0 to 11.0 kg/cm^{2}x 10^2
Flexural Modulus	2.2 to 5.7 lb./in.^{2} x 10^5	1.5 to 4.0 kg/cm^2 x 10^4
Compressive Strength	4.5 to 17.6 lb./in.^{2} x 10^3	3.2 to 12.4 kg/cm^{2}x 10^2
Izod Notched, R.T.	0.5 to 2.8 ft.-lb./in.	2.7 to 15.1 kg cm/cm
Hardness	R117 - R120 Rockwell	R117 - R120 Rockwell
Thermal Conductivity	1.6 to 2.5 BTU-in./hr.-ft.^{2}-°F	0.23 to 0.31 W/m-°K
Linear Thermal Expansion	0.5 to 11.0 in./in.-°F x 10^{-5}	0.9 to 19.8 cm/cm-°C x10^{-5}
Deflection Temperature @ 264 psi	195°F to 325°F	91°C to 163°C
Deflection Temperature @ 66 psi	300°F to 345°F	149°C to 174°C
Continuous Service Temperature	212°F to 221°F	100°C to 105°C
Dielectric Strength	380 to 500 V/10^{-3} in.	1.5 to 2.0 V/mm x 10^4
Dielectric Constant @ 1 MHz	3.5 to 4.2	3.5 to 4.2
Dissipation Factor @ 1 MHz	0.001 to 0.009	0.001 to 0.009
Water Absorption, 24 hr.	0.16 to 0.35%	0.16 to 0.35%

Typical Applications

- ***Automotive –*** Fasteners, carburetor floats, knobs, fuel pump housings
- ***Industrial Machinery –*** Valves, conveying equipment, rollers, springs
- ***Plumbing –*** Ballcocks, faucet cartridges, impellers, shower heads, faucet underbodies
- ***Electronic –*** Keytops, switches, buttons
- ***Miscellaneous –*** A/V cassette components, toiletry articles, zippers, bearings, toy parts

ADHESIVE SHEAR STRENGTH (psi) (MPa)

Acetal Homopolymer

	LOCTITE®	UNFILLED RESIN 30 rms	ROUGHENED 47 rms	ANTIOXIDANT 0.2% Irganox 1010	UV STABILIZER 0.2% Tinuvin 328 0.4% Tinuvin 770	IMPACT MODIFIER 30% Estane 5708F1	LUBRICANT 3.88% N,N'-Ethylene Bisstearamide Wax	GLASS FILLER 20% Type 3090 Glass Filler	PTFE FILLER 15% PTFE MP1300	COLORANT 4% 3972 colorant	ANTISTATIC 1.5% Markstat AL12	ACETAL COPOLYMER Celcon courtesy of Hoechst Celanese
Delrin 100 produced by Du Pont Polymers	**Loctite® 380™ Black Max® Instant Adhesive, Rubber Toughened**	100 0.7	150 1.0	100 0.7	100 0.7	100 0.7	100 0.7	100 0.7	100 0.7	100 0.7	150 1.0	50 0.3
	Loctite® 401™ Prism® Instant Adhesive, Surface Insensitive *MEDICAL: Loctite® 4011™ Prism® Instant Adhesive, Surface Insensitive*	200 1.4	600 4.1	400 2.8	900 6.2	350 2.4	350 2.4	1100 7.6	200 1.4	200 1.4	1750 21.1	100 0.7
	Loctite® 401™ Prism® Loctite® 770™ Prism® Primer *MEDICAL: Loctite® 4011™ Prism® / Loctite® 7701™ Prism® Primer*	1700 11.7	1700 11.7	1700 11.7	1700 11.7	1700 11.7	1700 11.7	2800 19.3	1700 11.7	1700 11.7	1700 11.7	300 2.1
	Loctite® 414™ Super Bonder® Instant Adhesive, General Purpose	500 3.5	500 3.5	500 3.5	500 3.5	500 3.5	900 6.2	1100 7.6	100 0.7	500 3.5	1100 7.6	100 0.7
	Loctite® 330™ Depend® Adhesive, Two-Part No-Mix Acrylic	50 0.3	100 0.7	50 0.3	50 0.3	50 0.3	50 0.3	50 0.3	50 0.3	50 0.3	50 0.3	200 1.4
	Loctite® 3105™ Light Cure Adhesive, *MEDICAL: Loctite® 3311™ Light Cure Adhesive*	250 1.7	250 1.7	250 1.7	300 2.1	350 2.4	450 3.1	300 2.1	250 1.7	250 1.7	250 1.7	200 1.4

		UNFILLED RESIN
Delrin 150E produced by DuPont Polymers *23 rms*	**Loctite® 4307™ Flashcure® Light Cure Adhesive**	200 1.4
	Loctite® H3000™ Speedbonder™ Structural Adhesive, General Purpose	200 1.4
	Loctite® H4500™ Speedbonder™ Structural Adhesive, Metal Bonder	150 1.0
	Loctite® 3032™ Adhesive, Polyolefin Bonder	350 2.4
	Loctite® E-00CL™ Hysol® Epoxy Adhesive, Low Odor	250 1.7
	Loctite® E-90FL™ Hysol® Epoxy Adhesive, Flexible	200 1.4
	Loctite® E-30CL™ Hysol® Epoxy Adhesive, Glass Bonder *MEDICAL: Loctite® M-31CL™ Hysol® Epoxy Adhesive, Glass Bonder*	300 2.1
	Loctite® E-20HP™ Hysol® Epoxy Adhesive, Fast Setting *MEDICAL: Loctite® M-21HP™ Hysol® Epoxy Adhesive, Fast Setting*	150 1.0
	Loctite® E-214HP™ Hysol® Epoxy Adhesive, High Strength	1050 7.2
	Loctite® Fixmaster® High Performance Epoxy	150 1.0
	Loctite® 1942™ Hysol® Hot Melt Adhesive, EVA Based	250 1.7
	Loctite® 7804™ Hysol® Hot Melt Adhesive	150 1.0
	Loctite® 3631™ Hysol® Hot Melt Adhesive, Urethane	700 4.8
	Loctite® U-05FL™ Hysol® Urethane Adhesive, High Strength	600 4.1
	Loctite® Fixmaster® Rapid Rubber Repair	250 1.7
	Loctite® 5900® Flange Sealant, Heavy Body RTV Silicone	50 0.3

Adhesive Performance

Loctite® 401™ Prism® Instant Adhesive, when used in conjunction with Loctite® 770™ Prism® Primer, achieved the highest bond strength on all of the acetal formulations that were evaluated. Loctite® E-214HP™ Hysol® Epoxy Adhesive, Loctite® 3631™ Hysol® Hot Melt Adhesive, Loctite® U-05FL™ Hysol® Urethane Adhesive, Loctite® 414™ Super Bonder® Instant Adhesive and Loctite® 3032™ Adhesive achieved the second highest bond strengths. Loctite® 330™ Depend® Adhesive and Loctite® 5900® Flange Sealant achieved the lowest bond strengths on acetal polymers. The addition of an antistatic additive to acetal homopolymer resulted in a large, statistically significant increase in the bond strengths achieved when using Loctite® 401™ Prism®, 4011™ Prism® or 414™ Super Bonder® Instant Adhesives.

Surface Treatments

Surface roughening either caused no effect or a statistically significant increase in bond strength achieved on acetal homopolymer. The use of Loctite® 770™ Prism® Primer, in conjunction with Loctite® 401™ Prism® Instant Adhesive, or Loctite® 4011™ Prism® Medical Device Instant Adhesive with Loctite® 7701™ Prism® Primer, caused a statistically significant increase in the bondability of both acetal homopolymer and copolymer.

Other Important Information

- The surface of acetals tends to be very dry, so an accelerator may be necessary to speed the cure of cyanoacrylates.
- Acetal homopolymers are compatible with all Loctite® brand adhesives, sealants, primers, and activators.
- Surface cleaners: isopropyl alcohol, Loctite® ODC-Free Cleaner & Degreaser.

NOTES:

🟧 The addition of the indicated additive (or surface roughening) caused a statistically significant decrease in the bond strength within 95% confidence limits.

▨ The addition of the indicated additive (or surface roughening) caused a statistically significant increase in the bond strength within 95% confidence limits.

Acrylic (PMMA)

Thermoplastic

7 OTHER

Trade Names	**Manufacturer**
Acrylite	CYRO Industries
Acrylt	Sumitomo Chemical
Diakon	ICI Americas
Modar	ICI Acrylics
Plexiglas	Atofina
Shinkolite	Mitsubishi Rayon
Sumipex	Sumitomo Chemical
Zylar	Novacor Chemicals

General Description

Polymethyl methacrylate, the most common member of the acrylic family, is produced through free radical polymerization of the monomer, which is initiated by a reactive chemical or radiant energy. The monomer is produced when acetone cyanohydrin is heated with methanol in the presence of concentrated sulfuric acid. The optical clarity, rigidity, wide selection of colors and ability to resist sunlight and other environmental stresses, make acrylics ideal for replacing glass in light transmission applications. Specialty grades of acrylic include impact resistant grades and a full range of transparent, translucent and opaque colors. In 2004, the price of acrylics ranged approximately from $1.00 to $1.75 per pound at truckload quantities.

General Properties

A transparency equal to glass and outstanding weatherability are acrylic's most notable properties. Years of testing with sunlight and artificial light sources have resulted in no appreciable yellowing or loss in the physical properties of acrylics. They have good tensile and flexural strength, but even low stresses can cause surface crazing if applied for extended periods of time. Acrylics are more rigid than most thermoplastics, but a large unsupported sheet will deform permanently under a continuous load, even from its own weight. Acrylics are not recommended for high temperature applications, illustrated by their continuous service temperatures of 170°F (76°C) to 190°F (88°C), though annealing can be used to increase this temperature. Acrylics are chemically resistant to many chemicals, however, are attacked by ketones, esters, aromatic and chlorinated hydrocarbons. Although acrylics are combustible, they are widely used in building interiors and lighting fixtures, posing minimal safety hazards provided that the pertinent building codes and applicable Underwriters Laboratories' standards are observed.

Typical Properties of Acrylic (PMMA)

	American Engineering	SI
Processing Temperature	350°F to 570°F	117°C to 299°C
Linear Mold Shrinkage	0.003 to 0.007 in./in.	0.003 to 0.007 cm/cm
Melting Point	266°F	130°C
Density	65.6 to 76.2 lb./ft.^{3}	1.05 to 1.22 g/cm^3
Tensile Strength, Yield	1.5 to 10.5 lb./in.^{2} x 10^3	1.1 to 7.4 kg/cm^2 x 10^2
Tensile Strength, Break	1.3 to 12.8 lb./in.^{2} x 10^3	0.9 to 9.0 kg/cm^2 x 10^2
Elongation, Break	0.5 to 75.0%	0.5 to 75.0%
Tensile Modulus	1.5 to 7.0 lb./in.^{2} x 10^5	1.1 to 4.9 kg/cm^2 x 10^4
Flexural Strength, Yield	1.7 to 3.1 lb./in.^{2} x 10^3	1.2 to 2.2 kg/cm^2 x 10^2
Flexural Modulus	0.1 to 6.2 lb./in.^{2} x 10^5	0 to 4.4 kg/cm^2 x 10^4
Compressive Strength	6.0 to 18.5 lb./in.^{2} x 10^3	4.2 to 13.0 kg/cm^2 x 10^2
Izod Notched, R.T.	0.2 to 2.0 ft.-lb./in.	0.9 to 10.8 kg cm/cm
Hardness	M65 - M100 Rockwell	M65 - M100 Rockwell
Thermal Conductivity	1.3 to 1.5 BTU-in./hr.-ft.^{2}-°F	0.19 to 0.22 W/m-°K
Linear Thermal Expansion	3.3 to 5.6 in./in.-°F x 10^{-5}	5.9 to 10.1 cm/cm-°C x10^{-5}
Deflection Temperature @ 264 psi	150°F to 225°F	66°C to 107°C
Deflection Temperature @ 66 psi	176°F to 217°F	80°C to 103°C
Continuous Service Temperature	170°F to 190°F	77°C to 88°C
Dielectric Strength	260 to 760 V/10^{-3} in.	1.0 to 3.0 V/mm x 10^4
Dielectric Constant @ 1 MHz	2.2 to 3.9	2.2 to 3.9
Dissipation Factor @ 1 MHz	0.025 to 0.045	0.025 to 0.045
Water Absorption, 24 hr.	0.1 to 0.5%	0.1 to 0.5%

Typical Applications

- ***Construction –*** Enclosures for swimming pools and buildings, paneling, break resistant security glazing, tinted sunscreens, domed skylights, lighting fixtures
- ***Automotive –*** Lenses, medallions, nameplates, parts, instrument panels, signals
- ***Household –*** Lavatory and vanity tops, tubs, counters, furniture
- ***Medical –*** IV systems, blood pumps, filters, y-sites, luers
- ***Miscellaneous –*** Display cabinets, appliances, false fingernails, aviation canopies

ADHESIVE SHEAR STRENGTH (psi) (MPa)

Acrylic

Perspex CP80 produced by ICI Acrylics Inc.

LOCTITE®	UNFILLED RESIN 3 rms	ROUGHENED 34 rms	ANTIOXIDANT 0.1% Irganox 245	UV STABILIZER 0.6% Uvinal 3039	FLAME RETARDANT 17% Phoschek P-30	LUBRICANT 55 Witconal NP-330	IMPACT MODIFIER 29% Paraloid EXL 3330	PLASTICIZER 9% Benoflex 50	COLORANT A 1% Omnicolor Pacific Blue	COLORANT B 0.5% 99-41-042 Green	ANTISTATIC 1.5% Markstat AL-48
Loctite® 380™ Black Max® Instant Adhesive, Rubber Toughened	600 4.1	1500 10.3	1400 9.7	1450 10.0	1050 7.2	>3050◆ >21.0◆	1250 8.6	600 4.1	1550 10.7	600 4.1	>2150◆ >14.8◆
Loctite® 401™ Prism® Instant Adhesive, Surface Insensitive *MEDICAL: Loctite® 4011™ Prism® Instant Adhesive, Surface Insensitive*	>3950◆ >27.2◆	2150 14.8	>3950◆ >27.2◆	>3950◆ >27.2◆	>5050◆ >34.8◆	>3950◆ >27.2◆	>3950◆ >27.2◆	>3000◆ >20.7◆	>3350◆ >23.1◆	>2350◆ >16.2◆	>3950◆ >27.2◆
Loctite® 401™ Prism® Loctite® 770™ Prism® Primer *MEDICAL: Loctite® 4011™ Prism® / Loctite® 7701™ Prism® Primer*	250 1.7	400 2.8	350 2.4	250 1.7	>5250◆ >36.2◆	350 2.4	1250 8.6	250 1.7	250 1.7	250 1.7	250 1.7
Loctite® 414™ Super Bonder® Instant Adhesive, General Purpose	>2900◆ >20.0◆	>2900◆ >20.0◆	>2900◆ >20.0◆	>2900◆ >20.0◆	>2900◆ >20.0◆	>4550◆ >31.4◆	2900 20.0	>2900◆ >20.0◆	>2900◆ >20.0◆	>2900◆ >20.0◆	>2900◆ >20.0◆
Loctite® 330™ Depend® Adhesive, Two-Part No-Mix Acrylic	1150 7.9	650 4.5	1150 7.9	1150 7.9	1150 7.9	1150 7.9	650 4.5	1150 7.9	1150 7.9	450 3.1	1150 7.9
Loctite® 3105™ Light Cure Adhesive, *MEDICAL: Loctite® 3311™ Light Cure Adhesive*	1750 12.1	1750 12.1	1750 12.1	1750 12.1	1750 12.1	1250 8.6	1750 12.1	1750 12.1	1350 9.3	1750 12.1	1750 12.1
4307™ Flashcure® Light Cure Adhesive	>4750◆ >32.8◆										
Loctite® H3000™ Speedbonder™ Structural Adhesive, General Purpose	950 6.6										
Loctite® H4500™ Speedbonder™ Structural Adhesive, Metal Bonder	500 3.5										
Loctite® 3032™ Adhesive, Polyolefin Bonder	1750 12.1										
Loctite® E-00CL™ Hysol® Epoxy Adhesive, Low Odor	300 2.1										
Loctite® E-90FL™ Hysol® Epoxy Adhesive, Flexible	1000 6.9										
Loctite® E-30CL™ Hysol® Epoxy Adhesive, Glass Bonder *MEDICAL: Loctite® M-31CL™ Hysol® Epoxy Adhesive, Glass Bonder*	600 4.1										
Loctite® E-20HP™ Hysol® Epoxy Adhesive, Fast Setting *MEDICAL: Loctite® M-21HP™ Hysol® Epoxy Adhesive, Fast Setting*	450 3.1										
Loctite® E-214HP™ Hysol® Epoxy Adhesive, High Strength	NOT TESTED										
Loctite® Fixmaster® High Performance Epoxy	650 4.5										
Loctite® 1942™ Hysol® Hot Melt Adhesive, EVA Based	350 2.4										
Loctite® 7804™ Hysol® Hot Melt Adhesive	15 0.1										
Loctite® 3631™ Hysol® Hot Melt Adhesive, Urethane	1150 7.9										
Loctite® U-05FL™ Hysol® Urethane Adhesive, High Strength	1250 8.6										
Loctite® Fixmaster® Rapid Rubber Repair	850 5.9										
Loctite® 5900® Flange Sealant, Heavy Body RTV Silicone	10 0.1										

Adhesive Performance

Loctite® 401™ Prism® Instant Adhesive, Loctite® 4307™ Flashcure® Light Cure Adhesive and Loctite® 414™ Super Bonder® Instant Adhesive created bonds that were stronger than the acrylic substrate for most of the formulations evaluated. Loctite® 3105™ Light Cure Adhesive, Loctite® 3032™ Adhesive, Loctite® E-90FL™ Hysol® Epoxy Adhesive and Loctite® U-05FL™ Hysol® Urethane Adhesives normally achieved the second highest bond strengths. Loctite® 7804™ Hysol® Hot Melt Adhesive and Loctite® 5900® Flange Sealant achieved the lowest bond strengths on PMMA. When using Loctite® 380™ Black Max® Instant Adhesive, the addition of lubricant or antistatic agents resulted in the bond strengths increasing from average strengths to substrate failure.

Surface Treatments

The use of Loctite® 770™ Prism® Primer, in conjunction with Loctite® 401™ Prism® Instant Adhesive, or Loctite® 4011™ Prism® Medical Device Instant Adhesive with Loctite® 7701™ Prism® Primer, caused a statistically significant decrease in the bond strengths achieved on all the formulations of acrylic which were evaluated, with the exception of the flame retarded formulation. Surface roughening caused a statistically significant increase in bond strengths achieved when using Loctite® 380™ Black Max® Instant Adhesive, but caused either no effect or a statistically significant decrease in bond strength for all the other adhesives evaluated.

Other Important Information

- Acrylics can be stress cracked by uncured cyanoacrylate adhesives, so any excess adhesive should be removed from the surface immediately.
- Acrylics are compatible with acrylic adhesives, but can be attacked by their activators before the adhesive has cured. Any excess activator should be removed from the surface immediately.
- Acrylics are incompatible with anaerobic adhesives.
- Surface cleaners: isopropyl alcohol, Loctite® ODC-Free Cleaner & Degreaser.

NOTES:

◆ The force applied to the tests specimens exceeded the strength of the material resulting in substrate failure before the actual bond strength achieved by the adhesive could be determined.

NOT TESTED:
Substrate melted at adhesive cure temperature.

☐ The addition of the indicated additive (or surface roughening) caused a statistically significant decrease in the bond strength within 95% confidence limits.

☐ The addition of the indicated additive (or surface roughening) caused a statistically significant increase in the bond strength within 95% confidence limits.

Acrylic-Styrene-Acrylonitrile (ASA)

Thermoplastic 7 OTHER

Trade Names	**Manufacturer**
• Centrex	Monsanto Chemical
• Geloy	GE Plastics
• Kibisan	Chi Mei Industrial
• Luran	BASF
• Terblend	BASF

General Description

ASA is an amorphous terpolymer of acrylic, styrene, and acrylonitrile that is produced by mass copolymerization or by grafting styrene-acrylonitrile to the acrylic elastomer backbone. The plastic is known for its toughness, outdoor weatherability, and UV resistance. Specialty grades available include impact resistant, high-gloss, and alloys with PVC and polycarbonate. In 2004, the price of ASA ranged approximately from $1.15 to $2.25 per pound at truckload quantities.

General Properties

The acrylic elastomer in ASA gives the resin its excellent weatherability characteristics, while the styrene imparts the pleasing surface appearance. ASA can have notched Izod impact strength values as high as 20 ft.-lb./in. (108 kg-cm/cm), and a tensile strength as high as 11,400 psi (800 kg/cm^2). ASA is also known for its glossy surface. For example, there are commercially available grades designed for use as capstock in sheet coextrusion processes which have a 60 degree gloss value of 95. With a heat deflection temperature at 264 psi of no more than 225°F (107°C), ASA is not recommended for use in high temperature applications. ASA has good resistance to oils, greases, and salt solutions, but is attacked by ketones, esters, aromatic compounds, chlorinated solvents, and some alcohols.

Typical Properties of Acrylic-Styrene-Acrylonitrile (ASA)

	American Engineering	SI
Processing Temperature	450°F to 520°F	232°C to 271°C
Linear Mold Shrinkage	0.005 to 0.006 in./in.	0.005 to 0.006 cm/cm
Melting Point	–	–
Density	65.6 to 75.5. lb./ft.^{3}	1.05 to 1.21 g/cm^3
Tensile Strength, Yield	4.6 to 7.5 lb./in.^{2} x 10^3	3.2 to 5.3 kg/cm^2 x 10^2
Tensile Strength, Break	5.5 to 11.4 lb./in.^{2} x 10^3	3.9 to 8.0 kg/cm^2 x 10^2
Elongation, Break	3.0 to 70.0%	3.0 to 70.0%
Tensile Modulus	3.0 to 4.0 lb./in.^{2} x 10^5	2.1 to 2.8 kg/cm^2 x 10^4
Flexural Strength, Yield	7.0 to 12.1 lb./in.^{2} x 10^3	4.9 to 8.5 kg/cm^2 x 10^2
Flexural Modulus	2.4 to 5.7 lb./in.^{2} x 10^5	1.7 to 4.0 kg/cm^2 x 10^4
Compressive Strength	–	–
Izod Notched, R.T.	0.3 to 20.0 ft.-lb./in.	1.6 to 108.0 kg cm/cm
Hardness	R85 - R109 Rockwell	R85 - R109 Rockwell
Thermal Conductivity	1.18 BTU-in./hr.-ft.^{2}-°F	0.17 W/m-°K
Linear Thermal Expansion	4.9 to 8.3 in./in.-°F x 10^{-5}	8.8 to 14.9 cm/cm-°C x10^{-5}
Deflection Temperature @ 264 psi	170°F to 225°F	77°C to 107°C
Deflection Temperature @ 66 psi	185°F to 230°F	85°C to 110°C
Continuous Service Temperature	–	–
Dielectric Strength	400 to 500 V/10^{-3} in.	1.6 to 2.0 V/mm x 10^4
Dielectric Constant @ 1 MHz	3.2 to 3.6	3.2 to 3.6
Dissipation Factor @ 1 MHz	0.0004 to 0.019	0.0004 to 0.019
Water Absorption, 24 hr.	0.10 to 0.40%	0.10 to 0.40%

Typical Applications

- ***Automotive –*** Body moldings, bumper parts
- ***Construction –*** Wall fixtures, downspouts, gutters, house siding profiles
- ***Sporting goods –*** Snowmobile and ATV housings, camper tops, windsurfer boards
- ***Miscellaneous –*** Garden hose fittings, telephone handsets, swimming pool steps

ADHESIVE SHEAR STRENGTH (psi) (MPa)

Acrylic-Styrene-Acrylonitrile

	LOCTITE®	UNFILLED RESIN *4 rms*	ROUGHENED *4 rms*	ANTIOXIDANT *0.2% Irganox 245*	UV STABILIZER *0.5% Tinuvin 770* *0.5% Tinuvin P*	FLAME RETARDANT *20% F2016*	IMPACT MODIFIER *9% Paraloid EXL3330*	LUBRICANT *30.3% Mold Wiz INT SP8*	COLORANT *1% Omnicolor Nectarine*	ANTISTATIC *1.5% Dehydat 93P*
Geloy XP1001-100 produced by GE Plastics	**Loctite® 380™ Black Max® Instant Adhesive, Rubber Toughened**	>1650◆ >11.4◆	>1650◆ >11.4◆	>1650◆ >11.4◆	>1300◆ >9.0◆	>1650◆ >11.4◆	>1650◆ >11.4◆	>1650◆ >11.4◆	>1650◆ >11.4◆	>1650◆ >11.4◆
	Loctite® 401™ Prism® Instant Adhesive, Surface Insensitive *MEDICAL: Loctite® 4011™ Prism® Instant Adhesive, Surface Insensitive*	>1750◆ >12.1◆	>1900◆ >13.1◆	>1750◆ >12.1◆	>1750◆ >12.1◆	>1750◆ >12.1◆	>1750◆ >12.1◆	>1750◆ >12.1◆	>1750◆ >12.1◆	>1750◆ >12.1◆
	Loctite® 401™ Prism® Loctite® 770™ Prism® Primer *MEDICAL: Loctite® 4011™ Prism® / Loctite® 7701™ Prism® Primer*	>1750◆ >12.1◆	1150 7.9	>1750◆ >12.1◆	>1750◆ >12.1◆	>1750◆ >12.1◆	>1750◆ >12.1◆	>1750◆ >12.1◆	>1750◆ >12.1◆	>1750◆ >12.1◆
	Loctite® 414™ Super Bonder® Instant Adhesive, General Purpose	>1700◆ >11.7◆	>1850◆ >12.8◆	>1700◆ >11.7◆	>1700◆ >11.7◆	>1700◆ >11.7◆	>1850◆ >12.8◆	>1700◆ >11.7◆	>1700◆ >11.7◆	>1700◆ >11.7◆
	Loctite® 330™ Depend® Adhesive, Two-Part No-Mix Acrylic	950 6.6	700 4.8	950 6.6	950 6.6	650 4.5	950 6.6	950 6.6	950 6.6	950 6.6
	Loctite® 3105™ Light Cure Adhesive, *MEDICAL: Loctite® 3311™ Light Cure Adhesive*	1300 9.0	1300 9.0	1300 9.0	1300 9.0	1300 9.0	1300 9.0	1300 9.0	1300 9.0	1300 9.0
Geloy CR7520-BR7166S courtesy of GE Plastics *2 rms*	**4307™ Flashcure® Light Cure Adhesive**	>3300◆ >22.8								
	Loctite® H3000™ Speedbonder™ Structural Adhesive, General Purpose	1650 11.4								
	Loctite® H4500™ Speedbonder™ Structural Adhesive, Metal Bonder	1800 12.4								
	Loctite® 3032™ Adhesive, Polyolefin Bonder	>2750◆ >19.0◆								
	Loctite® E-00CL™ Hysol® Epoxy Adhesive, Low Odor	400 2.8								
	Loctite® E-90FL™ Hysol® Epoxy Adhesive, Flexible	700 4.8								
	Loctite® E-30CL™ Hysol® Epoxy Adhesive, Glass Bonder *MEDICAL: Loctite® M-31CL™ Hysol® Epoxy Adhesive, Glass Bonder*	750 5.2								
	Loctite® E-20HP™ Hysol® Epoxy Adhesive, Fast Setting *MEDICAL: Loctite® M-21HP™ Hysol® Epoxy Adhesive, Fast Setting*	850 5.9								
	Loctite® E-214HP™ Hysol® Epoxy Adhesive, High Strength	NOT TESTED								
	Loctite® Fixmaster® High Performance Epoxy	900 6.2								
	Loctite® 1942™ Hysol® Hot Melt Adhesive, EVA Based	200 1.4								
	Loctite® 7804™ Hysol® Hot Melt Adhesive	150 1.0								
	Loctite® 3631™ Hysol® Hot Melt Adhesive, Urethane	1900 13.1								
	Loctite® U-05FL™ Hysol® Urethane Adhesive, High Strength	950 6.6								
	Loctite® Fixmaster® Rapid Rubber Repair	400 2.8								
	Loctite® 5900® Flange Sealant, Heavy Body RTV Silicone	100 0.7								

Adhesive Performance

Four of the cyanoacrylates tested, namely Loctite® 380™ Black Max®, 401™ Prism®, 4307™ Loctite® Flashcure® Light Cure Adhesive, and 414™ Super Bonder® Instant Adhesives, as well as Loctite® 3032™ Adhesive, all created bonds which were stronger than the substrate on almost all of the ASA formulations evaluated. Loctite® 3105™ Light Cure Adhesive, Loctite® H3000™ Speedbonder™ Structural Adhesive, Loctite® H4500™ Speedbonder™ Structural Adhesive, Loctite® U-05FL™ Hysol® Urethane Adhesive and Loctite® 3631™ Hysol® Hot Melt Adhesive did not achieve substrate failure, but did perform well on ASA. Loctite® 5900® Flange Sealant achieved the lowest bond strength on ASA.

Surface Treatments

The effect of using Loctite® 770™ Prism® Primer, in conjunction with Loctite® 401™ Prism® Instant Adhesive, or Loctite® 4011™ Prism® Medical Device Instant Adhesive with Loctite® 7701™ Prism® Primer, could not be determined because both primed and unprimed ASA achieved substrate failure for most of the formulations evaluated. Surface roughening had an inconsistent effect on the bondability of ASA.

Other Important Information

- ASA can be stress cracked by uncured cyanoacrylate adhesives, so any excess adhesive should be removed from the surface immediately.
- ASA is compatible with acrylic adhesives, but can be attacked by their activators before the adhesive has cured. Any excess activator should be removed from the surface immediately.
- ASA is incompatible with anaerobic adhesives.
- Surface cleaners: isopropyl alcohol, Loctite® ODC-Free Cleaner & Degreaser.

NOTES:

◆ The force applied to the tests specimens exceeded the strength of the material resulting in substrate failure before the actual bond strength achieved by the adhesive could be determined.

NOT TESTED:
Substrate melted at adhesive cure temperature.

☐ The addition of the indicated additive (or surface roughening) caused a statistically significant decrease in the bond strength within 95% confidence limits.

☐ The addition of the indicated additive (or surface roughening) caused a statistically significant increase in the bond strength within 95% confidence limits.

Acrylonitrile-Butadiene-Styrene (ABS)

Thermoplastic ♹ OTHER

Trade Names	Manufacturer
• Cevian	Hoescht Celanese
• Cycolac	General Electric
• Lustran	Monsanto Chemical
• Magnum	Dow Chemical
• Shinko-Lac	Mitsubishi Rayon
• Taitalac	Taita Chemical Co.
• Toyolac	Toray Industries

General Description

ABS is a generic name for a versatile family of amorphous thermoplastics produced by combining three monomers, acrylonitrile, butadiene, and styrene. The ratio of these monomers, as well as the molecular structure, can be manipulated to optimize the characteristics of the resulting polymer. Acrylonitrile contributes chemical resistance and thermal stability. Butadiene contributes product toughness, impact resistance, and property retention at low temperatures. Styrene contributes rigidity, surface appearance, and processability. The resultant polymer's properties can vary over a large range to suit the manufacturer's needs. For this reason, ABS is widely used in countless applications throughout industry. Specialty grades available include general purpose, glass filled, electroplateable, heat resistant, clear, high and low gloss, structural foam, and flame retardant grades. In 2004, the price of ABS ranged from $1.25 to $3.00 per pound at truckload quantities.

General Properties

ABS offers an excellent combination of toughness and rigidity at a low cost. Typical notched impact strength ranges from 0.5 to 12 ft.-lb./in. (2.7 to 64.8 kg cm/cm), while typical tensile modulii range from 200,000 to 1,200,000 psi (14,000 to 84,000 kg/cm^2). In addition to its toughness, ABS has a high dimensional stability (which permits tight mold tolerances), a pleasing surface appearance, and is very easy to process. ABS is a relatively good electrical insulator and is suitable for secondary insulating applications. ABS is chemically resistant to acids and bases, but is not recommended for use with esters, ketones, or aldehydes. ABS has poor resistance to UV exposure, resulting in significant changes in its appearance and mechanical properties. To address this limitation, there are protective coatings available which enhance ABS's resistance to UV degradation. Some grades of ABS are created by adding a fourth monomer, such as the addition of alpha methyl styrene to create a heat resistant grade. Clear grades are created by adding methyl methacrylate, giving ABS the ability to transmit 75 to 80% of light.

Typical Properties of Acrylonitrile-Butadiene-Styrene (ABS)

	American Engineering	SI
Processing Temperature	400°F to 525°F	204°C to 274°C
Linear Mold Shrinkage	0.002 to 0.007 in./in.	0.002 to 0.007 cm/cm
Melting Point	–	–
Density	63.7 to 79.9 lb./ft.^{3}	1.02 to 1.28 g/cm^3
Tensile Strength, Yield	4.6 to 7.9 lb./in.^{2} x 10^3	3.2 to 5.6 kg/cm^2 x 10^2
Tensile Strength, Break	4.0 to 12.0 lb./in.^{2} x 10^3	2.8 to 8.4 kg/cm^2 x 10^2
Elongation, Break	1.0 to 50.0%	1.0 to 50.0%
Tensile Modulus	2.0 to 12.0 lb./in.^{2} x 10^5	1.4 to 8.4 kg/cm^2 x 10^4
Flexural Strength, Yield	6.2 to 20.0 lb./in.^{2} x 10^3	4.4 to 14.1 kg/cm^{2}x 10^2
Flexural Modulus	2.5 to 4.4 lb./in.^{2} x 10^5	1.8 to 3.1 kg/cm^2 x 10^4
Compressive Strength	6.0 to 17.0 lb./in.^{2} x 10^3	4.2 to 12.0 kg/cm^{2}x 10^2
Izod Notched, R.T.	0.5 to 12.0 ft-lb./in.	2.7 to 64.8 kg cm/cm
Hardness	R95 - R125 Rockwell	R96 - R125 Rockwell
Thermal Conductivity	1.2 to 1.6 BTU-in./hr.-ft.^{2}-°F	0.17 to 0.23 W/m-°K
Linear Thermal Expansion	1.1 to 5.7 in./in.-°F x 10^{-5}	2.0 to 10.3 cm/cm-°C x10^{-5}
Deflection Temperature @ 264 psi	170°F to 240°F	77°C to 116°C
Deflection Temperature @ 66 psi	190°F to 245°F	88°C to 118°C
Continuous Service Temperature	130°F to 180°F	54°C to 82°C
Dielectric Strength	350 to 500 V/10^{-3} in.	1.4 to 2.0 V/mm x 10^4
Dielectric Constant @ 1 MHz	3.1 to 3.4	3.1 to 3.4
Dissipation Factor @ 1 MHz	0.008 to 0.009	0.008 to 0.009
Water Absorption, 24 hr.	0.1 to 0.5%	0.1 to 0.5%

Typical Applications

- ***Medical –*** Piercing pins, clamps, filter casings, stopcocks, check valves, blood dialyzers
- ***Miscellaneous –*** Appliances, business machines, telephones, luggage, power tools, bathtubs, pipe fittings, toys, faucets, shower heads, sporting goods, automotive applications

ADHESIVE SHEAR STRENGTH (psi) (MPa)

Acryonitrile-Butadiene-Styrene

Cyclone GPM 6300 produced by GE Plastics

LOCTITE®	UNFILLED RESIN *3 rms*	ROUGHENED *48 rms*	ANTIOXIDANT *0.1% Irgaphos 168 0.16% Irganox 245 0.04% Irganox 1076*	UV STABILIZER *0.4% UV5411 0.4% UV3346 0.1% Irganox 1076*	FLAME RETARDANT *13.5% DE83R 3% Chlorez 700S 4% 772VHT Sb Oxide*	SMOKE SUPPRESSANT *55 Firebrake ZB Zinc Borate*	LUBRICANT *0.2% N,N'-Ethylene Bisstearamide*	GLASS FILLER *20% Type 3540 Glass Filler*	COLORANT *4% 7526 Colorant*	ANTISTATIC *3% Armostat 550*
Loctite® 380™ Black Max® Instant Adhesive, Rubber Toughened	950 6.6	1400 9.7	950 6.6	950 6.6	950 6.6	650 4.5	950 6.6	950 6.6	950 6.6	>3500◆ >24.1◆
Loctite® 401™ Prism® Instant Adhesive, Surface Insensitive *MEDICAL: Loctite® 4011™ Prism® Instant Adhesive, Surface Insensitive*	>3500◆ >24.1◆	>3500◆ >24.1◆	>3500◆ >24.1◆	>3500◆ >24.1◆	>3500◆ >24.1◆	>3500◆ >24.1◆	>3500◆ >24.1◆	>3500◆ >24.1◆	>3500◆ >24.1◆	>3500◆ >24.1◆
Loctite® 401™ Prism® Loctite® 770™ Prism® Primer *MEDICAL: Loctite® 4011™ Prism® / Loctite® 7701™ Prism® Primer*	>3350† >23.1†	>3350† >23.1†	>3350† >23.1†	>3350† >23.1†	>3350† >23.1†	>3350† >23.1†	>3350† >23.1†	>3350† >23.1†	>3350† >23.1†	>3350† >23.1†
Loctite® 414™ Super Bonder® Instant Adhesive, General Purpose	>3500◆ >24.1◆	>3500◆ >24.1◆	>3500◆ >24.1◆	>3500◆ >24.1◆	>3500◆ >24.1◆	>3500◆ >24.1◆	>3500◆ >24.1◆	>3500◆ >24.1◆	>3500◆ >24.1◆	>3500◆ >24.1◆
Loctite® 330™ Depend® Adhesive, Two-Part No-Mix Acrylic	300 2.1	1300 9.0	150 1.0	300 2.1	300 2.1	300 2.1	300 2.1	300 2.1	300 2.1	300 2.1
Loctite® 3105™ Light Cure Adhesive, *MEDICAL: Loctite® 3311™ Light Cure Adhesive*	>3500† >24.1†	>3500† >24.1†	>3500† >24.1†	>3500† >24.1†	>3500† >24.1†	>3500† >24.1†	>3500† >24.1†	>3500† >24.1†	>3500† >24.1†	>3500† >24.1†
Loctite® 4307™ Flashcure® Light Cure Adhesive	>7650◆ >32.0◆									
Loctite® H3000™ Speedbonder™ Structural Adhesive, General Purpose	1700 11.7									
Loctite® H4500™ Speedbonder™ Structural Adhesive, Metal Bonder	800 5.5									
Loctite® 3032™ Adhesive, Polyolefin Bonder	2000 13.8									
Loctite® E-00CL™ Hysol® Epoxy Adhesive, Low Odor	450 3.1									
Loctite® E-90FL™ Hysol® Epoxy Adhesive, Flexible	3500 24.2									
Loctite® E-30CL™ Hysol® Epoxy Adhesive, Glass Bonder *MEDICAL: Loctite® M-31CL™ Hysol® Epoxy Adhesive, Glass Bonder*	1800 12.4									
Loctite® E-20HP™ Hysol® Epoxy Adhesive, Fast Setting *MEDICAL: Loctite® M-21HP™ Hysol® Epoxy Adhesive, Fast Setting*	2650 18.3									
Loctite® E-214HP™ Hysol® Epoxy Adhesive, High Strength	NOT TESTED									
Loctite® Fixmaster® High Performance Epoxy	850 5.9									
Loctite® 1942™ Hysol® Hot Melt Adhesive, EVA Based	200 1.4									
Loctite® 7804™ Hysol® Hot Melt Adhesive	50 0.3									
Loctite® 3631™ Hysol® Hot Melt Adhesive, Urethane	1950 13.5									
Loctite® U-05FL™ Hysol® Urethane Adhesive, High Strength	600 4.1									
Loctite® Fixmaster® Rapid Rubber Repair	250 1.7									
Loctite® 5900® Flange Sealant, Heavy Body RTV Silicone	200 1.4									

Adhesive Performance

Loctite® 401™ Prism®, 414™ Super Bonder® Instant Adhesives and Loctite® 4307™ Flashcure® and 3105™ Light Cure Adhesives created bonds that were stronger than the ABS substrate. The bond strengths achieved by Loctite® H3000™ and H4500™ Speedbonder™ Structural Adhesives, 3032™ Adhesive, Loctite® E-90FL™ and E-20HP™ Hysol® Epoxy Adhesives, and Loctite® 3631™ Hysol® Hot Melt Adhesive did not achieve substrate failure but performed exceptionally well. However, the addition of an antistatic agent resulted in a large, statistically significant increase in the bond strengths achieved on ABS. Loctite® 1942™ Hysol® and Loctite® 7804™ Hysol® Hot Melt Adhesives consistently achieved the lowest bond strengths.

Surface Treatments

Surface roughening caused a statistically significant increase in the bond strengths achieved when using Loctite® 380™ Black Max® Instant Adhesive and Loctite® 330™ Depend® Adhesive. The effect of surface roughening could not be determined for Loctite® 401™ Prism®, 4011™ Prism®, 414™ Super Bonder® Instant Adhesives, and Loctite® 3105™ and 3311™ Light Cure Adhesives because the bonds created by these adhesives were stronger than the ABS substrate for both the treated and untreated ABS. Likewise, the effect of using Loctite® 770™ Prism® Primer, in conjunction with Loctite® 401™ Prism® Instant Adhesive, or Loctite® 4011™ Prism® Medical Device Instant Adhesive with Loctite® 7701™ Prism® Primer, could not be determined.

Other Important Information

- ABS can be stress cracked by uncured cyanoacrylate adhesives, so any excess adhesive should be removed from the surface immediately.
- ABS is compatible with acrylic adhesives, but can be attacked by their activators before the adhesive has cured. Any excess activator should be removed from the surface immediately.
- ABS is incompatible with anaerobic adhesives.
- Surface cleaners: isopropyl alcohol, Loctite® ODC-Free Cleaner & Degreaser.

NOTES:

◆ The force applied to the tests specimens exceeded the strength of the material resulting in substrate failure before the actual bond strength achieved by the adhesive could be determined.

† Due to the severe deformation of the block shear specimens, testing was stopped before the actual bond strength achieved by the adhesive could be determined (the adhesive bond never failed).

NOT TESTED: Substrate melted at adhesive cure temperature.

☐ The addition of the indicated additive (or surface roughening) caused a statistically significant decrease in the bond strength within 95% confidence limits.

☐ The addition of the indicated additive (or surface roughening) caused a statistically significant increase in the bond strength within 95% confidence limits.

Diallyl Phthalate (DAP, DAIP)

Thermoset 7 OTHER

Trade Names

- Cosmic DAP
- Dapex

Manufacturer

Cosmic Plastics
Rogers Corporation

General Description

Diallyl phthalate (DAP) is the most commonly used of the allylic esters, which are a branch of the polyester family. The backbone of the diallyl phthalate monomer is made of a chain of benzene rings and allyl groups which is formed from a condensation reaction of phthalic anhydride and allyl alcohol. The monomer is then made into a thermoset resin using a peroxide, which may then be further polymerized to create a thermoset plastic using a variety of methods. Specialty grades available include flame retardant, and mineral, glass, and synthetic fiber filled. In 2004, the price of DAP ranged approximately from $2.50 to $6.00 per pound at truckload quantities.

General Properties

Allylic esters are among the most versatile of the thermosetting resins. Allylic resins are chosen for applications that require outstanding dimensional stability, ease of molding, low water absorption, and excellent electrical properties. Diallyl phthalate has a continuous service temperature as high as 500°F (260°C). Diallyl isophthalate, a similar but more expensive resin, may be used if superior dimensional and thermal stability are required. Allylic esters have excellent resistance to aliphatic hydrocarbons, oils, and alcohols, but are not recommended for use with phenols and oxidizing acids.

Typical Properties of Diallyl Phthalate (DAP, DAIP)

	American Engineering	SI
Processing Temperature	250°F to 350°F	121°C to 171°C
Linear Mold Shrinkage	0.002 to 0.008 in./in.	0.002 to 0.008 cm/cm
Melting Point	–	–
Density	87.4 to 137.3 lb./ft.^{3}	1.40 to 2.20 g/cm^3
Tensile Strength, Yield	3.0 to 3.4 lb./in.^{2} x 10^3	2.1 to 2.4 kg/cm^2 x 10^2
Tensile Strength, Break	1.0 to 12.5 lb./in.^{2} x 10^3	0.7 to 8.8 kg/cm^2 x 10^2
Elongation, Break	–	–
Tensile Modulus	13.0 to 20.0 lb./in.^{2} x 10^5	9.1 to 14.1 kg/cm^2 x 10^4
Flexural Strength, Yield	7.3 to 23.0 lb./in.^{2} x 10^3	5.1 to 16.2 kg/cm^{2}x 10^2
Flexural Modulus	6.7 to 26.0 lb./in.^{2} x 10^5	4.7 to 18.3 kg/cm^2 x 10^4
Compressive Strength	21.0 to 32.0 lb./in.^{2} x 10^3	14.8 to 22.5 kg/cm^{2}x 10^2
Izod Notched, R.T.	0.3 to 7.0 ft-lb./in.	1.6 to 37.8 kg cm/cm
Hardness	–	–
Thermal Conductivity	2.1 to 3.3 BTU-in./hr.-ft.^{2}-°F	0.30 to 0.48 W/m-°K
Linear Thermal Expansion	0.3 to 3.5 in./in.-°F x 10^{-5}	0.5 to 6.3 cm/cm-°C x10^{-5}
Deflection Temperature @ 264 psi	250°F to 550°F	121°C to 288°C
Deflection Temperature @ 66 psi	280°F to 600°F	138°C to 316°C
Continuous Service Temperature	300°F to 500°F	149°C to 260°C
Dielectric Strength	330 to 480 V/10^{-3} in.	1.3 to 1.9 V/mm x 10^4
Dielectric Constant @ 1 MHz	3.5 to 4.6	3.5 to 4.6
Dissipation Factor @ 1 MHz	0.010 to 0.180	0.010 to 0.180
Water Absorption, 24 hr.	0.15 to 0.30%	0.15 to 0.30%

Typical Applications

- ***Electrical –*** Connectors, switches, transformer cases, automotive distributor caps, insulators, potentiometers
- ***Miscellaneous –*** Tubing, ducting, radomes, junction boxes, aircraft and missile parts

Diallyl Phthalate

		GRADE RX3-1-525F *Short Glass Fiber Reinforced Flame Retardant Black Coloring, 18 rms*	GRADE RX3-1-525F ROUGHENED *28 rms*	GRADE RX1310 *Short glass Fiber Reinforced, Green Coloring, 16 rms*	GRADE RX1310 ROUGHENED *27 rms*	GRADE RX1-510N *Mineral Filled Blue Coloring, 14 rms*	GRADE RX1-510N ROUGHENED *24 rms*
DAP courtesy of Rogers Corporation	**Loctite® 380™ Black Max® Instant Adhesive, Rubber Toughened**	>1950◆ >13.5◆	>1950◆ >13.5◆	>1700◆ >11.7◆	>1700◆ >11.7◆	>1700◆ >11.7◆	>2550◆ >17.6◆
	Loctite® 401™ Prism® Instant Adhesive, Surface Insensitive *MEDICAL: Loctite® 4011™ Prism® Instant Adhesive, Surface Insensitive*	>3150◆ >21.7◆	>3150◆ >21.7◆	>2350◆ >16.2◆	>2350◆ >16.2◆	>2900◆ >20.0◆	>2900◆ >20.0◆
	Loctite® 401™ Prism® **Loctite® 770™ Prism® Primer** *MEDICAL: Loctite® 4011™ Prism® / Loctite® 7701™ Prism® Primer*	150 1.0	300 2.1	150 1.0	550 3.8	100 0.7	1050 7.2
	Loctite® 414™ Super Bonder® Instant Adhesive, General Purpose	>2700◆ >18.6◆	>2700◆ >18.6◆	>3000◆ >20.7◆	>3000◆ >20.7◆	>2750◆ >19.0◆	>2750◆ >19.0◆
	Loctite® 330™ Depend® Adhesive, Two-Part No-Mix Acrylic	350 2.4	1400 9.7	650 4.5	2150 14.8	500 3.5	2300 15.9
	Loctite® 3105™ Light Cure Adhesive, *MEDICAL: Loctite® 3311™ Light Cure Adhesive*	350 2.4	350 2.4	450 3.1	1450 10.0	300 2.1	1700 11.7
RX3-1-525F-p-M Black courtesy of Byncolit N.A. *11 rms*	**Loctite® 4307™ Flashcure® Light Cure Adhesive**	>2500 >17.2					
	Loctite® H3000™ Speedbonder™ Structural Adhesive, General Purpose	450 3.1					
	Loctite® H4500™ Speedbonder™ Structural Adhesive, Metal Bonder	750 5.2					
	Loctite® 3032™ Adhesive, Polyolefin Bonder	600 4.1					
	Loctite® E-00CL™ Hysol® Epoxy Adhesive, Low Odor	450 3.1					
	Loctite® E-90FL™ Hysol® Epoxy Adhesive, Flexible	1300 9.0					
	Loctite® E-30CL™ Hysol® Epoxy Adhesive, Glass Bonder *MEDICAL: Loctite® M-31CL™ Hysol® Epoxy Adhesive, Glass Bonder*	500 3.5					
	Loctite® E-20HP™ Hysol® Epoxy Adhesive, Fast Setting *MEDICAL: Loctite® M-21HP™ Hysol® Epoxy Adhesive, Fast Setting*	1150 7.9					
	Loctite® E-214HP™ Hysol® Epoxy Adhesive, High Strength	650 4.5					
	Loctite® Fixmaster® High Performance Epoxy	500 3.5					
	Loctite® 1942™ Hysol® Hot Melt Adhesive, EVA Based	400 2.8					
	Loctite® 7804™ Hysol® Hot Melt Adhesive	100 0.7					
	Loctite® 3631™ Hysol® Hot Melt Adhesive, Urethane	950 6.6					
	Loctite® U-05FL™ Hysol® Urethane Adhesive, High Strength	950 6.6					
	Loctite® Fixmaster® Rapid Rubber Repair	400 2.8					
	Loctite® 5900® Flange Sealant, Heavy Body RTV Silicone	200 1.4					

Adhesive Performance

The four cyanoacrylates tested, namely Loctite® 401™ Prism®, 4011™ and 414™ Super Bonder®, 380™ Black Max® Instant Adhesives, and Loctite® 4307™ Flashcure® Light Cure Adhesive, created bonds which were stronger than the three grades of DAP evaluated. Most of the other adhesives evaluated showed fair to excellent bond strengths on DAP. There were not statistically significant differences between the bondability of the three grades of DAP evaluated.

Surface Treatments

The use of Loctite® 770™ Prism® Primer, in conjunction with Loctite® 401™ Prism® Instant Adhesive, or Loctite® 4011™ Prism® Medical Device Instant Adhesive with Loctite® 7701™ Prism® Primer, significantly lowered the bond strengths achieved on DAP. Surface roughening caused a statistically significant increase in bond strength when using Loctite® 330™ Depend® Adhesive and Loctite® 3105™ and 3311™ Light Cure Adhesives. The effect of surface roughening on the bond strengths achieved by cyanoacrylate adhesives could not be determined because both roughened and unroughened DAP bonded with cyanoacrylates resulted in substrate failure.

Other Important Information

- Allylic esters are compatible with all Loctite® brand adhesives, sealants, primers, and activators.
- Surface cleaners: isopropyl alcohol, Loctite® ODC-Free Cleaner & Degreaser.

NOTES:

◆ The force applied to the tests' specimens exceeded the strength of the material, resulting in substrate failure before the actual bond strength achieved by the adhesive could be determined.

☐ The addition of the indicated additive (or surface roughening) caused a statistically significant decrease in the bond strength within 95% confidence limits.

☐ The addition of the indicated additive (or surface roughening) caused a statistically significant increase in the bond strength within 95% confidence limits.

Cellulose Acetate Propionate (CAP)

Thermoplastic 7 OTHER

Trade Names

- Tenite®

Manufacturer

Eastman Chemical Products

General Description

Cellulose is a naturally occurring polymer derived from wood pulp and cotton which is chemically modified to form a cellulosic plastic. The three major families of cellulose are ethyl cellulose, cellulose nitrate, and cellulose esters. The four most commonly used cellulose esters are cellulose acetate (CA), cellulose acetate butyrate (CAB), cellulose acetate propionate (CAP), and cellulose triacetate. Cellulose acetate propionate, one of the most commonly used cellulosic polymers, is manufactured by reacting cellulose with propionic acid and propionic anhydride. Cellulosics are tough, abrasion resistant plastics that have found use in a variety of applications such as films, dice, and eyeglasses. Specialty grades available include plasticized, UV stabilized, flame retardant, and colored. In 2004, the price of CAP ranged approximately from $1.75 to $2.00 per pound at truckload quantities.

General Properties

The main benefits offered by cellulosics are clarity, toughness at low temperatures, abrasion resistance, glossy appearance, resistance to stress cracking, and good electrical insulating properties. Other benefits of cellulosics include a warm, pleasant feel to the touch (due to their low thermal conductivity and specific heat), the availability of formulations which can be used in contact with food, and the ability to be processed by most thermoplastic methods. Generally, plasticizers are added to lower the melt temperature and modify the physical properties. As plasticizer is added, the hardness, stiffness and tensile strength decrease, while the impact strength increases. The solvent resistance of cellulosics varies with type. In general, they are resistant to attack by aliphatic hydrocarbons, bleach, ethylene glycol, salt solutions, and vegetable and mineral oils. However, cellulosics are known to be attacked by alkaline materials and fungus. Cellulosics are further limited by their flammability, low continuous use temperatures, and poor resistance to weathering, although UV resistant grades are available.

Typical Properties of Cellulose Acetate Propionate (CAP)

	American Engineering	SI
Processing Temperature	446°F to 464°F	230°C to 240°C
Linear Mold Shrinkage	0.002 to 0.006 in./in.	0.002 to 0.006 cm/cm
Melting Point	300°F to 400°F	149°C to 204°C
Density	74.9 to 81.2 lb./ft.^{3}	1.20 to 1.30 g/cm^{3}
Tensile Strength, Yield	3.6 to 6.1 lb./in.^{2} x 10^{3}	2.5 to 4.3 kg/cm^{2} x 10^{2}
Tensile Strength, Break	4.5 to 7.1 lb./in.^{2} x 10^{3}	3.2 to 5.0 kg/cm^{2} x 10^{2}
Elongation, Break	34.0 to 50.0%	34.0 to 50.0%
Tensile Modulus	–	–
Flexural Strength, Yield	4.4 to 8.2 lb./in.^{2} x 10^{3}	3.1 to 5.8 kg/cm^{2} x 10^{2}
Flexural Modulus	1.9 to 3.2 lb./in.^{2} x 10^{5}	1.3 to 2.2 kg/cm^{2} x 10^{4}
Compressive Strength	4.4 to 8.1 lb./in.^{2} x 10^{3}	3.1 to 5.8 kg/cm^{2} x 10^{2}
Izod Notched, R.T.	1.2 to 8.3 ft.-lb./in.	6.5 to 44.8 kg cm/cm
Hardness	R75 - R130 Rockwell	R75 - R130 Rockwell
Thermal Conductivity	1.73 to 1.74 BTU-in./hr.-ft.^{2}-°F	0.246 to 0.251 W/m-°K
Linear Thermal Expansion	–	–
Deflection Temperature @ 264 psi	120°F to 200°F	49°C to 93°C
Deflection Temperature @ 66 psi	140°F to 230°F	60°C to 110°C
Continuous Service Temperature	–	–
Dielectric Strength	–	–
Dielectric Constant @ 1 MHz	3.5 to 3.6	3.5 to 3.6
Dissipation Factor @ 1 MHz	0.020 to 0.030	0.020 to 0.030
Water Absorption, 24 hr.	1.3 to 2.4%	1.3 to 2.4%

Typical Applications

- ***Films –*** Photographic film, audio tape, visual aids, greeting cards, photo albums
- ***Miscellaneous –*** Lacquer and cement base, explosives, fashion accessories, flashlight cases, fire extinguisher components, toys, tool handles, electrical appliance housings, eyeglass frames and lenses, lighting fixtures, brush handles

ADHESIVE SHEAR STRENGTH (psi) (MPa)

Cellulose Acetate Propionate

	LOCTITE®	UNFILLED RESIN *3 rms*	ROUGHENED *19 rms*	ANTIOXIDANT *0.15% Irganox 1010*	UV STABILIZER *0.2% Chimasorb 994*	FLAME RETARDANT *17% Reofos 35*	PLASTICIZER *9% Benzoflex 988*	LUBRICANT *0.1% Zinc Stearate*	FILLER #1 *17% 497 Fiberglass*	FILLER #2 *17% Omyacarb F CzCO$_3$*	COLORANT *1% Green*	ANTISTATIC *1.5% Markstat AL-12*
Tenite 375400012 produced by Eastman Performance Products	**Loctite® 380™ Black Max® Instant Adhesive, Rubber Toughened**	400 2.8	400 2.8	400 2.8	400 2.8	250 1.7	250 1.7	250 1.7	400 2.8	650 4.5	400 2.8	1700 11.7
	Loctite® 401™ Prism® Instant Adhesive, Surface Insensitive *MEDICAL: Loctite® 4011™ Prism® Instant Adhesive, Surface Insensitive*	1950 13.5	1950 13.5	1950 13.5	>2450◆ >16.9◆	1350 9.3	1050 7.2	1950 13.5	1950 13.5	>1950† >13.5†	1950 13.5	>2200◆ >15.2◆
	Loctite® 401™ Prism® Loctite® 770™ Prism® Primer *MEDICAL: Loctite® 4011™ Prism® / Loctite® 7701™ Prism® Primer*	2150 14.8	1550 10.7	2150 14.8	2000 13.8	1000 6.9	1200 8.3	2150 14.8	>2200◆ >15.2◆	>2150◆ >14.8◆	2150 14.8	1800 12.4
	Loctite® 414™ Super Bonder® Instant Adhesive, General Purpose	1550 10.7	1550 10.7	1550 10.7	2000 13.8	900 6.2	1150 7.9	750 5.2	1550 10.7	1550 10.7	1550 10.7	>2450◆ >16.9◆
	Loctite® 330™ Depend® Adhesive, Two-Part No-Mix Acrylic	1200 8.3	900 6.2	700 4.8	550 3.8	650 4.5	650 4.5	350 2.4	650 4.5	1200 8.3	850 5.9	400 2.8
	Loctite® 3105™ Light Cure Adhesive, *MEDICAL: Loctite® 3311™ Light Cure Adhesive*	1850 12.8	1850 12.8	1850 12.8	1850 12.8	1300 9.0	1500 10.3	1850 12.8	>1900† >13.1†	>1600† >11.0†	1850 12.8	>2250◆ >15.5◆

Tenite 375E400012 produced by Eastman Performance Products courtesy of Albis Plastics *2 rms*	**Loctite® 4307™ Flashcure® Light Cure Adhesive**	1900 13.1
	Loctite® H3000™ Speedbonder™ Structural Adhesive, General Purpose	550 3.8
	Loctite® H4500™ Speedbonder™ Structural Adhesive, Metal Bonder	600 4.1
	Loctite® 3032™ Adhesive, Polyolefin Bonder	>2000◆ >13.8◆
	Loctite® E-00CL™ Hysol® Epoxy Adhesive, Low Odor	1100 7.6
	Loctite® E-90FL™ Hysol® Epoxy Adhesive, Flexible	400 2.8
	Loctite® E-30CL™ Hysol® Epoxy Adhesive, Glass Bonder *MEDICAL: Loctite® M-31CL™ Hysol® Epoxy Adhesive, Glass Bonder*	1050 7.2
	Loctite® E-20HP™ Hysol® Epoxy Adhesive, Fast Setting *MEDICAL: Loctite® M-21HP™ Hysol® Epoxy Adhesive, Fast Setting*	1550 10.7
	Loctite® E-214HP™ Hysol® Epoxy Adhesive, High Strength	NOT TESTED
	Loctite® Fixmaster® High Performance Epoxy	>3050◆ >21.0◆
	Loctite® 1942™ Hysol® Hot Melt Adhesive, EVA Based	250 1.7
	Loctite® 7804™ Hysol® Hot Melt Adhesive	150 1.0
	Loctite® 3631™ Hysol® Hot Melt Adhesive, Urethane	1950 13.5
	Loctite® U-05FL™ Hysol® Urethane Adhesive, High Strength	1000 6.9
	Loctite® Fixmaster® Rapid Rubber Repair	700 4.8
	Loctite® 5900® Flange Sealant, Heavy Body RTV Silicone	200 1.4

Adhesive Performance

Loctite® 3032™ Adhesive and Loctite® Fixmaster® High Performance Epoxy all created bonds that were stronger than the standard grade of CAP tested. Loctite® 401™ Prism® and 414™ Super Bonder® Instant Adhesives, Loctite® 4307™ Flashcure® and 3105™ Light Cure Adhesives, and Loctite® 3631™ Hysol® Hot Melt Adhesive typically achieved the next highest bond strengths on CAP. Loctite® 330™ Depend® Adhesive, Loctite® E-00CL™, E-30CL™ and and E-20HP™ Hysol® Epoxy Adhesives and Loctite® U-05FL™ Hysol® Urethane Adhesive performed exceptionally as well.

Surface Treatments

Loctite® 770™ Prism® Primer, when used in conjunction with Loctite® 401™ Prism® Instant Adhesive, or Loctite® 4011™ Prism® Instant Adhesive with Loctite® 7701™ Prism® Primer, had no overall statistically significant effect on the formulations of CAP which were evaluated. However, it did cause a statistically significant decrease in bond strengths achieved on the UV stabilized and antistatic formulations, and a statistically significant increase for the glass and calcium carbonate filled formulations. Surface roughening caused either no effect or a statistically significant decrease in the bondability of CAP.

Other Important Information

- Cellulosics can be stress cracked by uncured cyanoacrylate adhesives, so any excess adhesive should be removed from the surface immediately.
- Cellulosics are compatible with acrylic adhesives, but can be attacked by their activators before the adhesive has cured. Any excess activator should be removed from the surface immediately.
- Surface cleaners: isopropyl alcohol, Loctite® ODC-Free Cleaner & Degreaser.

NOTES:

◆ The force applied to the tests' specimens exceeded the strength of the material, resulting in substrate failure before the actual bond strength achieved by the adhesive could be determined.

† Due to the severe deformation of the block shear specimens, testing was stopped before the actual bond strength achieved by the adhesive could be determined (the adhesive bond never failed).

NOT TESTED: Substrate melted at adhesive cure temperature.

☐ The addition of the indicated additive (or surface roughening) caused a statistically significant decrease in the bond strength within 95% confidence limits.

☐ The addition of the indicated additive (or surface roughening) caused a statistically significant increase in the bond strength within 95% confidence limits.

Epoxy

Thermoset ♹ OTHER

Trade Names	Manufacturer
Araldite	Ciba-Geigy Corp.
Conapoxy	Conap, Inc.
Eccogel	Emerson & Cuming
Eccoseal	Emerson & Cuming
Epolite	Hexcel Corp.
EPON	Shell Chemical Co.
Epoxylite	Epoxylite Corp.
Lytex	Premix, Inc.
Maraglas	Acme
Paraplast	Hexcel Corp.
Loctite® Fixmaster® Poxy Pak™	Henkel Corporation
Quatrex	Dow Chemical
Ren	Ciba-Geigy Corp.
Scotchply	3M Industrial Chemicals
Stycast	Emerson & Cuming
Tactix	Dow Chemical

General Description

Epoxies are polymers that have epoxide groups, or oxirane rings, in their molecular structure. They are usually nonmelting thermosetting materials, but linear, high molecular weight thermoplastic epoxies are also available. Thermoset epoxies are usually supplied as one-part frozen premixes or two-part systems. Room temperature curing formulations are available, but heat curing epoxies typically have shorter cure cycles and superior physical properties. Epoxies may utilize many different curing agents including aromatic amines, anhydrides, carboxylic acids, phenol novolacs, and amino resins. The large number of variations possible in the chemical structure and cure mechanism of epoxies, coupled with their ability to be compounded with a wide variety of additives and fillers, has lead to epoxies' use in a vast variety of applications. Epoxies find use as adhesives, coatings, and binding resins in composite structures. Specialty grades available include, but are not limited to, electrically conductive, thermally conductive, fiber reinforced, wear resistant, and machinable grades. In 2004, the price of epoxies ranged approximately from $1.00 to $25.00 per pound at truckload quantities.

General Properties

Due to the vast array of fillers and different types of epoxy resins, the properties of epoxies vary substantially. Epoxies are generally very strong, heat, chemical and and abrasion resistant plastics. Glass fiber reinforced epoxy resins provide excellent strength-to-weight ratios and are used in many high technology applications. Many retain excellent electrical properties in extreme conditions and are used in heavy electrical applications that require long-term outdoor exposure. The excellent abrasion and chemical resistance of epoxy resins has led to their widespread use as flooring, coatings for pipes, and components for chemical scrubbers, as well as in marine applications.

Typical Properties of Epoxy

	American Engineering	SI
Processing Temperature	125°F to 250°F	52°C to 121°C
Linear Mold Shrinkage	0.001 to 0.015 in./in.	0.001 to 0.015 cm/cm
Melting Point	–	–
Density	43.7 to 139.2 lb./ft.^{3}	0.70 to 2.23 g/cm^{3}
Tensile Strength, Yield	5.8 to 10.5 lb./in.^{2} x 10^{3}	4.1 to 7.4 kg/cm^{2} x 10^{2}
Tensile Strength, Break	1.1 to 12.5 lb./in.^{2} x 10^{3}	0.8 to 8.8 kg/cm^{2} x 10^{2}
Elongation, Break	1.1 to 8.5%	1.1 to 8.5%
Tensile Modulus	2.0 to 8.0 lb./in.^{2} x 10^{5}	1.4 to 5.6 kg/cm^{2} x 10^{4}
Flexural Strength, Yield	4.0 to 25.0 lb./in.^{2} x 10^{3}	2.8 to 17.6 kg/cm^{2} x 10^{2}
Flexural Modulus	1.4 to 8.0 lb./in.^{2} x 10^{5}	1.0 to 5.6 kg/cm^{2} x 10^{4}
Compressive Strength	6.8 to 37.0 lb./in.^{2} x 10^{3}	4.8 to 26.0 kg/cm^{2} x 10^{2}
Izod Notched, R.T.	0.3 to No Break ft-lb./in.	1.6 to No Break kg cm/cm
Hardness	D60 - D96 Rockwell	D60 - D96 Rockwell
Thermal Conductivity	0.1 to 4.6 BTU-in./hr.-ft.^{2}-°F	0.014 to 0.663 W/m-°K
Linear Thermal Expansion	1.2 to 11.1 in./in.-°F x 10^{-5}	2.2 to 20.0 cm/cm-°C x10^{-5}
Deflection Temperature @ 264 psi	248°F to 540°F	100°C to 282°C
Deflection Temperature @ 66 psi	–	–
Continuous Service Temperature	200°F to 400°F	93°C to 204°C
Dielectric Strength	300 to 525 V/10^{-3} in.	1.2 to 2.1 V/mm x 10^{4}
Dielectric Constant @ 1 MHz	2.7 to 4.7	2.7 to 4.7
Dissipation Factor @ 1 MHz	0.001 to 0.100	0.001 to 0.100
Water Absorption, 24 hr.	0.10 to 0.70%	0.10 to 0.70%

Epoxies are also well-known for their adhesive abilities, which accounts for much of their use. Most epoxies are resistant to a wide variety of chemicals, including hydrocarbons, esters, bases, and salts. However, epoxies can be attacked by phenols, ketones, ethers, and concentrated acids.

Typical Applications

- ***Coatings –*** Marine coatings, chemical scrubbers, pipes
- ***Electronic –*** Encapsulation and casting of transistors, integrated circuits, switches, coils, insulators, bushings
- ***Miscellaneous –*** Adhesives, solder masks, rocket motor casings, pressure vessels, flooring, highway paving

ADHESIVE SHEAR STRENGTH (psi) (MPa)

Epoxy

Surlyn courtesy of E.I. DuPont

LOCTITE®	G-10 EPOXYGLASS *Mfg. by Westinghouse Corporation* *21 rms*	G-10 ROUGHENED *33 rms*	LOCTITE® FIXMASTER® POXY PAK™ *92 rms*	LOCTITE® FIXMASTER® POXY PAK™ ROUGHENED *167 rms*	LOCTITE® FIXMASTER® FAST CURE EPOXY *116 rms*	LOCTITE® FIXMASTER® FAST CURE EPOXY ROUGHENED *134 rms*
Loctite® 380™ Black Max® Instant Adhesive, Rubber Toughened	3200 22.1	3200 22.1	2100 14.5	3750 25.9	1600 11.0	>1850◆ >12.8◆
Loctite® 401™ Prism® Instant Adhesive, Surface Insensitive *MEDICAL: Loctite® 4011™ Prism® Instant Adhesive, Surface Insensitive*	3350 23.1	2150 14.8	>3200◆ >22.1◆	>3200◆ >22.1◆	1500 10.3	>1900◆ >13.1◆
Loctite® 401™ Prism® Loctite® 770™ Prism® Primer *MEDICAL: Loctite® 4011™ Prism® / Loctite® 7701™ Prism® Primer*	250 1.7	1500 10.3	2850 19.7	>2650◆ >18.3◆	2100 14.5	>1700◆ >11.7◆
Loctite® 414™ Super Bonder® Instant Adhesive, General Purpose	3600 24.8	1800 12.4	2650 18.3	>3750◆ >25.9◆	2750 19.0	>1900◆ >13.1◆
Loctite® 330™ Depend® Adhesive, Two-Part No-Mix Acrylic	1000 6.9	1700 11.7	1000 6.9	>1600◆ >11.0◆	1350 9.3	>1200◆ >8.3◆
Loctite® 3105™ Light Cure Adhesive, *MEDICAL: Loctite® 3311™ Light Cure Adhesive*	1500 10.3	1500 10.3	1550 10.7	1550 10.7	1250 8.6	>2050◆ >14.1◆
Loctite® 4307™ Flashcure® Light Cure Adhesive	>3050◆ >21.0◆					
Loctite® H3000™ Speedbonder™ Structural Adhesive, General Purpose	1700 11.7					
Loctite® H4500™ Speedbonder™ Structural Adhesive, Metal Bonder	750 5.2					
Loctite® 3032™ Adhesive, Polyolefin Bonder	1750 12.1					
Loctite® E-00CL™ Hysol® Epoxy Adhesive, Low Odor	1000 6.9					
Loctite® E-90FL™ Hysol® Epoxy Adhesive, Flexible	950 6.6					
Loctite® E-30CL™ Hysol® Epoxy Adhesive, Glass Bonder *MEDICAL: Loctite® M-31CL™ Hysol® Epoxy Adhesive, Glass Bonder*	>3600◆ >24.8◆					
Loctite® E-20HP™ Hysol® Epoxy Adhesive, Fast Setting *MEDICAL: Loctite® M-21HP™ Hysol® Epoxy Adhesive, Fast Setting*	5600 38.6					
Loctite® E-214HP™ Hysol® Epoxy Adhesive, High Strength	1150 7.9					
Loctite® Fixmaster® High Performance Epoxy	2400 16.6					
Loctite® 1942™ Hysol® Hot Melt Adhesive, EVA Based	250 1.7					
Loctite® 7804™ Hysol® Hot Melt Adhesive	150 1.0					
Loctite® 3631™ Hysol® Hot Melt Adhesive, Urethane	2700 18.6					
Loctite® U-05FL™ Hysol® Urethane Adhesive, High Strength	1550 10.7					
Loctite® Fixmaster® Rapid Rubber Repair	1150 7.9					
Loctite® 5900® Flange Sealant, Heavy Body RTV Silicone	200 1.4					

Adhesive Performance

Loctite® 4307™ Flashcure® Light Cure Adhesive and Loctite® E-30CL™ Hysol® Epoxy Adhesives both achieved bond strengths that were stronger than the grade of epoxy tested. The other cyanoacrylate adhesives evaluated, namely Loctite® 380™ Black Max®, 401™ Prism®, and 414™ Super Bonder® Instant Adhesives, achieved the highest bond strengths on the various types of epoxies tested.

Surface Treatments

Surface roughening usually caused either no effect or a statistically significant increase in the bond strengths achieved on epoxy. The use of Loctite® 770™ Prism® Primer, in conjunction with Loctite® 401™ Prism® Instant Adhesive, or Loctite® 4011™ Prism® Instant Adhesive with Loctite® 7701™ Prism® Primer, caused a significant decrease in the bond strengths achieved for most of the epoxies evaluated.

Other Important Information

- Epoxy is compatible with all Loctite® brand adhesives, sealants, primers, and activators.
- Surface cleaners: isopropyl alcohol, Loctite® ODC-Free Cleaner & Degreaser.

NOTES:

◆ The force applied to the tests' specimens exceeded the strength of the material, resulting in substrate failure before the actual bond strength achieved by the adhesive could be determined.

☐ The addition of the indicated additive (or surface roughening) caused a statistically significant decrease in the bond strength within 95% confidence limits.

☐ The addition of the indicated additive (or surface roughening) caused a statistically significant increase in the bond strength within 95% confidence limits.

Fluoropolymers (PTFE, FEP, PFA, ETFE)

Thermoplastic ♹ OTHER

Trade Names	Manufacturer
Algoflon	Ausimont USA, Inc.
Chemfluor	Norton Performance
Fluon	ICA Americas Inc.
Hostaflon	Hoeschst Celanese
Teflon	E.I. DuPont

General Description

Polytetrafluoroethylene (PTFE) is a highly crystalline thermoplastic which is produced by free radical polymerization of tetrafluoroethylene. The resulting polymer has a linear molecular structure of repeating -CF2-CF2- units. Due to PTFE's excellent chemical resistance, high melting point, low coefficient of friction, and outstanding resistance to flammability, it is usually used in applications which require long-term performance in extreme service environments. Specialty grades available include glass, glass/molysulfide, mica, carbon black, graphite, bronze, and ceramic filled grades. In 2004, the price of PTFE ranged approximately from $9.00 to $30.00 per pound at truckload quantities.

General Properties

Although PTFE's tensile strength, wear resistance, and creep resistance are low in comparison to other engineering thermoplastics, it has excellent impact strength, a coefficient of friction which is lower than almost any other material, a high oxygen index, and it will not support combustion. In addition, PTFE has useful mechanical properties at temperatures ranging from -328°F to 500°F (-200°C to 260°C). It has exceptional chemical resistance to most organic compounds including solvents, strong acids, and strong bases. PTFE is an outstanding electrical insulator, and it has a low dielectric constant and loss factor which are both stable over a wide range of temperatures and frequencies. It has an extremely high melt viscosity, so it cannot be processed by conventional melt extrusion or molding techniques. Methods for processing the resin are similar to those used with some metals and ceramics, such as compression of the powdered resin followed by high temperature sintering. Other fluorinated polymers, such as fluorinated ethylene propylene (FEP), perfluoroalkoxyethylene (PFA), polychlorotrifluoroethylene (PCTFE), and ethylene-tetrafluoroethylene copolymer (ETFE), have properties very similar to PTFE, but they can be processed by the usual thermoplastic methods.

Typical Properties of Polytetrafluoroethylene

	American Engineering	SI
Processing Temperature	–	–
Linear Mold Shrinkage	0.030 to 0.130 in./in.	0.030 to 0.130 cm/cm
Melting Point	620°F to 710°F	327°C to 377°C
Density	112.4 to 150.5 lb./ft.^{3}	1.80 to 2.41 g/cm^3
Tensile Strength, Yield	3.2 to 3.5 lb./in.^{2} x 10^3	2.2 to 2.5 kg/cm^2 x 10^2
Tensile Strength, Break	1.0 to 6.5 lb./in.^{2} x 10^3	0.7 to 4.6 kg/cm^2 x 10^2
Elongation, Break	2.0 to 650.0%	2.0 to 650.0%
Tensile Modulus	0.4 to 2.5 lb./in.^{2} x 10^5	0.3 to 1.8 kg/cm^2 x 10^4
Flexural Strength, Yield	0.9 to 4.7 lb./in.^{2} x 10^3	0.6 to 3.3 kg/cm^2 x 10^2
Flexural Modulus	0.9 to 2.2 lb./in.^{2} x 10^5	0.6 to 1.5 kg/cm^2 x 10^4
Compressive Strength	1.3 to 12.0 lb./in.^{2} x 10^3	0.9 to 8.4 kg/cm^2 x 10^2
Izod Notched, R.T.	3.0 to 4.1 ft.-lb./in.	16.2 to 22.1 kg cm/cm
Hardness	D55 - D75 Rockwell	D55 - D75 Rockwell
Thermal Conductivity	0.7 to 6.4 BTU-in./hr.-ft.^{2}-°F	0.10 to 0.92 W/m-°K
Linear Thermal Expansion	1.0 to 10.3 in./in.-°F x 10^{-5}	1.8 to 18.5 cm/cm-°C x10^{-5}
Deflection Temperature @ 264 psi	130°F to 512°F	54°C to 267°C
Deflection Temperature @ 66 psi	150°F to 550°F	66°C to 288°C
Continuous Service Temperature	475°F to 500°F	246°C to 260°C
Dielectric Strength	600 to 900 V/10^{-3} in.	2.4 to 3.5 V/mm x 10^4
Dielectric Constant @ 1 MHz	2.1 to 2.4	2.1 to 2.4
Dissipation Factor @ 1 MHz	0.0001 to 0.0030	0.0001 to 0.0030
Water Absorption, 24 hr.	0.01 to 0.10%	0.01 to 0.10%

Typical Applications

- ***Electrical –*** High-temperature, high-performance wire and cable insulation, sockets, pins, connectors
- ***Mechanical –*** Bushings, rider rings, seals, bearing pads, valve seats
- ***Nonstick –*** Home cookware, tools, food processing equipment coatings
- ***Miscellaneous –*** Conveyor parts, packaging, flame-retardant laminates, chemical processing equipment

ADHESIVE SHEAR STRENGTH (psi) (MPa)

Polytetrafluoroethylene

		UNFILLED RESIN *88 rms*	ROUGHENED *349 rms*	PTFE TREATED WITH ACTON FLUORO ETCH	PTFE TREATED WITH GORE TETRA ETCH	ETHYLENE TETRAFLUOROETHYLENE COPOLYMER (ETFE)	FLUORINATED ETHYLENE-PROPYLENE (FEP)	POLYPERFLUORO-ALKOXYETHYLENE (PFA)
Teflon courtesy of E.I. DuPont Polymers	**Loctite® 380™ Black Max® Instant Adhesive, Rubber Toughened**	200 1.4	200 1.4	950 6.6	1350 9.3	50 0.3	<50 <0.3	<50 <0.3
	Loctite® 401™ Prism® Instant Adhesive, Surface Insensitive *MEDICAL: Loctite® 4011™ Prism® Instant Adhesive, Surface Insensitive*	350 2.4	350 2.4	1800 12.4	1900 13.1	100 0.7	<50 <0.3	100 0.7
	Loctite® 401™ Prism® Loctite® 770™ Prism® Primer *MEDICAL: Loctite® 4011™ Prism® / Loctite® 7701™ Prism® Primer*	1050 7.2	800 5.5	1550 10.7	1200 8.3	>1650 >11.4	<50 <0.3	400 2.8
	Loctite® 414™ Super Bonder® Instant Adhesive, General Purpose	300 2.1	700 4.8	1750 21.1	1800 12.4	100 0.7	<50 <0.3	50 0.3
	Loctite® 330™ Depend® Adhesive, Two-Part No-Mix Acrylic	100 0.7	250 1.7	450 3.1	350 2.4	50 0.3	<50 <0.3	<50 <0.3
	Loctite® 3105™ Light Cure Adhesive, *MEDICAL: Loctite® 3311™ Light Cure Adhesive*	150 1.0	300 2.1	750 5.2	700 4.8	100 0.7	<50 <0.3	50 0.3
Teflon 9B produced by E.I Dupont Polymers *64 rms*	**Loctite® 4307™ Flashcure® Light Cure Adhesive**	150 1.0						
	Loctite® H3000™ Speedbonder™ Structural Adhesive, General Purpose	50 0.3						
	Loctite® H4500™ Speedbonder™ Structural Adhesive, Metal Bonder	<50 <0.3						
	Loctite® 3032™ Adhesive, Polyolefin Bonder	450 3.1						
	Loctite® E-00CL™ Hysol® Epoxy Adhesive, Low Odor	100 0.7						
	Loctite® E-90FL™ Hysol® Epoxy Adhesive, Flexible	50 0.3						
	Loctite® E-30CL™ Hysol® Epoxy Adhesive, Glass Bonder *MEDICAL: Loctite® M-31CL™ Hysol® Epoxy Adhesive, Glass Bonder*	50 0.3						
	Loctite® E-20HP™ Hysol® Epoxy Adhesive, Fast Setting *MEDICAL: Loctite® M-21HP™ Hysol® Epoxy Adhesive, Fast Setting*	100 0.7						
	Loctite® E-214HP™ Hysol® Epoxy Adhesive, High Strength	50 0.3						
	Loctite® Fixmaster® High Performance Epoxy	50 0.3						
	Loctite® 1942™ Hysol® Hot Melt Adhesive, EVA Based	150 1.0						
	Loctite® 7804™ Hysol® Hot Melt Adhesive	50 0.3						
	Loctite® 3631™ Hysol® Hot Melt Adhesive, Urethane	100 0.7						
	Loctite® U-05FL™ Hysol® Urethane Adhesive, High Strength	<50 <0.3						
	Loctite® Fixmaster® Rapid Rubber Repair	50 0.3						
	Loctite® 5900® Flange Sealant, Heavy Body RTV Silicone	<50 <0.3						

Adhesive Performance

Loctite® 4011™ Prism® Instant Adhesive used in conjunction with Loctite® 770™ Prism® Primer and Loctite® 3032™ Adhesive achieved the highest bond strengths on unetched fluoroplastics. Loctite® 4011™ Prism® and 414™ Super Bonder® Instant Adhesives typically achieved the next highest bond strengths. The bond strengths achieved on the unfilled/untreated resin can generally be described as poor for all other adhesives evaluated.

Surface Treatments

Acton Fluoro Etch and Gore Tetra Etch both caused large, statistically significant increases in the bond strengths achieved on PTFE. Surface roughening caused either no effect or small, statistically significant increase in the bond strengths achieved on PTFE. The use of Loctite® 770™ Prism® Primer in conjunction with Loctite® 4011™ Prism® Instant Adhesive, or Loctite® 4011™ Prism® Medical Device Instant Adhesive with Loctite® 7701™ Prism® Primer, caused a statistically significant increase in the bondability of the unprimed fluoropolymers; however, the effect was most pronounced on the PTFE and ETFE. Neither UV-ozone treatment nor plasma treatment caused an increase in the bondability of PTFE.

Other Important Information

- PTFE and all other fluorinated polymers are compatible with all Loctite® brand adhesives, sealants, primers, and activators.
- Surface cleaners: isopropyl alcohol, Loctite® ODC-Free Cleaner & Degreaser.
- For information on the chemical etchants call:

Acton Technologies, Inc.
100 Thompson Street, P.O. Box 726, Pittston, Pennsylvania 18640 *Phone* 570.654.0612

W.L. Gore & Associates, Inc.
555 Papermill Road, Newark, Delaware 19711 *Phone* 1.888.914.4673 or 410.506.7787

NOTES:

☐ The addition of the indicated additive (or surface roughening) caused a statistically significant decrease in the bond strength within 95% confidence limits.

☐ The addition of the indicated additive (or surface roughening) caused a statistically significant increase in the bond strength within 95% confidence limits.

Ionomer

Thermoplastic ♹ OTHER

Trade Names	**Manufacturer**
Formion	A. Schulman
Surlyn	DuPont

General Description

Ionomers are copolymers of ethylene and meth(acrylic) acid whose physical structure is distinguished by interchain ionic bonding. This bonding takes place between metal cations, such as zinc, sodium, and lithium, and an anion, such as the carboxylate group. Due to the dissociation of the interchain ionic bonding at high temperatures, ionomers can be processed using standard thermoplastic methods. Fillers are not typically used with ionomers, however glass fiber filled grades are available. In 2004 dollars, the price of ionomers ranged approximately from $1.27 to $2.25 per pound at truckload quantities.

General Properties

Properties of the ionomer resins vary with the amount and type of metal cation and the proportion of comonomer. Ionomers containing the zinc cation have better flow, impact strength, tear strength, paint adhesion and lower moisture absorption. Those containing the sodium cation offer lower haze and improved stress crack resistance, while the addition of the lithium cation increases the modulus. The good thermal stability, outstanding chemical resistance, and low moisture vapor transmission of ionomers result from their polyolefin-like structure. However, the interchain ionic crosslinking contributes excellent abrasion, puncture, and impact resistance, as well as low temperature toughness. Moreover, most ionomers have good optical clarity, and the less crystalline grades have superior clarity. Most commercial grades of ionomers comply with FDA regulations for food contact and food packaging which leads to their widespread use in this industry as a film. Ionomers weather poorly, consequently UV absorbers and stabilizers must be used in applications requiring resistance to weathering. Solvent resistance varies with the level of metal cation, but most ionomers are insoluble in common organic solvents at room temperature and resistant to mild acids and bases.

Typical Properties of Ionomer

	American Engineering	SI
Processing Temperature	450°F to 500°F	232°C to 260°C
Linear Mold Shrinkage	0.003 to 0.006 in./in.	0.003 to 0.006 cm/cm
Melting Point	175°F to 205°F	79°C to 96°C
Density	58.7 to 62.4 lb./ft.^{3}	.94 to 1.00 g/cm^3
Tensile Strength, Yield	1.3 to 5.8 lb./in.^{2} x 10^3	0.9 to 4.1 kg/cm^2 x 10^2
Tensile Strength, Break	2.4 to 5.1 lb./in.^{2} x 10^3	1.7 to 3.6 kg/cm^2 x 10^2
Elongation, Break	150 to 520%	150 to 520%
Tensile Modulus	0.1 to 0.5 lb./in.^{2} x 10^5	0.1 to 0.4 kg/cm^2 x 10^4
Flexural Strength, Yield	–	–
Flexural Modulus	0.1 to 2.5 lb./in.^{2} x 10^5	0.1 to 1.8 kg/cm^2 x 10^4
Compressive Strength	–	–
Izod Notched, R.T.	7.0 to No Break ft.-lb./in.	38.7 to No Break kg cm/cm
Hardness	R50 - R68 Rockwell	R50 - R68 Rockwell
Thermal Conductivity	1.6 to 2.1 BTU-in./hr.-ft.^{2}-°F	0.23 to 0.30 W/m-°K
Linear Thermal Expansion	6.1 to 13.0 in./in.-°F x 10^{-5}	11.0 to 23.4 cm/cm-°C x10^{-5}
Deflection Temperature @ 264 psi	85°F to 115°F	29°C to 46°C
Deflection Temperature @ 66 psi	100°F to 180°F	38°C to 82°C
Continuous Service Temperature	93°F to 118°F	34°C to 48°C
Dielectric Strength	400 to 450 V/10^{-3} in.	1.6 to 1.8 V/mm x 10^4
Dielectric Constant @ 1 MHz	–	–
Dissipation Factor @ 1 MHz	0.002 to 0.003	0.002 to 0.003
Water Absorption, 24 hr.	0.01%	0.01%

Typical Applications

- ***Packaging –*** Vacuum packaging of meat, tear-open packages for food and pharmaceutical products, heavy gauge film for electronic products
- ***Sporting goods –*** Golf balls, bowling pins, ice skates, ski boots, wrestling mats
- ***Automotive parts –*** Bumper guards, exterior trim
- ***Miscellaneous –*** Foam to make buoys, thin films for bulletproof glass

Ionomer

Surlym courtesy of E.I. DuPont

LOCTITE®	GRADE 7940 *4 rms*	7940 ROUGHENED *68 rms*	GRADE 8940 *4 rms*	8940 ROUGHENED *68rms*	GRADE 9950 *4 rms*	7940 ROUGHENED *68 rms*
Loctite® 380™ Black Max® Instant Adhesive, Rubber Toughened	200 1.4	>1200† >8.3†	200 1.4	>1200† >8.3†	50 0.3	800 5.5
Loctite® 401™ Prism® Instant Adhesive, Surface Insensitive *MEDICAL: Loctite® 4011™ Prism® Instant Adhesive, Surface Insensitive*	>1200† >8.3†	>1200† >8.3†	>1200† >8.3†	>1200† >8.3†	>1200† >8.3†	>1200† >8.3†
Loctite® 401™ Prism® **Loctite® 770™ Prism® Primer** *MEDICAL: Loctite® 4011™ Prism® / Loctite® 7701™ Prism® Primer*	>1200† >8.3†	>1200† >8.3†	>1200† >8.3†	>1200† >8.3†	>1200† >8.3†	>1200† >8.3†
Loctite® 414™ Super Bonder® Instant Adhesive, General Purpose	>1200† >8.3†	>1200† >8.3†	>1200† >8.3†	>1200† >8.3†	>1200† >8.3†	>1200† >8.3†
Loctite® 330™ Depend® Adhesive, Two-Part No-Mix Acrylic	450 3.1	450 3.1	350 2.4	350 2.4	350 2.4	350 2.4
Loctite® 3105™ Light Cure Adhesive, *MEDICAL: Loctite® 3311™ Light Cure Adhesive*	>1200† >8.3†	>1200† >8.3†	>1200† >8.3†	>1200† >8.3†	>1200† >8.3†	>1200† >8.3†
Loctite® 4307™ Flashcure® Light Cure Adhesive	1350 9.3					
Loctite® H3000™ Speedbonder™ Structural Adhesive, General Purpose	100 0.7					
Loctite® H4500™ Speedbonder™ Structural Adhesive, Metal Bonder	100 0.7					
Loctite® 3032™ Adhesive, Polyolefin Bonder	1650 11.4					
Loctite® E-00CL™ Hysol® Epoxy Adhesive, Low Odor	1750 12.1					
Loctite® E-90FL™ Hysol® Epoxy Adhesive, Flexible	1700 11.7					
Loctite® E-30CL™ Hysol® Epoxy Adhesive, Glass Bonder *MEDICAL: Loctite® M-31CL™ Hysol® Epoxy Adhesive, Glass Bonder*	1500 10.4					
Loctite® E-20HP™ Hysol® Epoxy Adhesive, Fast Setting *MEDICAL: Loctite® M-21HP™ Hysol® Epoxy Adhesive, Fast Setting*	1050 7.2					
Loctite® E-214HP™ Hysol® Epoxy Adhesive, High Strength	NOT TESTED					
Loctite® Fixmaster® High Performance Epoxy	800 5.5					
Loctite® 1942™ Hysol® Hot Melt Adhesive, EVA Based	250 1.7					
Loctite® 7804™ Hysol® Hot Melt Adhesive	200 1.4					
Loctite® 3631™ Hysol® Hot Melt Adhesive, Urethane	650 4.5					
Loctite® U-05FL™ Hysol® Urethane Adhesive, High Strength	1250 8.6					
Loctite® Fixmaster® Rapid Rubber Repair	650 4.5					
Loctite® 5900® Flange Sealant, Heavy Body RTV Silicone	200 1.4					

Adhesive Performance

Loctite® 4011™ Prism® and 414™ Super Bonder® Instant Adhesives and Loctite® 3105™ Light Cure Adhesive all created bonds which were stronger than the ionomer substrate. Loctite® 4307™ Flashcure® Light Cure Adhesive, Loctite® E-00CL™ and E-30CL™ Hysol® Epoxy Adhesives, and Loctite® U-05FL™ Hysol® Urethane Adhesive all achieved bond strengths comparable to the adhesives that achieved substrate failure. Loctite® H3000™ and H4500™ Speedbonder™ Structural Adhesives both achieved the lowest bond strengths. There was no statistically significant difference between the bondability of the three grades of Surlyn evaluated, with the exception of the low bond strengths achieved by Loctite® 380™ Black Max® Instant Adhesive on Surlyn 9950.

Surface Treatments

Surface roughening caused a large, statistically significant increase in the bond strengths achieved by Loctite® 380™ Black Max® Instant Adhesive, but had no statistically significant effect with Loctite® 330™ Depend® Adhesive. The effect of Loctite® 770™ Prism® Primer or Loctite® 7701™ Prism® Primer, and surface roughening with Loctite® 4011™ Prism®, 4011™ Prism® Medical Device and 414™ Super Bonder Instant Adhesives or Loctite® 3105™ and 3311™ Light Cure Adhesives, could not be determined because with all the treated and untreated ionomer, the bonds created were stronger than the ionomer substrate.

Other Important Information

- Ionomers can be stress cracked by uncured cyanoacrylate adhesives, so any excess adhesive should be removed from the surface immediately.
- Surface cleaners: isopropyl alcohol, Loctite® ODC-Free Cleaner & Degreaser.

NOTES:

† Due to the severe deformation of the block shear specimens, testing was stopped before the actual bond strength achieved by the adhesive could be determined (the adhesive bond never failed).

NOT TESTED: Substrate melted at adhesive cure temperature.

☐ The addition of the indicated additive (or surface roughening) caused a statistically significant increase in the bond strength within 95% confidence limits.

Liquid Crystal Polymer (LCP)

Thermoplastic ♹ OTHER

Trade Names	Manufacturer
• Granlar	Granmont Inc.
• HX Series	E.I. DuPont
• Vectra	Hoescht Celanese
• Xydar	Amoco Performance Products

General Description

Liquid crystal polymers (LCP), properly called wholly aromatic copolyesters, can be based on terephthalic acid, p,p-dihydroxybiphenyl, and p-hydroxybenzoic acid. The compounds react to form tightly packed, rigid polymer chains consisting of long, flat monomeric units. LCP's resistance to weathering, radiation, burning, and almost all chemicals, as well as its outstanding strength at extreme temperatures, makes it a suitable replacement for most other engineering materials, including metals and ceramics. Specialty grades available include glass, carbon, and mineral filled, as well as wear resistant, colored, and alloyed. In 2004, the price of LCP ranged approximately from $8.00 to $12.00 per pound at truckload quantities.

General Properties

LCP has outstanding mechanical properties at both ambient and extreme temperatures. For example, LCP can have a tensile modulus as high as 1.20x10^6 psi (8.4x10^4 kg/cm^2) at 575°F (308°C), which exceeds that of most other engineering thermoplastics at room temperature. Grades of LCP have tensile strengths in excess of 20,000 psi (1400 kg/cm^2), a compressive strength of more than 6,000 psi (422 kg/cm^2), and its mechanical properties improve at subzero temperatures. LCP is resistant to virtually all chemicals, including acids, organic hydrocarbons, and boiling water. It is attacked by concentrated, boiling caustics but is unaffected by milder solutions. LCP is also unaffected by ionizing and Cobalt 60 radiation up to 10 billion rads, it withstands high levels of UV radiation, and is transparent to microwaves. It is an electrical insulator with good arc resistance, is UL rated for continuous electrical service at 464°F (240°C), and can be used for applications with intermittent temperatures up to 600°F (316°C). LCP is inherently flame resistant, rated UL94 V-0, and will not sustain combustion. It has remarkable thermal oxidative stability with a decomposition temperature of greater than 1000°F (550°C) in air.

Typical Properties of Liquid Crystal Polymer (LCP)

	American Engineering	SI
Processing Temperature	500°F to 700°F	260°C to 371°C
Linear Mold Shrinkage	0.001 to 0.002 in./in.	0.001 to 0.002 cm/cm
Melting Point	530°F to 670°F	277°C to 354°C
Density	93.0 to 111.7 lb./ft.^{3}	1.49 to 1.79 g/cm^3
Tensile Strength, Yield	21.5 to 30.0 lb./in.^{2} x 10^3	15.1 to 21.1 kg/cm^2 x 10^2
Tensile Strength, Break	9.0 to 30.0 lb./in.^{2} x 10^3	6.3 to 21.1 kg/cm^2 x 10^2
Elongation, Break	1.0 to 3.0%	1.0 to 3.0%
Tensile Modulus	14.6 to 32.0 lb./in.^{2} x 10^5	10.3 to 22.5 kg/cm^2 x 10^4
Flexural Strength, Yield	13.7 to 27.0 lb./in.^{2} x 10^3	9.6 to 26.0 kg/cm^2 x 10^2
Flexural Modulus	13.9 to 23.2 lb./in.^{2} x 10^5	9.8 to 16.3 kg/cm^2 x 10^4
Compressive Strength	6.5 to 11.6 lb./in.^{2} x 10^3	4.6 to 8.2 kg/cm^2 x 10^2
Izod Notched, R.T.	0.7 to 3.1 ft.-lb./in.	3.8 to 16.7 kg cm/cm
Hardness	R95 - R110 Rockwell	R95 - R110 Rockwell
Thermal Conductivity	0.9 to 3.1 BTU-in./hr.-ft.^{2}-°F	0.13 to 0.45 W/m-°K
Linear Thermal Expansion	0.1 to 1.5 in./in.-°F x 10^{-5}	0.2 to 2.7 cm/cm-°C x10^{-5}
Deflection Temperature @ 264 psi	350°F to 660°F	170°C to 349°C
Deflection Temperature @ 66 psi	–	–
Continuous Service Temperature	–	–
Dielectric Strength	550 to 900 V/10^{-3} in	2.2 to 3.5 V/mm x 10^4
Dielectric Constant @ 1 MHz	3.1 to 4.3	3.1 to 4.3
Dissipation Factor @ 1 MHz	0.020 to 0.030	0.020 to 0.030
Water Absorption, 24 hr.	0.01 to 0.10%	0.01 to 0.10%

Typical Applications

- ***Electrical –*** Stator insulation, rotors, boards for motors, burn-in sockets, interface connectors
- ***Heavy Industry –*** Chemical process and oil field equipment

Liquid Crystal Polymer (LCP)

	LOCTITE®	G-540 *40% Glass Reinforced* *58 rms*	G-540 ROUGHENED *63 rms*	G-5930 *30% Glass Reinforced* *106 rms*	G-930 ROUGHENED *113 rms*
Xydar courtesy of Amoco Performance Products	Loctite® 380™ Black Max® Instant Adhesive, Rubber Toughened	500 3.5	1050 7.2	350 2.4	1200 8.3
	Loctite® 401™ Prism® Instant Adhesive, Surface Insensitive *MEDICAL: Loctite® 4011™ Prism® Instant Adhesive, Surface Insensitive*	300 2.1	1100 7.6	300 2.1	1450 10.0
	Loctite® 401™ Prism® Loctite® 770™ Prism® Primer *MEDICAL: Loctite® 4011™ Prism® / Loctite® 7701™ Prism® Primer*	400 2.8	1050 7.2	500 3.5	1550 10.7
	Loctite® 414™ Super Bonder® Instant Adhesive, General Purpose	350 2.4	1100 7.6	350 2.4	1250 8.6
	Loctite® 330™ Depend® Adhesive, Two-Part No-Mix Acrylic	450 3.1	1150 7.9	500 3.5	900 6.2
	Loctite® 3105™ Light Cure Adhesive, *MEDICAL: Loctite® 3311™ Light Cure Adhesive*	650 4.5	650 4.5	500 3.5	500 3.5

Vectra L140D-2 produced by Ticona *111 rms*	Loctite® 4307™ Flashcure® Light Cure Adhesive	750 5.2
	Loctite® H3000™ Speedbonder™ Structural Adhesive, General Purpose	500 3.5
	Loctite® H4500™ Speedbonder™ Structural Adhesive, Metal Bonder	550 3.8
	Loctite® 3032™ Adhesive, Polyolefin Bonder	450 3.1
	Loctite® E-00CL™ Hysol® Epoxy Adhesive, Low Odor	600 4.1
	Loctite® E-90FL™ Hysol® Epoxy Adhesive, Flexible	550 3.8
	Loctite® E-30CL™ Hysol® Epoxy Adhesive, Glass Bonder *MEDICAL: Loctite® M-31CL™ Hysol® Epoxy Adhesive, Glass Bonder*	1000 6.9
	Loctite® E-20HP™ Hysol® Epoxy Adhesive, Fast Setting *MEDICAL: Loctite® M-21HP™ Hysol® Epoxy Adhesive, Fast Setting*	900 6.2
	Loctite® E-214HP™ Hysol® Epoxy Adhesive, High Strength	2100 14.5
	Loctite® Fixmaster® High Performance Epoxy	1050 7.2
	Loctite® 1942™ Hysol® Hot Melt Adhesive, EVA Based	100 0.7
	Loctite® 7804™ Hysol® Hot Melt Adhesive	100 0.7
	Loctite® 3631™ Hysol® Hot Melt Adhesive, Urethane	350 2.4
	Loctite® U-05FL™ Hysol® Urethane Adhesive, High Strength	750 5.2
	Loctite® Fixmaster® Rapid Rubber Repair	450 3.1
	Loctite® 5900® Flange Sealant, Heavy Body RTV Silicone	150 1.0

Adhesive Performance

Loctite® E-30CL™, E-20HP™ and E-214HP™ Hysol® Epoxy Adhesives and Loctite® Fixmaster® High Performance Epoxy all achieved good bond strength on the unfilled LCP resin. All other adhesives achieved moderate to poor bond strengths on LCP.

Surface Treatments

Surface roughening caused a large, statistically significant increase in the bond strengths achieved on LCP for all the adhesives evaluated, except Loctite® 3105™ and 3311™ Light Cure Adhesives, for which surface roughening had no statistically significant effect. Although the process of surface roughening did not result in a significant increase in the surface roughness of the LCP, it removed a surface layer, which resulted in higher bond strengths. The use of Loctite® 770™ Prism® Primer, in conjunction with Loctite® 401™ Prism® Instant Adhesive, or Loctite® 4011™ Prism® Medical Device Instant Adhesive with Loctite® 7701™ Prism® Primer, resulted in no statistically significant change in the bondability of LCP.

Other Important Information

- LCP is compatible with all Loctite® brand adhesives, sealants, primers, and activators.
- Surface cleaners: isopropyl alcohol, Loctite® ODC-Free Cleaner & Degreaser.

NOTES:

☐ The addition of the indicated additive (or surface roughening) caused a statistically significant increase in the bond strength within 95% confidence limits.

Phenolic

Thermoset 7 OTHER

Trade Names / Manufacturer

Trade Names	Manufacturer
Durez	Occidental Chemical
Fiberite FM	ICI/Fiberite
Plaslok	Plaslok Corporation
Plenco	Plastics Engineering Co.
Polychem	Budd Company
Pyrotex	Raymark Friction Co.
Rogers RX	Rogers Corporation
Tecolite	Toshiba Chemical Products

General Description

Phenolic resins are usually produced by reacting phenol and formaldehyde. The resins are then subsequently heat cured to form the highly crystalline, thermosetting phenolic polymer. Due to phenolics' thermoset structure, and high crosslink density, they have outstanding rigidity, dimensional stability, chemical resistance, and thermal stability. The major limitation to using phenolics is that they are difficult to process, requiring heat cure cycles under pressure. In addition, phenolics are only available in dark colors because of the oxidative discoloration which takes place during polymerization. Insulating adhesives, molded items, and the bonding agents used in plywood and waferboard are just some of phenolic's many applications. Specialty grades available include cotton, rope, glass, and mineral filled grades, as well as heat resistant and electric grades. In 2004, the price of phenolic ranged approximately from $0.75 to $2.25 per pound at truckload quantities.

General Properties

Phenolics have moderate strength compared to other plastics, but have higher hardness and greater rigidity than most thermoplastics and many thermosets. Some grades of phenolic are comparable to much more expensive engineering resins, with continuous service temperatures in excess of 400°F (204°C). In addition, the excellent electrical properties of phenolic are maintained at these elevated temperatures. Phenolics have outstanding creep resistance, very low mold shrinkage, and they change size only slightly with changes in temperature. Typical of a thermoset plastic, the chemical resistance of phenolics is excellent. Phenolics are resistant to hydrocarbons, phenols, and ethers, however, are severely attacked by acids and bases. Many grades have excellent flame resistance, and receive UL 94 ratings of HB and V-0.

Typical Properties of Phenolic

	American Engineering	SI
Processing Temperature	230°F to 350°F	110°C to 177°C
Linear Mold Shrinkage	0.002 to 0.009 in./in.	0.002 to 0.009 cm/cm
Melting Point	–	–
Density	83.7 to 99.9 lb./ft.^{3}	1.34 to 1.60 g/cm^3
Tensile Strength, Yield	6.0 to 8.0 lb./in.^{2} x 10^3	4.2 to 5.6 kg/cm^2 x 10^2
Tensile Strength, Break	5.0 to 9.0 lb./in.^{2} x 10^3	3.5 to 6.3 kg/cm^2 x 10^2
Elongation, Break	0.1 to 1.0%	0.1 to 1.0%
Tensile Modulus	10.0 to 16.0 lb./in.^{2} x 10^5	7.0 to 11.2 kg/cm^2 x 10^4
Flexural Strength, Yield	6.5 to 15.0 lb./in.^{2} x 10^3	4.6 to 10.5 kg/cm^{2}x 10^2
Flexural Modulus	8.0 to 17.5 lb./in.^{2} x 10^5	5.6 to 12.3 kg/cm^2 x 10^4
Compressive Strength	23.5 to 34.0 lb./in.^{2} x 10^3	16.5 to 23.9 kg/cm^{2}x 10^2
Izod Notched, R.T.	0.3 to 0.7 ft.-lb./in.	1.4 to 3.8 kg cm/cm
Hardness	M50 - M120 Rockwell	M50 - M120 Rockwell
Thermal Conductivity	3.0 to 10.6 BTU-in./hr.-ft.^{2}-°F	0.43 to 1.47 W/m-°K
Linear Thermal Expansion	1.5 to 3.4 in./in.-°F x 10^{-5}	2.7 to 6.1 cm/cm-°C x10^{-5}
Deflection Temperature @ 264 psi	250°F to 500°F	121°C to 260°C
Deflection Temperature @ 66 psi	–	–
Continuous Service Temperature	350°F to 450°F	177°C to 232°C
Dielectric Strength	200 to 400 V/10^{-3} in	0.8 to 1.6 V/mm x 10^4
Dielectric Constant @ 1 MHz	4.4 to 9.2	4.4 to 9.2
Dissipation Factor @ 1 MHz	0.030 to 0.070	0.030 to 0.070
Water Absorption, 24 hr.	0.03 to 0.8%	0.03 to 0.8%

Typical Applications

- ***Appliances –*** Handles, knobs, bases, end panels
- ***Automotive –*** Brake components, electric motors, rotors, fuse blocks, coil towers, solenoid covers and housings, ignition parts
- ***Electrical –*** Terminal switches and blocks, plugs, receptacles, circuit breakers, light sockets, control housings, high performance connectors and coil bobbins
- ***Miscellaneous –*** Adhesives, commutators, timers, pulleys, cookware handles

Phenolic

Durez courtesy of Occidental Chemical Corporation

LOCTITE®	**GENERAL PURPOSE 25000118** – *Cellulose, Wood Flour, Zinc Stearate and Calcium Stearate filled with Black Pigment*	**25000118 ROUGHENED**	**GLASS FILLED 32245** *Mineral Filled in Addition to General Purpose Ingredients*	**HEAT RESISTANT 152118** *Mineral Filled in Addition to General Purpose Ingredients*	**ELECTRIC GRADE 156122** *Glass, Mineral Filled in Addition to General Purpose Ingredients*	**PLENCO 04300** *Mineral Filled, Heat Resistant courtesy of Plastics Engineering Co.*
Loctite® 380™ Black Max® Instant Adhesive, Rubber Toughened	1600 11.0	1600 11.0	1500 10.3	>1750◆ >12.1◆	>1650◆ >11.4◆	>1900◆ >13.1◆
Loctite® 401™ Prism® Instant Adhesive, Surface Insensitive *MEDICAL: Loctite® 4011™ Prism® Instant Adhesive, Surface Insensitive*	600 4.1	600 4.1	450 3.1	1800 12.4	400 2.8	>1750◆ >12.1◆
Loctite® 401™ Prism® **Loctite® 770™ Prism® Primer** *MEDICAL: Loctite® 4011™ Prism® / Loctite® 7701™ Prism® Primer*	150 1.0	150 1.0	150 1.0	100 0.7	150 1.0	50 0.3
Loctite® 414™ Super Bonder® Instant Adhesive, General Purpose	400 2.8	400 2.8	250 1.7	1800 12.4	400 2.8	>2300◆ >15.9◆
Loctite® 330™ Depend® Adhesive, Two-Part No-Mix Acrylic	900 6.2	900 6.2	850 5.9	500 3.5	600 4.1	>1800◆ >12.4◆
Loctite® 3105™ Light Cure Adhesive, *MEDICAL: Loctite® 3311™ Light Cure Adhesive*	1100 7.6	1450 10.0	600 4.1	1250 8.6	1050 7.2	750 5.2
Loctite® 4307™ Flashcure® Light Cure Adhesive	1000 6.9					
Loctite® H3000™ Speedbonder™ Structural Adhesive, General Purpose	1300 9.0					
Loctite® H4500™ Speedbonder™ Structural Adhesive, Metal Bonder	900 6.2					
Loctite® 3032™ Adhesive, Polyolefin Bonder	1900 13.1					
Loctite® E-00CL™ Hysol® Epoxy Adhesive, Low Odor	1100 7.6					
Loctite® E-90FL™ Hysol® Epoxy Adhesive, Flexible	2550 17.6					
Loctite® E-30CL™ Hysol® Epoxy Adhesive, Glass Bonder *MEDICAL: Loctite® M-31CL™ Hysol® Epoxy Adhesive, Glass Bonder*	>4150◆ >28.6◆					
Loctite® E-20HP™ Hysol® Epoxy Adhesive, Fast Setting *MEDICAL: Loctite® M-21HP™ Hysol® Epoxy Adhesive, Fast Setting*	3200 22.1					
Loctite® E-214HP™ Hysol® Epoxy Adhesive, High Strength	550 3.8					
Loctite® Fixmaster® High Performance Epoxy	>2900◆ >20.0◆					
Loctite® 1942™ Hysol® Hot Melt Adhesive, EVA Based	200 1.4					
Loctite® 7804™ Hysol® Hot Melt Adhesive	150 1.0					
Loctite® 3631™ Hysol® Hot Melt Adhesive, Urethane	1700 11.7					
Loctite® U-05FL™ Hysol® Urethane Adhesive, High Strength	950 6.6					
Loctite® Fixmaster® Rapid Rubber Repair	150 1.0					
Loctite® 5900® Flange Sealant, Heavy Body RTV Silicone	250 1.7					

Adhesive Performance

Loctite® E-30CL™ Hysol® Epoxy Adhesive and Loctite® Fixmaster® High Performance Epoxy both achieved bond strengths that were higher than the grade unfilled phenolic tested. Loctite® 380™ Black Max® Instant Adhesive, Loctite® 3105™ and 4307™ Flashcure® Light Cure Adhesives, Loctite® H3000™ Speedbonder™ Structural Adhesive, Loctite® 3032™ Adhesive, Loctite® E-00CL™, E-90FL™ and E-20HP™ Hysol® Epoxy Adhesives, and Loctite® 3631™ Hysol® Hot Melt Adhesive all achieved the highest bond that did not result in substrate failure. Loctite® 414™ Super Bonder® Instant Adhesive, Loctite® 330™ Depend® Adhesive, Loctite® H4500™ Speedbonder™ Structural Adhesive, Loctite® E-214HP™ Hysol® Epoxy Adhesive, and Loctite® U-05FL™ Hysol® Urethane Adhesive typically achieved lower, but still significant bond strengths.

Surface Treatments

The use of Loctite® 770™ Prism® Primer, in conjunction with Loctite® 401™ Prism® Instant Adhesive, or Loctite® 4011™ Prism® Medical Device Instant Adhesive with Loctite® 7701™ Prism® Primer, caused a statistically significant decrease in the bondability of the various grades of phenolic which were evaluated. Surface roughening caused a statistically significant increase in the bond strengths achieved on phenolics when using Loctite® 3105™ and 3311™ Light Cure Adhesives, but had no significant effect when using any of the other adhesives.

Other Important Information

- Phenolic is compatible with all Loctite® brand adhesives, sealants, primers, and activators.
- Surface cleaners: isopropyl alcohol, Loctite® ODC-Free Cleaner & Degreaser.

NOTES:

◆ The force applied to the tests' specimens exceeded the strength of the material, resulting in substrate failure before the actual bond strength achieved by the adhesive could be determined.

☐ The addition of the indicated additive (or surface roughening) caused a statistically significant increase in the bond strength within 95% confidence limits.

Polyamide

Thermoplastic ♹ OTHER

Trade Names	Manufacturer
• Adell	Adell Plastics, Inc.
• Akulon	DSM Engineering
• Amilan	Toray Industries
• Ashlene	Ashley Polymers
• Capron	Allied-Signal Corporation
• Celstran	Hoescht Celanese
• Minlon	E.I. DuPont
• Nybex	Ferro Corporation
• PA	Bay Resins
• Rilsan	Atochem N.A.
• Ultramid	BASF
• Vestamid	Huls America
• Vydyne	Monsanto Chemical
• Zytel	E.I. DuPont

General Description

Polyamide, commonly called nylon, is a semi-crystalline thermoplastic which is composed of linear aliphatic segments that are connected by amide linkages. Polyamide can be produced either by the polymerization of a lactam and an amino acid or a dibasic acid and a diamine. The wide variety of routes by which nylon can be produced, make it possible to tailor the backbone to meet specific needs. The various types of nylon are identified by number designations which represent the number of carbon atoms in each of the starting materials. For example, nylon 6/6 is made from the 6-carbon hexamethylenediamine and a 6-carbon adipic acid. Specialty grades available include lubricated, plasticized, flame retardant, and glass filled. In 2004, the price of nylon 6 ranged approximately from $2.60 to $16.50 per pound at truckload quantities.

General Properties

All nylons absorb moisture from the atmosphere, and the water that enters their structure causes dimensional changes and acts as a plasticizer. These factors must be taken into account when designing a critical part constructed of polyamide. The plastic is inexpensive and has excellent tensile strength which are reasons for its widespread use as a fiber. Unfilled polyamide is biologically inert, and most grades have been cleared for food contact use by the FDA. Nylons are resistant to many chemicals, including ketones, fully halogenated hydrocarbons, esters, fuels, and brake fluids. Polar solvents tend to be absorbed much like water and strong acids; oxidizing agents and some concentrated salts will attack them. Gradual oxidation occurs in polyamide at elevated temperatures, but short-term exposures can exceed 400°F (200°C). Some heat-stabilized grades have been rated up to 265°F (130°C) for electrical applications, but mechanical application ratings are lower.

Typical Properties of Polyamide

	American Engineering	SI
Processing Temperature	425°F to 545°F	218°C to 285°C
Linear Mold Shrinkage	0.007 to 0.018 in./in.	0.007 to 0.018 cm/cm
Melting Point	420°F to 430°F	216°C to 221°C
Density	68.7 to 73.0 lb./ft.^{3}	1.10 to 1.17 g/cm^3
Tensile Strength, Yield	5.0 to 15.0 lb./in.^{2} x 10^3	3.5 to 10.5 kg/cm^2 x 10^2
Tensile Strength, Break	7.4 to 12.5 lb./in.^{2} x 10^3	5.2 to 8.8 kg/cm^2 x 10^2
Elongation, Break	10 to 300%	10 to 300%
Tensile Modulus	1.0 to 5.0 lb./in.^{2} x 10^5	0.7 to 3.5 kg/cm^2 x 10^4
Flexural Strength, Yield	9.5 to 19.0 lb./in.^{2} x 10^3	6.7 to 13.4 kg/cm^{2}x 10^2
Flexural Modulus	1.2 to 4.9 lb./in.^{2} x 10^5	0.8 to 3.4 kg/cm^2 x 10^4
Compressive Strength	1.2 to 14.2 lb./in.^{2} x 10^3	0.8 to 10.0 kg/cm^{2}x 10^2
Izod Notched, R.T.	0.5 to 2.5 ft.-lb./in.	2.7 to 13.5 kg cm/cm
Hardness	R70 - R120 Rockwell	R70 - R120 Rockwell
Thermal Conductivity	1.2 to 2.0 BTU-in./hr.-ft.^{2}-°F	0.17 to 0.29 W/m-°K
Linear Thermal Expansion	3.9 to 6.0 in./in.-°F x 10^{-5}	7.0 to 10.8 cm/cm-°C x10^{-5}
Deflection Temperature @ 264 psi	110°F to 410°F	43°C to 210°C
Deflection Temperature @ 66 psi	250°F to 420°F	121°C to 216°C
Continuous Service Temperature	175°F to 240°F	79°C to 116°C
Dielectric Strength	300 to 500 V/10^{-3} in.	1.2 to 2.2 V/mm x 10^4
Dielectric Constant @ 1 MHz	3.1 to 4.1	3.1 to 4.1
Dissipation Factor @ 1 MHz	3.1 to 4.1	3.1 to 4.1
Water Absorption, 24 hr.	0.25 to 3.0%	0.25 to 3.0%

Typical Applications

- ***Automotive –*** Electrical connectors, wire jackets, emission canisters, light duty gears, fan blades, brake fluid and power steering reservoirs, valve covers, steering column housings, emission control valves, mirror housings
- ***Electronic –*** Cable ties, plugs, connectors, coil forms, terminals
- ***Consumer goods –*** Ski boots, ice skate supports, racquetball racquets, ballpoint pens
- ***Miscellaneous –*** Oven cooking bags, gun stocks, air conditioner hoses, brush bristles, sutures, fishing line, mallet heads, combs, furniture parts

ADHESIVE SHEAR STRENGTH (psi) (MPa)

Polyamide

Nylon 6-Capron 8202 produced by Allied-Signal

LOCTITE®	UNFILLED RESIN 11 rms	ROUGHENED 15 rms	ANTIOXIDANT 0.35% Irganox B1171	UV STABILIZER 0.63% Chimasorb 944	IMPACT MODIFIER 5% EXL 3607	FLAME RETARDANT 18% PO-64P 44% Antimony Oxide	LUBRICANT #1 0.5% Aluminum Stearate	LUBRICANT #2 0.5% Mold Wiz INT-33PA	GLASS FILLER 30% Type 3450 Glass Fiber	TALC FILLER 30% Mistron CB Talc	PLASTICIZER 4% Ketjen-Flex 8450	ANTISTATIC 5% Larostat HTS 906
Loctite® 380™ Black Max® Instant Adhesive, Rubber Toughened	2450 16.9	2450 16.9	2450 16.9	2450 16.9	>2200◆ >15.2◆	1700 11.7	1450 10.0	2450 16.9	2450 16.9	2450 16.9	3300 22.8	2450 16.9
Loctite® 401™ Prism® Instant Adhesive, Surface Insensitive *MEDICAL: Loctite® 4011™ Prism® Instant Adhesive, Surface Insensitive*	4500 31.0	4500 31.0	4500 31.0	4500 31.0	>4500◆ >31.0◆	4500 31.0	4500 31.0	>4500◆ >31.0◆	>4700◆ >32.4◆	2200 15.2	>4550◆ >31.4◆	>3100◆ >21.4◆
Loctite® 401™ Prism® Loctite® 770™ Prism® Primer *MEDICAL: Loctite® 4011™ Prism® / Loctite® 7701™ Prism® Primer*	1600 11.0	1600 11.0	250 1.7	1600 11.0	>1650◆ >11.4◆	1600 11.0	350 2.4	550 3.8	150 1.0	2100 14.5	650 4.5	350 2.4
Loctite® 414™ Super Bonder® Instant Adhesive, General Purpose	4100 28.3	4100 28.3	4100 28.3	4100 28.3	>4300◆ >29.7◆	4100 28.3	4600 31.7	>3750◆ >25.9◆	>4450◆ >30.7◆	2750 19.0	>4450◆ >30.7◆	>4100◆ >28.3◆
Loctite® 330™ Depend® Adhesive, Two-Part No-Mix Acrylic	450 3.1	450 3.1	450 3.1	450 3.1	450 3.1	450 3.1	450 3.1	450 3.1	450 3.1	450 3.1	450 3.1	450 3.1
Loctite® 3105™ Light Cure Adhesive, *MEDICAL: Loctite® 3311™ Light Cure Adhesive*	1400 9.7	1400 9.7	1400 9.7	1400 9.7	1400 9.7	1400 9.7	1400 9.7	1050 7.2	1400 9.7	1400 9.7	1400 9.7	1400 9.7
Loctite® 4307™ Flashcure® Light Cure Adhesive	>1150◆ >7.9◆											
Loctite® H3000™ Speedbonder™ Structural Adhesive, General Purpose	950 6.6											
Loctite® H4500™ Speedbonder™ Structural Adhesive, Metal Bonder	400 2.8											
Loctite® 3032™ Adhesive, Polyolefin Bonder	550 3.8											
Loctite® E-00CL™ Hysol® Epoxy Adhesive, Low Odor	400 2.8											
Loctite® E-90FL™ Hysol® Epoxy Adhesive, Flexible	600 4.1											
Loctite® E-30CL™ Hysol® Epoxy Adhesive, Glass Bonder *MEDICAL: Loctite® M-31CL™ Hysol® Epoxy Adhesive, Glass Bonder*	800 5.5											
Loctite® E-20HP™ Hysol® Epoxy Adhesive, Fast Setting *MEDICAL: Loctite® M-21HP™ Hysol® Epoxy Adhesive, Fast Setting*	600 4.1											
Loctite® E-214HP™ Hysol® Epoxy Adhesive, High Strength	650 4.1											
Loctite® Fixmaster® High Performance Epoxy	550 3.8											
Loctite® 1942™ Hysol® Hot Melt Adhesive, EVA Based	300 2.1											
Loctite® 7804™ Hysol® Hot Melt Adhesive	200 1.4											
Loctite® 3631™ Hysol® Hot Melt Adhesive, Urethane	1000 6.9											
Loctite® U-05FL™ Hysol® Urethane Adhesive, High Strength	700 4.8											
Loctite® Fixmaster® Rapid Rubber Repair	50 0.3											
Loctite® 5900® Flange Sealant, Heavy Body RTV Silicone	250 1.7											

Adhesive Performance

Loctite® 401™ Prism® and 414™ Super Bonder® Instant Adhesives achieved the highest bond strengths, typically in excess of 4000 psi. Loctite® 380™ Black Max® Instant Adhesive, a rubber toughened adhesive, achieved the second highest bond strengths, followed by Loctite® 3105™ Light Cure Adhesive. Loctite® 4307™ Flashcure® Light Cure Adhesive also achieved a bond strength that resulted in substrate failure. Loctite® Fixmaster® Rapid Rubber Repair achieved the lowest overall bond strength. All other adhesives tested generally achieved good bond strength.

Surface Treatments

The use of Loctite® 770™ Prism® Primer, in conjunction with Loctite® 401™ Prism® Instant Adhesive, or Loctite® 4011™ Prism® Medical Device Instant Adhesive with Loctite® 7701™ Prism® Primer, caused either no effect, or a statistically significant decrease in the bondability of nylon 6, on all of the formulations which were evaluated.

Other Important Information

- Polyamide is compatible with all Loctite® brand adhesives, sealants, primers, and activators.
- Surface cleaners: isopropyl alcohol, Loctite® ODC-Free Cleaner & Degreaser.

NOTES:

◆ The force applied to the tests' specimens exceeded the strength of the material, resulting in substrate failure before the actual bond strength achieved by the adhesive could be determined.

☐ The addition of the indicated additive (or surface roughening) caused a statistically significant decrease in the bond strength within 95% confidence limits.

☐ The addition of the indicated additive (or surface roughening) caused a statistically significant increase in the bond strength within 95% confidence limits.

Polybutylene Terephthalate (PBT)

Thermoplastic 7 OTHER

Trade Names	Manufacturer
Arnite	DSM Engineering
Celanex	Hoescht Celanese
Minlon	E.I. DuPont
Pocan	Albis Corporation
Toray	Toray Industries
Ultradur	BASF
Valox	General Electric
Vybex	Ferro Corporation

General Description

Polybutylene terephthalate (PBT) is a crystalline thermoplastic polyester formed by the catalyzed melt polycondensation of dimethyl terephthalate and 1,4-butanediol. The resulting polymer is known for its good mechanical properties, low moisture absorption, and chemical resistance. Specialty grades available include glass filled, mineral filled, impact resistant, and flame retardant grades. In 2004, the price of PBT ranged approximately from $2.60 to $4.00 per pound at truckload quantities.

General Properties

The most notable properties of PBT are its chemical resistance and mechanical properties. PBT offers good resistance to water, weak acids and bases, ketones, alcohols, glycols, ethers, aliphatic hydrocarbons, and chlorinated aliphatic hydrocarbons at room temperature. At temperatures up to 140°F (60°C), PBT is resistant to transmission fluid, brake fluid, gasoline, and motor oil. It is not recommended for use in strong bases at any temperature, or in aqueous mediums at temperatures above 125°F (52°C). PBT has good tensile strength, high dimensional stability, and a lubricity which makes it very resistant to wear. It has a relatively low heat deflection temperature, but glass filled grades can increase this to over 400°F (204°C). Due to the extremely low water absorption of PBT (0.05% to 0.15%), its dimensional stability and electrical properties are unaffected by high humidity conditions. It has a volume resistivity independent of temperature that exceeds 1016 ohm-cm. In medical applications, PBT is suitable for sterilization with ethylene oxide, but does not have enough heat resistance to be steam sterilized.

Typical Properties of Polybutylene Terephthalate (PBT)

	American Engineering	SI
Processing Temperature	400°F to 500°F	204°C to 274°C
Linear Mold Shrinkage	0.001 to 0.004 in./in.	0.001 to 0.004 cm/cm
Melting Point	430°F to 433°F	221°C to 223°C
Density	62.4 to 81.2 lb./ft.^{3}	1.00 to 1.30 g/cm^3
Tensile Strength, Yield	4.6 to 7.9 lb./in.^{2} x 10^3	3.2 to 5.6 kg/cm^2 x 10^2
Tensile Strength, Break	4.0 to 12.0 lb./in.^{2} x 10^3	2.8 to 8.4 kg/cm^2 x 10^2
Elongation, Break	1.0 to 50.0%	1.0 to 50.0%
Tensile Modulus	2.0 to 12.0 lb./in.^{2} x 10^5	1.4 to 8.4 kg/cm^2 x 10^4
Flexural Strength, Yield	6.2 to 20.0 lb./in.^{2} x 10^3	4.4 to 14.1 kg/cm^{2}x 10^2
Flexural Modulus	2.5 to 4.4 lb./in.^{2} x 10^5	1.8 to 3.1 kg/cm^2 x 10^4
Compressive Strength	6.5 to 17.0 lb./in.^{2} x 10^3	4.6 to 12.0 kg/cm^{2}x 10^2
Izod Notched, R.T.	0.5 to 12.0 ft.-lb./in.	2.7 to 64.8 kg cm/cm
Hardness	R95 - R125 Rockwell	R95 - R125 Rockwell
Thermal Conductivity	1.2 to 1.6 BTU-in./hr.-ft.^{2}-°F	0.17 to 0.23 W/m-°K
Linear Thermal Expansion	1.1 to 5.7 in./in.-°F x 10^{-5}	2.0 to 10.3 cm/cm-°C x10^{-5}
Deflection Temperature @ 264 psi	170°F to 240°F	77°C to 116°C
Deflection Temperature @ 66 psi	190°F to 245°F	88°C to 118°C
Continuous Service Temperature	130°F to 180°F	54°C to 82°C
Dielectric Strength	350 to 500 V/10^{-3} in.	1.4 to 2.0 V/mm x 10^4
Dielectric Constant @ 1 MHz	3.1 to 3.4	3.1 to 3.4
Dissipation Factor @ 1 MHz	0.019 to 0.030	0.019 to 0.030
Water Absorption, 24 hr.	0.03 to 0.50%	0.03 to 0.50%

Typical Applications

- ***Automotive –*** Brake system parts, distributor caps, fuel injection modules, grille opening panels
- ***Electronics –*** Connectors, switches, relays, TV tuners, motor housings, fuse cases, light sockets
- ***Medical –*** Specialty syringes, irrigation and wound drainage systems, check valves, catheter housings
- ***Miscellaneous –*** Industrial zippers, power tool housings, hair dryers, calculators, cooker-fryer handles, iron and toaster housings, food processor blades

ADHESIVE SHEAR STRENGTH (psi) (MPa)

Polybutylene Terephthalate

LOCTITE®	UNFILLED RESIN GRADE 325 *4 rms*	GRADE 325 ROUGHENED *60 rms*	GRADE DR51 *15% Glass Reinforced*	GRADE 420 *30% Glass Reinforced*	GRADE 508 *30% Glass Reinforced Alloy*	GRADE 732E *30% Glass/Mineral Reinforced*	GRADE 735 *40% Glass/Mineral Reinforced*	GRADE 830 *30% Glass Reinforced Alloy*	GRADE 850 *15% Glass Reinforced PBT Alloy*
Loctite® 380™ Black Max® Instant Adhesive, Rubber Toughened	100 0.7	500 3.5	100 0.7	200 1.4	450 3.1	950 6.6	900 6.2	150 1.0	200 1.4
Loctite® 401™ Prism® Instant Adhesive, Surface Insensitive *MEDICAL: Loctite® 4011™ Prism® Instant Adhesive, Surface Insensitive*	250 1.7	950 6.6	400 2.8	300 2.1	2100 14.5	>2650◆ >18.3◆	>2600◆ >17.9◆	600 4.1	400 2.8
Loctite® 401™ Prism® Loctite® 770™ Prism® Primer *MEDICAL: Loctite® 4011™ Prism® / Loctite® 7701™ Prism® Primer*	>3150◆ >21.9◆	1450 10.0	4200 29.0	>4150◆ >28.6◆	3350 23.1	>2900◆ >20.0◆	>2800◆ >19.3◆	>4050◆ >27.9◆	>4400◆ >30.3◆
Loctite® 414™ Super Bonder® Instant Adhesive, General Purpose	250 1.7	2150 14.8	450 3.1	550 3.8	1800 12.4	>2200◆ >15.2◆	>2650◆ >18.3◆	350 2.4	1100 7.6
Loctite® 330™ Depend® Adhesive, Two-Part No-Mix Acrylic	100 0.7	200 1.4	100 0.7	150 1.0	1650 11.4	950 6.6	350 2.4	150 1.0	150 1.0
Loctite® 3105™ Light Cure Adhesive, *MEDICAL: Loctite® 3311™ Light Cure Adhesive*	200 1.4	600 4.1	200 1.4	600 4.1	1250 8.6	1750 12.1	750 5.2	550 3.8	700 4.8
Loctite® 4307™ Flashcure® Light Cure Adhesive	350 2.4								
Loctite® H3000™ Speedbonder™ Structural Adhesive, General Purpose	350 2.4								
Loctite® H4500™ Speedbonder™ Structural Adhesive, Metal Bonder	650 4.5								
Loctite® 3032™ Adhesive, Polyolefin Bonder	1100 7.6								
Loctite® E-00CL™ Hysol® Epoxy Adhesive, Low Odor	550 3.5								
Loctite® E-90FL™ Hysol® Epoxy Adhesive, Flexible	500 3.5								
Loctite® E-30CL™ Hysol® Epoxy Adhesive, Glass Bonder *MEDICAL: Loctite® M-31CL™ Hysol® Epoxy Adhesive, Glass Bonder*	700 4.8								
Loctite® E-20HP™ Hysol® Epoxy Adhesive, Fast Setting *MEDICAL: Loctite® M-21HP™ Hysol® Epoxy Adhesive, Fast Setting*	550 3.8								
Loctite® E-214HP™ Hysol® Epoxy Adhesive, High Strength	1500 10.4								
Loctite® Fixmaster® High Performance Epoxy	500 3.4								
Loctite® 1942™ Hysol® Hot Melt Adhesive, EVA Based	250 1.7								
Loctite® 7804™ Hysol® Hot Melt Adhesive	150 1.0								
Loctite® 3631™ Hysol® Hot Melt Adhesive, Urethane	1400 9.7								
Loctite® U-05FL™ Hysol® Urethane Adhesive, High Strength	1000 6.9								
Loctite® Fixmaster® Rapid Rubber Repair	800 5.5								
Loctite® 5900® Flange Sealant, Heavy Body RTV Silicone	200 1.4								

Valox courtesy of GE Plastics

Adhesive Performance

Loctite® 401™ Prism® Instant Adhesive, used in conjunction with Loctite® 770™ Prism® Primer, achieved the highest bond strengths on all the grades of PBT which were evaluated. Typically, Loctite® 401™ Prism® and 414™ Super Bonder® Instant Adhesives, Loctite® 3032™ Adhesive, Loctite® E-214HP™ Hysol® Epoxy Adhesive, Loctite® U-05FL™ Hysol® Urethane Adhesive, and Loctite® 3631™ Hysol® Hot Melt Adhesive achieved the highest bond strengths, followed by Loctite® H4500™ Speedbonder™ Structural Adhesive, Loctite® E-00CL™, E-90FL™ and E-30CL™ Hysol® Epoxy Adhesives, and Loctite® Fixmaster® High Performance Epoxy and Rapid Rubber Repair. Loctite® 380™ Black Max® Instant Adhesive and Loctite® 330™ Depend® Adhesive achieved the lowest bond strengths on PBT.

Surface Treatments

Surface roughening, plasma treatment, UV-ozone treatment, and the use of Loctite® 770™ or 7701™ Prism® Primers have all proven to cause large, statistically significant increases in the bondability of PBT.

Other Important Information

- Good solvents for PBT are hexafluoroisopropanol, trifluoroacetic acid, o-chlorophenol, and mixtures of phenol with chlorinated aliphatic hydrocarbons.
- PBT is compatible with all Loctite® brand adhesives, sealants, primers, and activators.
- Surface cleaners: isopropyl alcohol, Loctite® ODC-Free Cleaner & Degreaser.

NOTES:

◆ The force applied to the tests' specimens exceeded the strength of the material, resulting in substrate failure before the actual bond strength achieved by the adhesive could be determined.

☐ The addition of the indicated additive (or surface roughening) caused a statistically significant decrease in the bond strength within 95% confidence limits.

☐ The addition of the indicated additive (or surface roughening) caused a statistically significant increase in the bond strength within 95% confidence limits.

Polycarbonate (PC)

Thermoplastic ♹ OTHER

Trade Names	Manufacturer
• Calibre	Dow Chemical
• Karlex	Ferro Corporation
• Lexan	General Electric
• Makrolon	Miles Inc.
• Novarex	Mitsubishi Chemical
• Panlite	Teijin Chem Ltd.
• Sinvet	Enichem Elastomers

General Description

In the polycarbonate resin, carbonate groups are used to link groups of dihydric or polyhydric phenols. General-purpose polycarbonate is formed by reacting bisphenol A with phosgene, but formulations using other polyhydric phenols are available. These include specialty resins which meet industry codes for flame retardance and smoke density, and resins with increased melt strength for extrusion and blow molding. Polycarbonate is a versatile and popular blend material for polyester and ABS, and is widely used in the medical device industry as a replacement for glass. Additives and coatings are commonly used and can greatly improve creep resistance, mold shrinkage, tensile modulus, thermal stability, weatherability, and all strength characteristics of standard polycarbonate. In 2004, the price of PC ranged approximately from $2.00 to $5.00 per pound at truckload quantities.

General Properties

Polycarbonate offers a unique combination of outstanding clarity and high impact strength. In addition, it is very dimensionally stable and has low flammability. These characteristics make polycarbonate well suited for light transmission applications, such as automotive tail light housings. Due to the low levels of monomers and catalysts used in processing polycarbonate, it is generally biocompatible and suited for use in medical applications where device surfaces may come into contact with blood or other bodily fluids. PC offers a limited resistance to chemicals and is soluble in many organic solvents. Solvent welding or adhesively joining parts makes PC prone to stress cracking. This can be overcome by selecting an adhesive with a rapid cure mechanism, an adhesive with a low tendency to induce stress cracking, and/or annealing the part prior to adhesive application.

Typical Properties of Polycarbonate (PC)

	American Engineering	SI
Processing Temperature	500°F to 575°F	260°C to 302°C
Linear Mold Shrinkage	0.003 to 0.007 in./in.	0.003 to 0.007 cm/cm
Melting Point	–	–
Density	70.5 to 80.5 lb./ft.^{3}	1.13 to 1.29 g/cm^3
Tensile Strength, Yield	8.4 to 9.6 lb./in.^{2} x 10^3	5.9 to 6.7 kg/cm^2 x 10^2
Tensile Strength, Break	7.4 to 10.9 lb./in.^{2} x 10^3	5.2 to 7.7 kg/cm^2 x 10^2
Elongation, Break	97.0 to 136.0%	97.0 to 136.0%
Tensile Modulus	3.1 to 3.5 lb./in.^{2} x 10^5	2.2 to 2.5 kg/cm^2 x 10^4
Flexural Strength, Yield	12.4 to 14.0 lb./in.^{2} x 10^3	8.7 to 9.8 kg/cm^2 x 10^2
Flexural Modulus	3.2 to 3.5 lb./in.^{2} x 10^5	2.2 to 2.5 kg/cm^2 x 10^4
Compressive Strength	9.9 to 11.1 lb./in.^{2} x 10^3	7.0 to 7.8 kg/cm^2 x 10^2
Izod Notched, R.T.	11.3 to 17.0 ft.-lb./in.	60.8 to 91.8 kg cm/cm
Hardness	R120 - R125 Rockwell	R120 - R125 Rockwell
Thermal Conductivity	1.3 to 1.6 BTU-in./hr.-ft.^{2}-°F	0.19 to 0.23 W/m-°K
Linear Thermal Expansion	2.9 to 3.9 in./in.-°F x 10^{-5}	2.2 to 7.0 cm/cm-°C x10^{-5}
Deflection Temperature @ 264 psi	200°F to 350°F	98°C to 177°C
Deflection Temperature @ 66 psi	280°F to 350°F	138°C to 177°C
Continuous Service Temperature	240°F to 275°F	116°C to 135°C
Dielectric Strength	375 to 500 V/10^{-3} in.	1.5 to 2.0 V/mm x 10^4
Dielectric Constant @ 1 MHz	2.7 to 3.2	2.7 to 3.2
Dissipation Factor @ 1 MHz	0.009 to 0.010	0.009 to 0.010
Water Absorption, 24 hr.	0.1 to 0.3%	0.1 to 0.3%

Typical Applications

- ***Packaging –*** Reusable bottles, frozen foods, large water bottles
- ***Food Service –*** Beverage pitchers, mugs, food processor bowls, tableware, microwave cookware
- ***Automotive –*** Lamp housings and lenses, parts, electrical components, instrument panels
- ***Medical –*** Filter housings, tubing connectors, surgical staplers, eyewear
- ***Miscellaneous –*** Bulletproofing, computer housings, aircraft interiors

ADHESIVE SHEAR STRENGTH (psi) (MPa)

Polycarbonate

Calibre 300-4 produced by Dow Chemical

LOCTITE®	**UNFILLED RESIN** *4 rms*	**ROUGHENED** *18 rms*	**ANTIOXIDANT** *0.1% Irgafos 168 0.1% Irgafos 1076*	**UV STABILIZER** *0.4% Tinuvin 234*	**FLAME RETARDANT** *2% BT-93 1% Antimony Oxide*	**IMPACT MODIFIER** *5% Paraloid EXL3607*	**LUBRICANT** *0.3% Mold Wiz INT-33UDK*	**GLASS FILLER** *23% Type 3090 Glass Filler*	**COLORANT** *4% CPC07327*
Loctite® 380™ Black Max® Instant Adhesive, Rubber Toughened	750 5.2	1600 11.0	750 5.2	750 5.2	1300 9.0	1000 6.9	1300 9.0	1150 7.9	1650 11.4
Loctite® 401™ Prism® Instant Adhesive, Surface Insensitive *MEDICAL: Loctite® 4011™ Prism® Instant Adhesive, Surface Insensitive*	3850 26.6	4500 31.0	3850 26.6	3850 26.6	>4100◆ >28.3◆	3850 26.6	3850 26.6	3850 26.6	3850 26.6
Loctite® 401™ Prism® **Loctite® 770™ Prism® Primer** *MEDICAL: Loctite® 4011™ Prism® / Loctite® 7701™ Prism® Primer*	2000 13.8	3400 23.5	2000 13.8	2000 13.8	>3800◆ >26.2◆	2000 13.8	2000 13.8	600 4.1	500 3.5
Loctite® 414™ Super Bonder® Instant Adhesive, General Purpose	1600 11.0	3950 27.2	3950 27.2	1600 11.0	>3400◆ >23.5◆	>4500◆ >31.0◆	3850 26.6	2700 18.8	3950 27.2
Loctite® 330™ Depend® Adhesive, Two-Part No-Mix Acrylic	1100 7.6	1100 7.6	550 3.8	450 3.1	300 2.1	500 3.5	1100 7.6	1100 7.6	1100 7.6
Loctite® 3105™ Light Cure Adhesive, *MEDICAL: Loctite® 3311™ Light Cure Adhesive*	3700 25.5	4550 31.4	3700 25.5	3700 25.5	3700 25.5	3700 25.5	3700 25.5	4850 33.5	3700 25.5
Loctite® 4307™ Flashcure® Light Cure Adhesive	>4250◆ >29.3◆								
Loctite® H3000™ Speedbonder™ Structural Adhesive, General Purpose	1250 8.6								
Loctite® H4500™ Speedbonder™ Structural Adhesive, Metal Bonder	1100 7.6								
Loctite® 3032™ Adhesive, Polyolefin Bonder	850 5.9								
Loctite® E-00CL™ Hysol® Epoxy Adhesive, Low Odor	900 6.2								
Loctite® E-90FL™ Hysol® Epoxy Adhesive, Flexible	1150 7.9								
Loctite® E-30CL™ Hysol® Epoxy Adhesive, Glass Bonder *MEDICAL: Loctite® M-31CL™ Hysol® Epoxy Adhesive, Glass Bonder*	2650 18.3								
Loctite® E-20HP™ Hysol® Epoxy Adhesive, Fast Setting *MEDICAL: Loctite® M-21HP™ Hysol® Epoxy Adhesive, Fast Setting*	1200 8.3								
Loctite® E-214HP™ Hysol® Epoxy Adhesive, High Strength	1200 8.3								
Loctite® Fixmaster® High Performance Epoxy	2450 16.9								
Loctite® 1942™ Hysol® Hot Melt Adhesive, EVA Based	350 2.4								
Loctite® 7804™ Hysol® Hot Melt Adhesive	100 0.7								
Loctite® 3631™ Hysol® Hot Melt Adhesive, Urethane	3200 22.1								
Loctite® U-05FL™ Hysol® Urethane Adhesive, High Strength	850 5.9								
Loctite® Fixmaster® Rapid Rubber Repair	600 4.1								
Loctite® 5900® Flange Sealant, Heavy Body RTV Silicone	200 1.4								

Adhesive Performance

Loctite® 4307™ Flashcure® Light Cure Adhesive achieved bond strengths which were higher than the grade of unfilled polycarbonate tested. Loctite® 401™ Prism® and 414™ Super Bonder® Instant Adhesives, Loctite® 3105™ Light Cure Adhesive, and Loctite® E-30CL™ Hysol® Epoxy Adhesive, Loctite® 3631™ Hysol® Hot Melt Adhesive, and Loctite® Fixmaster® High Performance Epoxy all achieved very high bond strengths on PC. Loctite® 7804™ Hysol® Hot Melt Adhesive achieved the lowest bond strength.

Surface Treatments

Surface roughening either caused no effect or a statistically significant increase in the bondability of PC. The use of Loctite® 770™ Prism® Primer, in conjunction with Loctite® 401™ Prism® Instant Adhesive, or Loctite® 4011™ Prism® Medical Device Instant Adhesive with Loctite® 7701™ Prism® Primer, caused a statistically significant decrease in the bond strengths achieved on PC for most of the formulations evaluated.

Other Important Information

- Polycarbonate is generally compatible with acrylic and cyanoacrylate adhesives, but there is a potential for stress cracking. In addition, polycarbonate can be attacked by the activators for two-part, no-mix acrylic adhesives before the adhesive has cured. Any excess activator should be removed from the surface of the polycarbonate immediately.
- Polycarbonate is incompatible with anaerobic adhesives.
- Surface cleaners: isopropyl alcohol, Loctite® ODC-Free Cleaner & Degreaser.

NOTES:

◆ The force applied to the tests' specimens exceeded the strength of the material, resulting in substrate failure before the actual bond strength achieved by the adhesive could be determined.

☐ The addition of the indicated additive (or surface roughening) caused a statistically significant decrease in the bond strength within 95% confidence limits.

☐ The addition of the indicated additive (or surface roughening) caused a statistically significant increase in the bond strength within 95% confidence limits.

Polyester

Thermoset ♹ OTHER

Trade Names	Manufacturer
• Aropol	Ashland Chemical Company
• Dielectrite	Industrial Dielectric
• Durez	Occidental Chemical Company
• Polylite	Reichhold Chemical Company
• Premi-Glas	Premix, Inc.
• Premi-Ject	Premix, Inc.
• Stypol	Cook Composites

General Description

Thermoset polyesters and alkyd compounds are produced by the reaction of an organic alcohol with an organic acid. The term alkyd is used for those resins which use the lowest amounts of monomer. Polyesters can be created with a tremendous variety of different monomers and catalysts. They are known for their excellent electrical properties and are widely used in home electrical appliances that require high temperature stability. Specialty grades available include flame retardant, glass filled and magnetizable ferrite filled grades. In 2004, the price of thermoset polyesters ranged approximately from $0.75 to $3.00 per pound at truckload quantities.

General Properties

Thermoset polyesters and alkyd molding compounds are dense materials having specific gravities that range from 1.2 to 2.0. They are also very strong and rigid as illustrated by tensile strengths as high as 14,000 psi (96.5 MPa) and flexural strengths as high as 20,000 psi (138 MPa), respectively. Thermoset polyesters have moderate impact strengths ranging from 1.6 to 10.6 ft-lb/in (8.6 to 57.2 kg cm/cm). Polyesters have good dielectric strength at high temperatures and outstanding resistance to breakdown under electrical arc and tracking conditions. Thermal and dimensional stability is good up to 450°F (230°C). Some grades have high flammability ratings even when molded into sheets as thin as 0.020 in. Thermoset polyesters have good chemical resistance to many chemicals, including alcohols, ethers, salts, organic and inorganic acids. However, they are attacked by hydrocarbons, phenols, ketones, esters, and oxidizing acids.

Typical Properties of Polyester

	American Engineering	SI
Processing Temperature	300°F to 350°F	150°C to 177°C
Linear Mold Shrinkage	0.001 to 0.007 in./in.	0.001 to 0.007 cm/cm
Melting Point	–	–
Density	72.4 to 124.9 lb./ft.^{3}	1.2 to 2.0 g/cm^3
Tensile Strength, Yield	2.6 to 11.0 lb./in.^{2} x 10^3	1.8 to 7.7 kg/cm^2 x 10^2
Tensile Strength, Break	3.7 to 12.1 lb./in.^{2} x 10^3	2.6 to 8.5 kg/cm^2 x 10^2
Elongation, Break	1.0 to 4.2%	1.0 to 4.2%
Tensile Modulus	1.2 to 6.4 lb./in.^{2} x 10^5	0.8 to 4.5 kg/cm^2 x 10^4
Flexural Strength, Yield	11.1 to 20.5 lb./in.^{2} x 10^3	7.8 to 14.4 kg/cm^2 x 10^2
Flexural Modulus	4.7 to 7.4 lb./in.^{2} x 10^5	3.3 to 5.2 kg/cm^2 x 10^4
Compressive Strength	17.5 to 24.3 lb./in.^{2} x 10^3	12.3 to 17.1 kg/cm^2 x 10^2
Izod Notched, R.T.	1.6 to 10.6 ft.-lb./in.	8.6 to 57.2 kg cm/cm
Hardness	5 to 70 Barcol	5 to 70 Barcol
Thermal Conductivity	1.18 BTU-in./hr.-ft.^{2}-°F	0.17 W/m-°K
Linear Thermal Expansion	1.0 to 2.0 in./in.-°F x 10^{-5}	1.8 to 3.6 cm/cm-°C x10^{-5}
Deflection Temperature @ 264 psi	160°F to 500°F	71°C to 260°C
Deflection Temperature @ 66 psi	–	–
Continuous Service Temperature	120°F to 220°F	49°C to 104°C
Dielectric Strength	350 to 500 V/10^{-3} in	1.4 to 2.0 V/mm x 10^4
Dielectric Constant @ 1 MHz	3.2 to 4.5	3.2 to 4.5
Dissipation Factor @ 1 MHz	0.007 to 0.025	0.007 to 0.025
Water Absorption, 24 hr.	0.1 to 0.2%	0.1 to 0.2%

Typical Applications

- ***Electronic* –** Automotive ignition components, appliances, switch boxes, breaker components, encapsulation
- ***Miscellaneous* –** Boat hulls, shower stalls, cookware

ADHESIVE SHEAR STRENGTH (psi) (MPa)

Polyester

	LOCTITE®	C-685 BLACK 183 *20 to 30% Glass Fiber Mineral Filled, 15 rms*	C-685 ROUGHENED *33 rms, Courtesy of American Cyanamid*	DIELECTRIC 48-53-E *Courtesy of Industrial Dielectrics*	DIELECTRIC 44-10 *Unspecified Glass Fill courtesy of Industrial Dielectrics*	DIELECTRIC 46-16-26 *Unspecified Glass Fill courtesy of Industrial Dielectrics*	DIELECTRIC 46-3 *Unspecified Glass Fill courtesy of Industrial Dielectrics*
BMC 685-173 courtesy of Bulk Molding Compounds *8 rms*	**Loctite® 380™ Black Max® Instant Adhesive, Rubber Toughened**	>1350◆ >9.3◆	>900◆ >6.2◆	>1400◆ >9.7◆	>1450◆ >10.0◆	>2100◆ >14.5◆	>1600◆ >11.0◆
	Loctite® 401™ Prism® Instant Adhesive, Surface Insensitive *MEDICAL: Loctite® 4011™ Prism® Instant Adhesive, Surface Insensitive*	>1350◆ >9.3◆	1200 8.3	>1400◆ >9.7◆	>1300◆ >9.0◆	>2050◆ >14.1◆	>1550◆ >10.7◆
	Loctite® 401™ Prism® **Loctite® 770™ Prism® Primer** *MEDICAL: Loctite® 4011™ Prism® / Loctite® 7701™ Prism® Primer*	350 2.4	650 4.5	>600◆ >4.1◆	350 2.4	450 3.1	250 1.7
	Loctite® 414™ Super Bonder® Instant Adhesive, General Purpose	>1900◆ >13.1◆	800 5.5	>1300◆ >9.0◆	>1350◆ >9.3◆	>1950◆ >13.5◆	>1250◆ >8.6◆
	Loctite® 330™ Depend® Adhesive, Two-Part No-Mix Acrylic	700 4.8	700 4.8	450 3.1	650 4.5	600 4.1	700 4.8
	Loctite® 3105™ Light Cure Adhesive, *MEDICAL: Loctite® 3311™ Light Cure Adhesive*	600 4.1	1650 11.3	1100 7.6	1150 7.9	1000 6.9	650 4.5
	Loctite® 4307™ Flashcure® Light Cure Adhesive	>1900◆ >13.1◆					
	Loctite® H3000™ Speedbonder™ Structural Adhesive, General Purpose	1050 7.2					
	Loctite® H4500™ Speedbonder™ Structural Adhesive, Metal Bonder	350 2.4					
	Loctite® 3032™ Adhesive, Polyolefin Bonder	800 5.5					
	Loctite® E-00CL™ Hysol® Epoxy Adhesive, Low Odor	850 5.9					
	Loctite® E-90FL™ Hysol® Epoxy Adhesive, Flexible	>1250◆ >8.6◆					
	Loctite® E-30CL™ Hysol® Epoxy Adhesive, Glass Bonder *MEDICAL: Loctite® M-31CL™ Hysol® Epoxy Adhesive, Glass Bonder*	1050 7.2					
	Loctite® E-20HP™ Hysol® Epoxy Adhesive, Fast Setting *MEDICAL: Loctite® M-21HP™ Hysol® Epoxy Adhesive, Fast Setting*	>1650◆ >11.4◆					
	Loctite® E-214HP™ Hysol® Epoxy Adhesive, High Strength	850 5.9					
	Loctite® Fixmaster® High Performance Epoxy	>1550◆ >10.7◆					
	Loctite® 1942™ Hysol® Hot Melt Adhesive, EVA Based	100 0.7					
	Loctite® 7804™ Hysol® Hot Melt Adhesive	50 0.3					
	Loctite® 3631™ Hysol® Hot Melt Adhesive, Urethane	1150 7.9					
	Loctite® U-05FL™ Hysol® Urethane Adhesive, High Strength	750 5.2					
	Loctite® Fixmaster® Rapid Rubber Repair	500 3.5					
	Loctite® 5900® Flange Sealant, Heavy Body RTV Silicone	200 1.4					

Adhesive Performance

Loctite® 401™ Prism®, 414™ Super Bonder®, 380™ Black Max® Instant Adhesives, Loctite® 4307™ Flashcure® Light Cure Adhesive, Loctite® E-20HP™ Hysol® Epoxy Adhesive and Loctite® Fixmaster® High Performance Epoxy achieved the highest bond strengths on the thermoset polyester, typically achieving substrate failure. With the exception of the three hot melt adhesives, all other adhesives developed moderate to good bond strength on unfilled thermoset polyester.

Surface Treatments

The use of Loctite® 770™ Prism® Primer, in conjunction with Loctite® 401™ Prism® Instant Adhesive, or Loctite® 4011™ Prism® Medical Device Instant Adhesive with Loctite® 7701™ Prism® Primer, are not recommended as they significantly decreased the bond strengths achieved on the grades of thermoset polyester which were evaluated. Surface roughening caused either no effect or a statistically significant increase in the bond strengths achieved by the acrylic adhesives. However, surface roughening typically resulted in a statistically significant increase in the bond strengths achieved by the cyanoacrylate adhesives.

Other Important Information

- Thermoset polyester is compatible with all Loctite® brand adhesives, sealants, primers, and activators.
- Surface cleaners: isopropyl alcohol, Loctite® ODC-Free Cleaner & Degreaser.

NOTES:

◆ The force applied to the tests' specimens exceeded the strength of the material, resulting in substrate failure before the actual bond strength achieved by the adhesive could be determined.

☐ The addition of the indicated additive (or surface roughening) caused a statistically significant decrease in the bond strength within 95% confidence limits.

☐ The addition of the indicated additive (or surface roughening) caused a statistically significant increase in the bond strength within 95% confidence limits.

Polyetheretherketone (PEEK)

Thermoplastic 7 OTHER

Trade Names

- Arlon
- Victrex PEEK

Manufacturer

Greene, Tweed & Co.
Victrex, USA

General Description

Polyetheretherketone, a poly(aryletherketone), is a linear, semi-crystalline, wholly aromatic polymer. It offers outstanding thermal stability and is resistant to a wide range of chemicals. Due to PEEK's suitability for extreme service conditions, it has found use in many demanding niche applications such as high temperature bearings and aircraft radomes and fairings. Specialty grades available include glass, carbon and PTFE filled grades. In 2004, the price of PEEK ranged approximately from $33.00 to $36.00 per pound at truckload quantities.

General Properties

PEEK is a high performance thermoplastic which is well suited for high-temperature environments. In addition, it has good mechanical properties, including a flexural modulus among the highest of all thermoplastics. Furthermore, the addition of fillers to PEEK typically increases both its modulus and thermal stability. PEEK is suitable for applications that will see intermittent exposure to temperatures up to 600°F (315°C) and has a maximum continuous service temperature of approximately 480°F (250°C). Unfilled PEEK meets UL94 V-0 flammability requirements and generates very little smoke upon combustion. PEEK resists mild acids and bases at elevated temperatures, superheated water up to 500°F (260°C), and most common organic solvents. PEEK also has outstanding resistance to radiation, significantly greater than polystyrene, the second most radiation resistant polymeric material. Samples of PEEK have withstood 1100 Mrads without significantly degrading. Sunlight and weathering resistance are also good, with no loss of properties evident after one year of outdoor exposure.

Typical Properties of Polyetheretherketone (PEEK)

	American Engineering	SI
Processing Temperature	700°F to 750°F	371°C to 399°C
Linear Mold Shrinkage	0.001 to 0.005 in./in.	0.001 to 0.005 cm/cm
Melting Point	630°F to 640°F	332°C to 338°C
Density	84.3 to 96.8 lb./ft.^{3}	1.35 to 1.55 g/cm^3
Tensile Strength, Yield	16.9 to 31.2 lb./in.^{2} x 10^3	11.9 to 21.9 kg/cm^2 x 10^2
Tensile Strength, Break	13.1 to 26.1 lb./in.^{2} x 10^3	9.2 to 18.7 kg/cm^2 x 10^2
Elongation, Break	2.0 to 8.0%	2.0 to 8.0%
Tensile Modulus	9.0 to 35.5 lb./in.^{2} x 10^5	6.3 to 23.6 kg/cm^2 x 10^4
Flexural Strength, Yield	21.6 to 39.8 lb./in.^{2} x 10^3	15.2 to 28.0 kg/cm^2 x 10^2
Flexural Modulus	4.0 to 20.0 lb./in.^{2} x 10^5	2.8 to 14.1 kg/cm^2 x 10^4
Compressive Strength	11.0 to 32.0 lb./in.^{2} x 10^3	7.7 to 22.5 kg/cm^2 x 10^2
Izod Notched, R.T.	0.9 to 2.2 ft.-lb./in.	4.7 to 11.9 kg cm/cm
Hardness	M100 - M124 Rockwell	M100 - M124 Rockwell
Thermal Conductivity	1.5 to 6.5 BTU-in./hr.-ft.^{2}-°F	0.22 to 0.94 W/m-°K
Linear Thermal Expansion	0.7 to 1.8 in./in.-°F x 10^{-5}	1.3 to 3.2 cm/cm-°C x10^{-5}
Deflection Temperature @ 264 psi	350°F to 610°F	177°C to 321°C
Deflection Temperature @ 66 psi	500°F to 640°F	260°C to 338°C
Continuous Service Temperature	428°F to 480°F	220°C to 249°C
Dielectric Strength	350 to 500 V/10^{-3} in.	1.4 to 2.0 V/mm x 10^4
Dielectric Constant @ 1 MHz	3.0 to 4.2	3.0 to 4.2
Dissipation Factor @ 1 MHz	0.001 to 0.005	0.001 to 0.005
Water Absorption, 24 hr.	0.06 to 0.18%	0.06 to 0.18%

Typical Applications

- ***Aerospace –*** Wire and cable insulation, coatings, EMI/RFI shields
- ***Miscellaneous –*** High temperature bearings, compressor parts, nuclear power plant and oil well applications, military equipment

ADHESIVE SHEAR STRENGTH (psi) (MPa)

Polyetheretherketone

	LOCTITE®	**VICTREX 450G CONTROL**	**450G ROUGHENED** *22 rms*	**PEEK 450 CA30** *30% Carbon Fiber, courtesy of Victrex, U.S.A.*	**THERMOCOMP LF-1006** *30% Glass Fiber, courtesy of LNP Engineering Plastics*	**LUBRICOMP LCL-4033 EM** *15% Carbon Fiber, 15% PTFE, courtesy of LNP Engineering Plastics*
Unfilled Resin courtesy of Victrex, U.S.A. and Modern Plastics	**Loctite® 380™ Black Max® Instant Adhesive, Rubber Toughened**	150 1.0	700 4.8	150 1.0	100 0.7	100 0.7
	Loctite® 401™ Prism® Instant Adhesive, Surface Insensitive *MEDICAL: Loctite® 4011™ Prism® Instant Adhesive, Surface Insensitive*	250 1.7	350 2.4	200 1.4	250 1.7	400 2.8
	Loctite® 401™ Prism® Loctite® 770™ Prism® Primer *MEDICAL: Loctite® 4011™ Prism® / Loctite® 7701™ Prism® Primer*	250 1.7	350 2.4	450 3.1	550 3.8	300 2.1
	Loctite® 414™ Super Bonder® Instant Adhesive, General Purpose	200 1.4	300 2.1	250 1.7	400 2.8	250 1.7
	Loctite® 330™ Depend® Adhesive, Two-Part No-Mix Acrylic	350 2.4	350 2.4	450 3.1	500 3.5	500 3.5
	Loctite® 3105™ Light Cure Adhesive, *MEDICAL: Loctite® 3311™ Light Cure Adhesive*	1100 7.6	1100 7.6	950 6.6	1200 8.3	900 6.2
	Loctite® 4307™ Flashcure® Light Cure Adhesive	900 6.2				
	Loctite® H3000™ Speedbonder™ Structural Adhesive, General Purpose	300 2.1				
	Loctite® H4500™ Speedbonder™ Structural Adhesive, Metal Bonder	250 1.7				
	Loctite® 3032™ Adhesive, Polyolefin Bonder	300 2.1				
	Loctite® E-00CL™ Hysol® Epoxy Adhesive, Low Odor	250 1.7				
	Loctite® E-90FL™ Hysol® Epoxy Adhesive, Flexible	450 3.1				
	Loctite® E-30CL™ Hysol® Epoxy Adhesive, Glass Bonder *MEDICAL: Loctite® M-31CL™ Hysol® Epoxy Adhesive, Glass Bonder*	500 3.5				
	Loctite® E-20HP™ Hysol® Epoxy Adhesive, Fast Setting *MEDICAL: Loctite® M-21HP™ Hysol® Epoxy Adhesive, Fast Setting*	300 2.1				
	Loctite® E-214HP™ Hysol® Epoxy Adhesive, High Strength	500 3.5				
	Loctite® Fixmaster® High Performance Epoxy	400 2.8				
	Loctite® 1942™ Hysol® Hot Melt Adhesive, EVA Based	100 0.7				
	Loctite® 7804™ Hysol® Hot Melt Adhesive	100 0.7				
	Loctite® 3631™ Hysol® Hot Melt Adhesive, Urethane	750 5.2				
	Loctite® U-05FL™ Hysol® Urethane Adhesive, High Strength	600 4.1				
	Loctite® Fixmaster® Rapid Rubber Repair	750 5.2				
	Loctite® 5900® Flange Sealant, Heavy Body RTV Silicone	200 1.4				

Adhesive Performance

Loctite® 3105™ and 4307™ Flashcure® Light Cure Adhesives consistently achieved the highest bond strengths on PEEK. With the exception of the three hot melt adhesives, all other adhesives developed moderate to good bond strength on unfilled PEEK.

Surface Treatments

Surface roughening caused either no effect or a statistically significant increase in the bond strengths achieved on PEEK. Loctite® 770™ Prism® Primer, used in conjunction with Loctite® 401™ Prism® Instant Adhesive, or Loctite® 4011™ Prism® Medical Device Instant Adhesive with Loctite® 7701™ Prism® Primer, had no overall statistically significant effect on the bondability of PEEK. However, Loctite® 770™ and 7701™ Prism® Primers did result in a statistically significant increase in the bond strengths achieved on the PEEK 450 CA30 and Thermocomp LF-1006 grades.

Other Important Information

- PEEK is compatible with all Loctite® brand adhesives, sealants, primers, and activators.
- Surface cleaners: isopropyl alcohol, Loctite® ODC-Free Cleaner & Degreaser.

NOTES:

☐ The addition of the indicated additive (or surface roughening) caused a statistically significant decrease in the bond strength within 95% confidence limits.

▨ The addition of the indicated additive (or surface roughening) caused a statistically significant increase in the bond strength within 95% confidence limits.

Polyetherimide (PEI)

Thermoplastic ♹ OTHER

Trade Names

- Ultem

Manufacturer

GE Plastics

General Description

Polyetherimide (PEI) is an amorphous thermoplastic which is based on repeating aromatic imide and ether units. PEI is known for its high strength and rigidity, especially under long-term heat exposure. The rigid aromatic imide units provide PEI with its high performance properties at elevated temperatures, while the ether linkages provide it with the chain flexibility necessary to have good melt flow and processability. Currently, the largest area of growth for PEI is in metal replacement applications, mostly involving the replacement of aluminum and brass automotive parts. Specialty grades available include glass, mineral, and carbon reinforced, low wear and low friction, improved chemical resistance and PC/PEI blends, as well as commercial aircraft interior and medically rated grades. In 2004, the price of PEI ranged approximately from $9.00 to $11.00 per pound at truckload quantities.

General Properties

Polyetherimide is a high performance plastic which is well suited for extreme service environments. At room temperature, its mechanical properties exceed those of most thermoplastics, and it displays an impressive retention of these properties at temperatures as high as 375°F (191°C). PEI also performs extremely well at elevated temperatures. For example, Ultem 1000 has a glass transition temperature of 419°F (215°C), heat deflection temperature at 264 psi (1.82 MPa) of 392°F (200°C), and continuous service temperature of 338°F (170°C). PEI exhibits excellent impact strength and ductility, but does display notch sensitivity when subjected to high stress rates. PEI has an exceptionally high flame resistance, and when it does burn, it generates very low levels of smoke. It is an excellent electrical insulator, has a low dissipation factor, a high volume resistivity, a high arc resistance, and is extraordinarily free of ionic contaminations. Not only does PEI have excellent hydrolytic stability, UV stability, and radiation resistance, but it is also extremely well suited for repeated steam, hot air, ethylene oxide gas and cold chemical sterilizations. PEI is resistant to a wide range of chemicals including alcohols, hydrocarbons, aqueous detergents and bleaches, strong acids, and mild bases.

Typical Properties of Polyetherimide (PEI)

	American Engineering	SI
Processing Temperature	600°F to 750°F	316°C to 399°C
Linear Mold Shrinkage	0.001 to 0.006 in./in.	0.001 to 0.006 cm/cm
Melting Point	400°F to 450°F	204°C to 232°C
Density	78.0 to 93.6 lb./ft.^{3}	1.25 to 1.50 g/cm^3
Tensile Strength, Yield	14.9 to 26.6 lb./in.^{2} x 10^3	10.5 to 18.7 kg/cm^2 x 10^2
Tensile Strength, Break	12.1 to 25.9 lb./in.^{2} x 10^3	8.5 to 18.2 kg/cm^2 x 10^2
Elongation, Break	1.5 to 5.3%	1.5 to 5.3%
Tensile Modulus	3.3 to 18.0 lb./in.^{2} x 10^5	2.3 to 12.7 kg/cm^2 x 10^4
Flexural Strength, Yield	19.5 to 44.6 lb./in.^{2} x 10^3	13.7 to 31.4 kg/cm^2 x 10^2
Flexural Modulus	4.0 to 18.4 lb./in.^{2} x 10^5	2.8 to 12.9 kg/cm^2 x 10^4
Compressive Strength	20.0 to 26.0 lb./in.^{2} x 10^3	14.1 to 18.3 kg/cm^2 x 10^2
Izod Notched, R.T.	0.8 to 1.6 ft.-lb./in.	4.1 to 8.7 kg cm/cm
Hardness	R115 - R125 Rockwell	R115 - R125 Rockwell
Thermal Conductivity	1.6 to 5.1 BTU-in./hr.-ft.^{2}-°F	0.23 to 0.74 W/m-°K
Linear Thermal Expansion	0.6 to 1.9 in./in.-°F x 10^{-5}	1.1 to 3.4 cm/cm-°C x10^{-5}
Deflection Temperature @ 264 psi	390°F to 420°F	199°C to 216°C
Deflection Temperature @ 66 psi	400°F to 440°F	204°C to 227°C
Continuous Service Temperature	300° to 350°F	149°C to 177°C
Dielectric Strength	480 to 770 V/10^{-3} in.	1.9 to 3.0 V/mm x 10^4
Dielectric Constant @ 1 MHz	3.0 to 3.8	3.0 to 3.8
Dissipation Factor @ 1 MHz	0.001 to 0.005	0.001 to 0.005
Water Absorption, 24 hr.	0.12 to 0.25%	0.12 to 0.25%

Typical Applications

- ***Transportation –*** Under-the-hood temperature sensors, fuel system and transmission components
- ***Electronics –*** Thin wall connectors, chip carriers, burn-in sockets, printed wiring boards
- ***Medical –*** Fittings, connectors
- ***Miscellaneous –*** Computer disks, electrical tapes, flexible circuitry, explosion-proof electrical enclosures

Polyetherimide (PEI)

	LOCTITE®	UNFILLED RESIN ULTEM GRADE 1010 *3 rms*	GRADE 1010 ROUGHENED *47 rms*	GRADE 2100 *10% Glass Reinforced*	GRADE 2400 *40% Glass Reinforced*	GRADE 3453 *45% Glass/Silica Reinforced*	GRADE 4001 *Unreinforced, with Lubricant*	GRADE CRS5001 *Unreinforced, Chemically Resistant Grade*	GRADE 7801 *25% Carbon Reinforced*	GRADE LTX100A *PEI/PC Blend Injection Molding Grade*
Courtesy of GE Plastics	**Loctite® 380™ Black Max® Instant Adhesive, Rubber Toughened**	150 1.0	1050 7.2	350 2.4	1150 7.9	1300 9.0	150 1.0	450 3.1	950 6.6	750 5.2
	Loctite® 401™ Prism® Instant Adhesive, Surface Insensitive *MEDICAL: Loctite® 4011™ Prism® Instant Adhesive, Surface Insensitive*	1350 9.3	2450 16.9	1050 7.2	1000 6.9	1650 11.4	650 4.5	1400 9.7	1250 8.6	1400 9.7
	Loctite® 401™ Prism® Loctite® 770™ Prism® Primer *MEDICAL: Loctite® 4011™ Prism® / Loctite® 7701™ Prism® Primer*	300 2.1	2000 13.8	500 3.5	850 5.9	1350 9.3	300 2.1	200 1.4	1350 9.3	650 4.5
	Loctite® 414™ Super Bonder® Instant Adhesive, General Purpose	1100 7.6	2000 13.8	900 6.2	2150 14.8	2000 13.8	700 4.8	1050 7.2	1850 12.8	1100 7.6
	Loctite® 330™ Depend® Adhesive, Two-Part No-Mix Acrylic	500 3.5	800 5.5	700 4.8	1700 11.7	1500 10.3	550 3.8	700 4.8	750 5.2	800 5.5
	Loctite® 3105™ Light Cure Adhesive, *MEDICAL: Loctite® 3311™ Light Cure Adhesive*	2250 15.5	2250 15.5	1750 12.1	1300 9.0	1500 10.3	>1800◆ >12.4◆	1550 10.7	1400 9.7	3550 24.5
Ultem Grade 1000 NAT	**Loctite® 4307™ Flashcure® Light Cure Adhesive**	>2050◆ >14.1◆								
	Loctite® H3000™ Speedbonder™ Structural Adhesive, General Purpose	750 5.2								
	Loctite® H4500™ Speedbonder™ Structural Adhesive, Metal Bonder	350 2.4								
	Loctite® 3032™ Adhesive, Polyolefin Bonder	550 3.8								
	Loctite® E-00CL™ Hysol® Epoxy Adhesive, Low Odor	650 4.5								
	Loctite® E-90FL™ Hysol® Epoxy Adhesive, Flexible	1000 6.9								
	Loctite® E-30CL™ Hysol® Epoxy Adhesive, Glass Bonder *MEDICAL: Loctite® M-31CL™ Hysol® Epoxy Adhesive, Glass Bonder*	1350 9.3								
	Loctite® E-20HP™ Hysol® Epoxy Adhesive, Fast Setting *MEDICAL: Loctite® M-21HP™ Hysol® Epoxy Adhesive, Fast Setting*	1150 7.9								
	Loctite® E-214HP™ Hysol® Epoxy Adhesive, High Strength	900 6.2								
	Loctite® Fixmaster® High Performance Epoxy	1100 7.6								
	Loctite® 1942™ Hysol® Hot Melt Adhesive, EVA Based	300 2.1								
	Loctite® 7804™ Hysol® Hot Melt Adhesive	250 1.7								
	Loctite® 3631™ Hysol® Hot Melt Adhesive, Urethane	1400 9.7								
	Loctite® U-05FL™ Hysol® Urethane Adhesive, High Strength	450 3.1								
	Loctite® Fixmaster® Rapid Rubber Repair	500 3.5								
	Loctite® 5900® Flange Sealant, Heavy Body RTV Silicone	250 1.7								

Adhesive Performance

Loctite® 4307™ Flashcure® Light Cure Adhesive achieved the highest bond strengths on the PEI, typically achieving substrate failure. Loctite® 401™ Prism®, 4011™ Prism® Medical Device, 414™ Super Bonder® Instant Adhesives, Loctite® 3105™ Light Cure Adhesive, Loctite® E-90FL™ and E-30CL™ Hysol® Epoxy Adhesives, Loctite® 3631™ Hysol® Hot Melt Adhesive, and Loctite® Fixmaster® High Performance Epoxy normally achieved the high bond strengths on the various grades of Ultem which were evaluated. However, the performance of each adhesive varied from grade to grade.

Surface Treatments

Surface roughening caused large, statistically significant increases in the bond strengths achieved on PEI. The use of Loctite® 770™ Prism® Primer, in conjunction with Loctite® 401™ Prism® Instant Adhesive, or Loctite® 4011™ Prism® Medical Device Instant Adhesive with Loctite® 7701™ Prism® Primer, caused a significant decrease in the bond strengths achieved on most of the grades of Ultem which were evaluated.

Other Important Information

- Good solvents for use with PEI are methylene chloride and n-methylpyrrolidone.
- An accelerator may be necessary to speed the cure of cyanoacrylates on unfilled grades of PEI.
- Some grades of PEI have been found to be incompatible with cyanoacrylate adhesives.
- Surface cleaners: isopropyl alcohol, Loctite® ODC-Free Cleaner & Degreaser.

NOTES:

◆ The force applied to the tests' specimens exceeded the strength of the material, resulting in substrate failure before the actual bond strength achieved by the adhesive could be determined.

🟧 The addition of the indicated additive (or surface roughening) caused a statistically significant decrease in the bond strength within 95% confidence limits.

⬜ The addition of the indicated additive (or surface roughening) caused a statistically significant increase in the bond strength within 95% confidence limits.

Polyethersulfone (PES)

Thermoplastic ♹ OTHER

Trade Names	**Manufacturer**
• Ultrason	BASF
• Victrex PES	Victrex, USA

General Description

PES is an amorphous thermoplastic whose backbone is composed of alternating aromatic groups linked with alternating oxygen and sulfur dioxide groups. PES is primarily used for high temperature applications. Specialty grades available include glass, carbon, stainless steel, and fluorocarbon filled. In 2004, the price of PES ranged approximately from $3.31 to $4.55 per pound at truckload quantities.

General Properties

The most notable properties of PES are its transparency, good mechanical properties, and outstanding thermal stability. Unfilled PES has a useful life of 4 to 5 years at 390°F (199°C) and approximately 20 years at 356°F (180°C). Moreover, the mechanical and electrical properties of PES show a low sensitivity to temperature change and load. In addition, the mechanical properties of PES at elevated temperatures can be significantly increased by annealing. PES has a low smoke emission and can withstand long-term exposure to both air and water at elevated temperatures. PES is chemically resistant to most inorganic chemicals, greases, aliphatic hydrocarbons, and both leaded and unleaded gasoline. However, PES is attacked by esters, ketones, methylene chloride, and polar aromatic solvents. The chemical resistance of PES is lessened by internal stress, but this can be alleviated by annealing the polymer. Typical of the polysulfone family, PES has a low resistance to weathering and is degraded by UV light, making unfilled PES inappropriate for outdoor use. The major disadvantage to adhesively joining PES is that PES is extremely sensitive to stress cracking. However, the addition of glass fillers, the use of adhesive accelerators and/or annealing PES greatly increases its resistance to stress cracking.

Typical Properties of Polyethersulfone (PES)

	American Engineering	SI
Processing Temperature	675°F to 700°F	357°C to 371°C
Linear Mold Shrinkage	0.001 to 0.006 in./in.	0.001 to 0.006 cm/cm
Melting Point	440°F to 460°F	227°C to 238°C
Density	91.8 to 99.9 lb./ft.^{3}	1.47 to 1.60 g/cm^3
Tensile Strength, Yield	13.0 to 21.0 lb./in.^{2} x 10^3	9.1 to 14.8 kg/cm^2 x 10^2
Tensile Strength, Break	11.9 to 23.6 lb./in.^{2} x 10^3	8.4 to 16.6 kg/cm^2 x 10^2
Elongation, Break	2.0 to 4.3%	2.0 to 4.3%
Tensile Modulus	5.9 to 13.5 lb./in.^{2} x 10^5	4.1 to 9.5 kg/cm^2 x 10^4
Flexural Strength, Yield	17.9 to 29.5 lb./in.^{2} x 10^3	12.6 to 20.7 kg/cm^2 x 10^2
Flexural Modulus	3.4 to 13.0 lb./in.^{2} x 10^5	2.4 to 9.1 kg/cm^2 x 10^4
Compressive Strength	15.9 to 21.3 lb./in.^{2} x 10^3	11.2 to 15.0 kg/cm^2 x 10^2
Izod Notched, R.T.	1.0 to 1.6 ft.-lb./in.	5.3 to 8.6 kg cm/cm
Hardness	R120 - R123 Rockwell	R120 - R123 Rockwell
Thermal Conductivity	1.3 to 2.9 BTU-in./hr.-ft.^{2}-°F	0.19 to 0.42 W/m-°K
Linear Thermal Expansion	1.2 to 3.3 in./in.-°F x 10^{-5}	2.2 to 5.9 cm/cm-°C x10^{-5}
Deflection Temperature @ 264 psi	400°F to 460°F	204°C to 238°C
Deflection Temperature @ 66 psi	420°F to 460°F	216°C to 238°C
Continuous Service Temperature	350°F to 390°F	177°C to 199°C
Dielectric Strength	370 to 600 V/10^{-3} in.	1.5 to 2.4 V/mm x 10^4
Dielectric Constant @ 1 MHz	3.5 to 4.2	3.5 to 4.2
Dissipation Factor @ 1 MHz	0.006 to 0.010	0.006 to 0.010
Water Absorption, 24 hr.	0.29 to 0.41%	0.29 to 0.41%

Typical Applications

- ***Electrical –*** Multipin connectors, coil formers, printed circuit boards
- ***Miscellaneous –*** Radomes, pump housings, bearing cages, hot combs, medical trays

ADHESIVE SHEAR STRENGTH (psi) (MPa)

Polyethersulfone

	LOCTITE®	UNFILLED RESIN *5 rms*	ROUGHENED *24 rms*	LUBRICANT *9% Polymist F510*	INTERNAL MOLD RELEASE *0.5% Mold Wiz 55PV*	FILLER *17% 497 Fiberglass*	COLORANT *0.5% Yellow 55-21007*	POLYSULFONE *Udel courtesy of Amoco Performance Products*
Ultrason E2010 by BASF	**Loctite® 380™ Black Max® Instant Adhesive, Rubber Toughened**	650 4.5	1850 12.8	950 6.6	650 4.5	1750 12.1	650 4.5	650 4.5
	Loctite® 401™ Prism® Instant Adhesive, Surface Insensitive *MEDICAL: Loctite® 4011™ Prism® Instant Adhesive, Surface Insensitive*	1600 11.0	1600 11.0	850 5.9	500 3.5	1600 11.0	850 5.9	1600 11.0
	Loctite® 401™ Prism® Loctite® 770™ Prism® Primer *MEDICAL: Loctite® 4011™ Prism® / Loctite® 7701™ Prism® Primer*	150 1.0	1100 7.6	600 4.1	150 1.0	1850 12.8	450 3.1	150 1.0
	Loctite® 414™ Super Bonder® Instant Adhesive, General Purpose	950 6.6	1250 8.6	700 4.8	950 6.6	1900 13.1	2950 20.3	700 4.8
	Loctite® 330™ Depend® Adhesive, Two-Part No-Mix Acrylic	250 1.7	250 1.7	800 5.5	250 1.7	1150 7.9	550 3.8	900 6.2
	Loctite® 3105™ Light Cure Adhesive, *MEDICAL: Loctite® 3311™ Light Cure Adhesive*	3050 21.0	3050 21.0	2350 16.2	3800 26.2	3050 21.0	3050 21.0	3050 21.0
Udel P-1700 produced by Solvay Advanced Polymers *11 rms*	**Loctite® 4307™ Flashcure® Light Cure Adhesive**	>2600◆ >17.9◆						
	Loctite® H3000™ Speedbonder™ Structural Adhesive, General Purpose	1000 6.9						
	Loctite® H4500™ Speedbonder™ Structural Adhesive, Metal Bonder	600 4.1						
	Loctite® 3032™ Adhesive, Polyolefin Bonder	2000 13.8						
	Loctite® E-00CL™ Hysol® Epoxy Adhesive, Low Odor	450 3.1						
	Loctite® E-90FL™ Hysol® Epoxy Adhesive, Flexible	600 4.1						
	Loctite® E-30CL™ Hysol® Epoxy Adhesive, Glass Bonder *MEDICAL: Loctite® M-31CL™ Hysol® Epoxy Adhesive, Glass Bonder*	650 4.5						
	Loctite® E-20HP™ Hysol® Epoxy Adhesive, Fast Setting *MEDICAL: Loctite® M-21HP™ Hysol® Epoxy Adhesive, Fast Setting*	650 4.5						
	Loctite® E-214HP™ Hysol® Epoxy Adhesive, High Strength	1700 11.7						
	Loctite® Fixmaster® High Performance Epoxy	1000 6.9						
	Loctite® 1942™ Hysol® Hot Melt Adhesive, EVA Based	200 1.4						
	Loctite® 7804™ Hysol® Hot Melt Adhesive	100 0.7						
	Loctite® 3631™ Hysol® Hot Melt Adhesive, Urethane	1400 9.7						
	Loctite® U-05FL™ Hysol® Urethane Adhesive, High Strength	600 4.1						
	Loctite® Fixmaster® Rapid Rubber Repair	250 1.7						
	Loctite® 5900® Flange Sealant, Heavy Body RTV Silicone	150 1.0						

Adhesive Performance

Loctite® 3105™ Light Cure Adhesive consistently achieved the highest bond strengths on PES, while Loctite® 4307™ Flashcure® Light Cure Adhesive achieved substrate failure at a lower bond strength. Loctite® 401™ Prism®, 414™ Super Bonder® Instant Adhesives, Loctite® E-214HP™ Hysol® Epoxy Adhesive, Loctite® 3631™ Hysol® Hot Melt Adhesive, and Loctite® Fixmaster® High Performance Epoxy all developed significant bond strength on unfilled PES. The only statistically significant difference between the bondability of unfilled PES and polysulfone was that Loctite® 330™ Depend® Adhesive achieved higher, statistically significant bond strengths on the polysulfone than on the unfilled PES.

Surface Treatments

Surface roughening caused either no effect or a statistically significant increase in the bond strengths achieved on PES. The use of Loctite® 770™ Prism® Primer, in conjunction with Loctite® 401™ Prism® Instant Adhesive, or Loctite® 4011™ Prism® Medical Device Instant Adhesive with Loctite® 7701™ Prism® Primer, caused a statistically significant decrease in the bondability of both PES and polysulfone.

Other Important Information

- PES and polysulfone are extremely sensitive to stress cracking caused by exposure to uncured cyanoacrylate adhesives, so any excess adhesive should be removed from the surface immediately, and cyanoacrylate accelerators should be used whenever possible.
- PES and polysulfone are compatible with acrylic adhesives, but can be attacked by their activators before the adhesive has cured. Any excess activator should be removed from the surface immediately.
- PES and polysulfone are incompatible with anaerobic adhesives.
- Surface cleaners: isopropyl alcohol, Loctite® ODC-Free Cleaner & Degreaser.

NOTES:

◆ The force applied to the tests' specimens exceeded the strength of the material, resulting in substrate failure before the actual bond strength achieved by the adhesive could be determined.

☐ The addition of the indicated additive (or surface roughening) caused a statistically significant decrease in the bond strength within 95% confidence limits.

☐ The addition of the indicated additive (or surface roughening) caused a statistically significant increase in the bond strength within 95% confidence limits.

Polyethylene (LDPE, HDPE)

Thermoplastic 2 HDPE 4 LDPE

Trade Names	**Manufacturer**
Aspun	Dow Plastics
Attane	Dow Plastics
Bapolene	Bamberger Polymers, Inc.
Clysar	DuPont Company
Dowlex	Dow Chemical Company
Escorene	Exxon Mobil Chemical
Fortiflex	Solvay Polymers
Hostan GUR	Hoescht Celanese Corporation
Marlex	Phillips 66 Company
Microthene	Quantum Chemical Company
Novapol	Novacor Chemicals
Petrothene	Quantum Chemical
Polyfort FLP	A. Schulman, Inc.
Sclair	Novacor Chemicals
Tuflin	Union Carbide Corporation
Ultra-wear	Polymer Corporation

General Description

Polyethylene is a lightweight, semicrystalline thermoplastic produced by the liquid phase, free radical initiated polymerization of ethylene. The polymer is formed when the proper combination of pressure, temperature, and catalyst break open the double bonds within the ethylene molecules. The amount of branching within the bulk polymer and its density can be controlled by varying the reaction conditions. An increase in the density of polyethylene leads to an increase in its hardness, surface abrasion, tensile strength, modulus, thermal stability, chemical resistance, and surface gloss but diminishes toughness, clarity, flexibility, elongation, and stress cracking resistance. Specialty grades available include the four major density groups, namely I, II, III, and IV in order of increasing density, UV stabilized, flame retardant, antistatic, and grades with many different types of fillers. In 2004, the price of PE ranged approximately from $0.75 to $1.50 per pound at truckload quantities.

General Properties

Polyethylene is not a high performance plastic suited for extreme service environments, but rather an extremely versatile and inexpensive resin that has become one of the most popular of all plastics. Almost all of polyethylene's properties vary greatly with changes in density and molecular weight. Low density polyethylene has a relatively low strength and hardness, but is flexible, clear, impact, creep and stress-crack resistant, and can have an elongation comparable to some rubbers. High density polyethylene has significantly higher strength, hardness, abrasion and chemical resistance, but it sacrifices some of the properties in which low density polyethylene excels. Polyethylenes are not able to withstand high temperatures, but their chemical resistance is excellent for an inexpensive, non-engineering resin. They are not recommended for continuous use with hydrocarbons, some alcohols, and oxidizing acids, but they are resistant to phenols, ketones, esters, ethers, bases, salts, organic and inorganic acids.

Typical Properties of Polyethylene (LDPE, HDPE)

	American Engineering	**SI**
Processing Temperature	300°F to 630°F	149°C to 332°C
Linear Mold Shrinkage	0.017 to 0.050 in./in.	0.017 to 0.050 cm/cm
Melting Point	210°F to 400°F	99°C to 204°C
Density	56.2 to 58.1 lb./ft.^{3}	0.90 to 0.93 g/cm^3
Tensile Strength, Yield	1.1 to 2.0 lb./in.^{2} x 10^3	0.8 to 1.4 kg/cm^2 x 10^2
Tensile Strength, Break	1.1 to 5.8 lb./in.^{2} x 10^3	0.8 to 4.1 kg/cm^2 x 10^2
Elongation, Break	60.0 to 780.0%	60.0 to 780.0%
Tensile Modulus	0.1 to 0.4 lb./in.^{2} x 10^5	0.1 to 0.3 kg/cm^2 x 10^4
Flexural Strength, Yield	–	–
Flexural Modulus	0.2 to 0.5 lb./in.^{2} x 10^5	0.1 to 0.4 kg/cm^2 x 10^4
Compressive Strength	–	–
Izod Notched, R.T.	–	–
Hardness	R44 - R55 Rockwell	R44 - R55 Rockwell
Thermal Conductivity	1.8 to 2.9 BTU-in./hr.-ft.^{2}-°F	0.26 to 0.42 W/m-°K
Linear Thermal Expansion	11.0 to 18.0 in./in.-°F x 10^{-5}	19.8 to 32.4 cm/cm-°C x10^{-5}
Deflection Temperature @ 264 psi	73°F to 126°F	23°C to 52°C
Deflection Temperature @ 66 psi	100°F to 120°F	38°C to 49°C
Continuous Service Temperature	104°F to 158°F	40°C to 70°C
Dielectric Strength	475 to 900 V/10^{-3} in.	1.9 to 3.5 V/mm x 10^4
Dielectric Constant @ 1 MHz	2.2 to 2.4	2.2 to 2.4
Dissipation Factor @ 1 MHz	0.0001 to 0.0005	0.0001 to 0.0005
Water Absorption, 24 hr.	0.01 to 1.5%	0.01 to 1.5%

Typical Applications

- ***Films –*** Shrink bundling, drum and bag liners, ice bags, shipping sacks, cling wrap, snack packaging, diaper liners
- ***Packaging –*** Food and shipping containers, milk, water, antifreeze, and household chemical containers, squeeze bottles
- ***Miscellaneous –*** Pipe and chemical drum liners, electric cable jacketing, toys, portable sanitary facilities, commercial storage tanks, envelopes

ADHESIVE SHEAR STRENGTH (psi) (MPa)

Low Density Polyethylene

.722 M Produced by Dow Chemical

LOCTITE®	**UNFILLED RESIN** *5 rms*	**ROUGHENED** *88 rms*	**ANTIOXIDANT** *0.1% Irganox 1010*	**UV STABILIZER** *0.3% Cyasorb UV-531*	**FLAME RETARDANT** *16% DET-83R 6% Antimony Oxide*	**LUBRICANT** *1% Synpro 114-36*	**FILLER** *17% OmyaCarb F*	**COLORANT** *0.1% Watchung Red B RT4280*	**ANTISTATIC** *0.4% Armostat 375*	**HIGH DENSITY POLYETHELENE** *courtesy of Compression Polymers*
Loctite® 380™ Black Max® Instant Adhesive, Rubber Toughened	<50 <0.3	<50 <0.3	50 0.3	100 0.7	100 0.7	100 0.7	100 0.7	<50 <0.3	<50 <0.3	<50 <0.3
Loctite® 401™ Prism® Instant Adhesive, Surface Insensitive *MEDICAL: Loctite® 4011™ Prism® Instant Adhesive, Surface Insensitive*	150 1.0	150 1.0	150 1.0	100 0.7	150 1.0	150 1.0	150 1.0	100 0.7	600 4.1	50 0.3
Loctite® 401™ Prism® Loctite® 770™ Prism® Primer *MEDICAL: Loctite® 4011™ Prism® / Loctite® 7701™ Prism® Primer*	500 3.5	500 3.5	500 3.5	200 1.4	500 3.5	500 3.5	500 3.5	500 3.5	500 3.5	2000 13.8
Loctite® 414™ Super Bonder® Instant Adhesive, General Purpose	150 1.0	150 1.0	150 1.0	150 1.0	150 1.0	150 1.0	300 2.1	50 0.3	750 5.2	50 0.3
Loctite® 330™ Depend® Adhesive, Two-Part No-Mix Acrylic	150 1.0	150 1.0	150 1.0	200 1.4	150 1.0	150 1.0	200 1.4	150 1.0	150 1.0	150 1.0
Loctite® 3105™ Light Cure Adhesive, *MEDICAL: Loctite® 3311™ Light Cure Adhesive*	350 2.4	350 2.4	350 2.4	150 1.0	100 0.7	350 2.4	350 2.4	100 0.7	200 1.4	100 0.7
Loctite® 4307™ Flashcure® Light Cure Adhesive	100 0.7									
Loctite® H3000™ Speedbonder™ Structural Adhesive, General Purpose	50 0.3									
Loctite® H4500™ Speedbonder™ Structural Adhesive, Metal Bonder	100 0.7									
Loctite® 3032™ Adhesive, Polyolefin Bonder	>1400◆ >9.7◆									
Loctite® E-00CL™ Hysol® Epoxy Adhesive, Low Odor	200 1.4									
Loctite® E-90FL™ Hysol® Epoxy Adhesive, Flexible	100 0.7									
Loctite® E-30CL™ Hysol® Epoxy Adhesive, Glass Bonder *MEDICAL: Loctite® M-31CL™ Hysol® Epoxy Adhesive, Glass Bonder*	300 1.0									
Loctite® E-20HP™ Hysol® Epoxy Adhesive, Fast Setting *MEDICAL: Loctite® M-21HP™ Hysol® Epoxy Adhesive, Fast Setting*	150 1.0									
Loctite® E-214HP™ Hysol® Epoxy Adhesive, High Strength	NOT TESTED									
Loctite® Fixmaster® High Performance Epoxy	150 1.0									
Loctite® 1942™ Hysol® Hot Melt Adhesive, EVA Based	200 1.4									
Loctite® 7804™ Hysol® Hot Melt Adhesive	100 0.7									
Loctite® 3631™ Hysol® Hot Melt Adhesive, Urethane	300 2.1									
Loctite® U-05FL™ Hysol® Urethane Adhesive, High Strength	150 1.0									
Loctite® Fixmaster® Rapid Rubber Repair	100 0.7									
Loctite® 5900® Flange Sealant, Heavy Body RTV Silicone	<50 <0.3									

Adhesive Performance

Loctite® 3032™ Adhesive typically achieved bond strengths that were higher in strength than the unfilled resin. Loctite® 401™ Prism® Instant Adhesive, when used in conjunction with Loctite® 770™ Prism® Primer, achieved good bond strength on this difficult-to-bond plastic. The addition of an antistatic agent to LDPE significantly enhanced the bond strength of Loctite® 401™ Prism® and 414™ Super Bonder® Instant Adhesives.

Surface Treatments

Loctite® 770™ Prism® Primer, when used in conjunction with Loctite® 401™ Prism® Instant Adhesive, or Loctite® 4011™ Prism® Medical Device Instant Adhesive with Loctite® 7701™ Prism® Primer, caused a statistically significant increase in the bond strengths achieved on all of the formulations of PE which were evaluated, with the exception of the formulation which contained an antistatic agent additive. Surface roughening caused no statistically significant effect on the bondability of LDPE.

Other Important Information

- Polyethylene is compatible with all Loctite® brand adhesives, sealants, primers, and activators.
- Surface cleaners: isopropyl alcohol, Loctite® ODC-Free Cleaner & Degreaser.

NOTES:

◆ The force applied to the tests' specimens exceeded the strength of the material, resulting in substrate failure before the actual bond strength achieved by the adhesive could be determined.

NOT TESTED: Substrate melted at adhesive cure temperature.

☐ The addition of the indicated additive (or surface roughening) caused a statistically significant decrease in the bond strength within 95% confidence limits.

☐ The addition of the indicated additive (or surface roughening) caused a statistically significant increase in the bond strength within 95% confidence limits.

Polyethylene Terephthalate (PET)

Thermoplastic

Trade Names	Manufacturer
Cleartuf	Goodyear
Ektar FB	Eastman Performance
Impet	Hoechst Celanese
Kodapak PET	Eastman Chemical Products
Lumirror	Toray Industries
Mylar	E.I. DuPont
Petlon	Albis Corporation
Petra	Allied-Signal Corp.
Rynite	E.I. DuPont
Selar	E.I. DuPont
Tenite PET	Eastman Chemical Products
Traytuf	Goodyear
Valox	GE Plastics

General Description

Polyethylene terephthalate is produced by the condensation reaction of either dimethyl terephthalate (DMT) or purified terephthalic acid (PTA) with ethylene glycol. Recently, PET has been produced almost exclusively using PTA, while the addition of a secondary copolymerizing agent, such as cyclohexanedimethanol (CHDM) or isophthalic acid (IPA), has become common. These secondary copolymerizing agents are used to improve the clarity, toughness, and barrier properties of PET, which makes PET better suited for its primary market, blow molded carbonated soft drink containers. Specialty grades available include flame retardant, impact modified, and glass, mineral, carbon, PTFE, and mica filled. In 2004, the price of PET ranged approximately from $1.00 to $2.50 per pound at truckload quantities.

General Properties

For almost all injection molding applications of PET, the PET will be either glass or mineral filled. Reinforced PET is the stiffest of all commonly used thermoplastics, illustrated by the flexural modulus of glass filled PET ranging from 1.3 to 2.6 x 106 psi (0.9 to 1.8 x 105 kg/cm^2). Reinforced PET also has a high tensile strength, excellent heat resistance, outstanding weatherability, and minimal water absorption. Although reinforced PET only has moderate impact resistance (1.2 to 2.6 ft.-lb./in.), impact resistant grades are available which offer a notched izod impact strength of up to 4 ft.-lb./in. Reinforced PET has a high dielectric strength, which remains constant or increases with temperature up to 300°F (149°C). PET is chemically resistant to most chemicals, over a wide range of temperatures, including motor fuels, oils, and hydrocarbon solvents. However, PET is not recommended for long-term use in water at temperatures above 122°F (50°C). Since PET is a condensation polymer, it can be depolymerized when recycling, resulting in the reclamation of pure raw materials, which can then be used to fabricate new products. In 1993, 41% of all U.S. PET sales were recycled.

Typical Properties of Polyethylene Terephthalate (PET)

	American Engineering	SI
Processing Temperature	500°F to 580°F	260°C to 304°C
Linear Mold Shrinkage	0.006 to 0.007 in./in.	0.006 to 0.007 cm/cm
Melting Point	470°F to 500°F	243°C to 260°C
Density	84.3 to 87.4 lb./ft.^{3}	1.35 to 1.40 g/cm^3
Tensile Strength, Yield	5.5 to 13.0 lb./in.^{2} x 10^3	3.9 to 9.1 kg/cm^2 x 10^2
Tensile Strength, Break	7.0 to 10.5 lb./in.^{2} x 10^3	4.9 to 7.4 kg/cm^2 x 10^2
Elongation, Break	85.0 to 160.0%	85.0 to 160.0%
Tensile Modulus	4.0 to 5.5 lb./in.^{2} x 10^5	2.8 to 3.9 kg/cm^2 x 10^4
Flexural Strength, Yield	11.1 to 18.5 lb./in.^{2} x 10^3	7.8 to 13.0 kg/cm^{2}x 10^2
Flexural Modulus	1.3 to 2.6 lb./in.^{2} x 10^5	0.9 to 1.8 kg/cm^2 x 10^4
Compressive Strength	14.0 to 18.3 lb./in.^{2} x 10^3	9.8 to 12.9 kg/cm^{2}x 10^2
Izod Notched, R.T.	0.3 to 4.2 ft.-lb./in.	1.6 to 22.7 kg cm/cm
Hardness	M94 - M101 Rockwell	M94 - M101 Rockwell
Thermal Conductivity	1.0 to 1.7 BTU-in./hr.-ft.^{2}-°F	6.7 to 12.1 W/m-°K
Linear Thermal Expansion	0.8 to 5.0 in./in.-°F x 10^{-5}	1.4 to 9.0 cm/cm-°C x10^{-5}
Deflection Temperature @ 264 psi	350°F to 450°F	177°C to 232°C
Deflection Temperature @ 66 psi	154°F to 162°F	68°C to 72°C
Continuous Service Temperature	330°F to 3801°F	166°C to 193°C
Dielectric Strength	390 to 770 V/10^{-3} in.	1.5 to 2.7 V/mm x 10^4
Dielectric Constant @ 1 MHz	2.9 to 3.2	2.9 to 3.2
Dissipation Factor @ 1 MHz	0.010 to 0.020	0.010 to 0.020
Water Absorption, 24 hr.	0.08 to 0.15%	0.08 to 0.15%

Typical Applications

- ***Automotive –*** Cowl vent grilles, sunroof rails, wiper blade supports
- ***Electrical –*** Computer fans, fuse holders, insulated housings
- ***Packaging –*** Soft drink containers, packaged food containers

ADHESIVE SHEAR STRENGTH (psi) (MPa)

Polyethylene Terephthalate

	LOCTITE®	UNFILLED RESIN 7 rms	ROUGHENED 31 rms	IMPACT MODIFIER 17% Novalene 7300P	FLAME RETARDANT 15% PO-64P 4% Antimony Oxide	LUBRICANT 0.2% Zinc Stearate	INTERNAL MOLD RELEASE 0.5% Mold Wiz 33PA	FILLER 17% 3540 Fiberglass	COLORANT 0.5% Green 99-41042	ANTISTATIC 1% Dehydat 8312
T80 by Hoechst Celanse	**Loctite® 380™ Black Max® Instant Adhesive, Rubber Toughened**	450 3.1	200 1.4	>250◆ >1.7◆	1550 10.7	750 5.2	800 5.5	800 5.5	1000 6.9	>1350◆ >9.3◆
	Loctite® 401™ Prism® Instant Adhesive, Surface Insensitive *MEDICAL: Loctite® 4011™ Prism® Instant Adhesive, Surface Insensitive*	>3200◆ >22.1◆	900 6.2	>350◆ >2.4◆	>2150◆ >14.8◆	>1800◆ >12.4◆	>3200◆ >22.1◆	2900 20.0	>2200◆ >15.2◆	>1900◆ >13.1◆
	Loctite® 401™ Prism® Loctite® 770™ Prism® Primer *MEDICAL: Loctite® 4011™ Prism® / Loctite® 7701™ Prism® Primer*	>1800◆ >12.4◆	700 4.8	>250◆ >1.7◆	600 4.0	>1800◆ >12.4◆	>1800◆ >12.4◆	>3350◆ >23.1◆	>1800◆ >12.4◆	>1800◆ >12.4◆
	Loctite® 414™ Super Bonder® Instant Adhesive, General Purpose	>2200◆ >15.2◆	950 6.6	>400◆ >2.8◆	>2200◆ >15.2◆	>2200◆ >15.2◆	>2200◆ >15.2◆	2200 15.2	>2200◆ >15.2◆	>1450◆ >10.0◆
	Loctite® 330™ Depend® Adhesive, Two-Part No-Mix Acrylic	500 3.5	500 3.5	>150◆ >1.0◆	850 5.9	500 3.5	500 3.5	800 5.5	500 3.5	500 3.5
	Loctite® 3105™ Light Cure Adhesive, *MEDICAL: Loctite® 3311™ Light Cure Adhesive*	1150 7.9	1150 7.9	>300◆ >2.1◆	1150 7.9	1150 7.9	1700 11.7	1700 11.7	1150 7.9	1150 7.9
Quadrant Ertalyte PET produced by Modern Plastics *40 rms*	**Loctite® 4307™ Flashcure® Light Cure Adhesive**	>1200◆ >8.6								
	Loctite® H3000™ Speedbonder™ Structural Adhesive, General Purpose	250 1.7								
	Loctite® H4500™ Speedbonder™ Structural Adhesive, Metal Bonder	350 2.4								
	Loctite® 3032™ Adhesive, Polyolefin Bonder	450 3.1								
	Loctite® E-00CL™ Hysol® Epoxy Adhesive, Low Odor	300 2.1								
	Loctite® E-90FL™ Hysol® Epoxy Adhesive, Flexible	450 3.1								
	Loctite® E-30CL™ Hysol® Epoxy Adhesive, Glass Bonder *MEDICAL: Loctite® M-31CL™ Hysol® Epoxy Adhesive, Glass Bonder*	200 1.4								
	Loctite® E-20HP™ Hysol® Epoxy Adhesive, Fast Setting *MEDICAL: Loctite® M-21HP™ Hysol® Epoxy Adhesive, Fast Setting*	250 1.7								
	Loctite® E-214HP™ Hysol® Epoxy Adhesive, High Strength	650 4.5								
	Loctite® Fixmaster® High Performance Epoxy	150 1.0								
	Loctite® 1942™ Hysol® Hot Melt Adhesive, EVA Based	200 1.4								
	Loctite® 7804™ Hysol® Hot Melt Adhesive	50 0.3								
	Loctite® 3631™ Hysol® Hot Melt Adhesive, Urethane	1050 7.2								
	Loctite® U-05FL™ Hysol® Urethane Adhesive, High Strength	500 3.5								
	Loctite® Fixmaster® Rapid Rubber Repair	600 4.1								
	Loctite® 5900® Flange Sealant, Heavy Body RTV Silicone	200 1.4								

Adhesive Performance

Loctite® 401™ Prism®, 414™ Super Bonder® Instant Adhesives and Loctite® 4307™ Flashcure® Light Cure Adhesive created bonds which were stronger than the PET substrate for most of the formulations tested. Loctite® 3105™ Light Cure Adhesive and Loctite® 3631™ Hysol® Hot Melt Adhesive achieved the next highest bond strengths. Loctite® 4307™ Flashcure® Light Cure Adhesive, a UV Cationic Epoxy, and Loctite® 7804™ Hysol® Hot Melt Adhesive achieved the lowest bond strengths.

Surface Treatments

The overall effect of using Loctite® 770™ Prism® Primer, in conjunction with Loctite® 401™ Prism® Instant Adhesive, or Loctite® 4011™ Prism® Medical Device Instant Adhesive with Loctite® 7701™ Prism® Primer, on PET could not be determined because most of the PET formulations evaluated achieved substrate failure for both the primed and unprimed PET. However, the use of Loctite® 770™ or 7701™ Prism® Primers did cause a statistically significant increase in the bondability of glass filled PET and a statistically significant decrease in the bondability of flame retarded PET. Surface roughening had no effect with the acrylic adhesives and a negative effect with the cyanoacrylate adhesives.

Other Important Information

- PET is compatible with all Loctite® brand adhesives, sealants, primers, and activators.
- Surface cleaners: isopropyl alcohol, Loctite® ODC-Free Cleaner & Degreaser.

NOTES:

◆ The force applied to the tests' specimens exceeded the strength of the material, resulting in substrate failure before the actual bond strength achieved by the adhesive could be determined.

☐ The addition of the indicated additive (or surface roughening) caused a statistically significant decrease in the bond strength within 95% confidence limits.

☐ The addition of the indicated additive (or surface roughening) caused a statistically significant increase in the bond strength within 95% confidence limits.

Polyimide (PI)

Thermoplastic ♷ OTHER

Trade Names	Manufacturer
Envex	Rogers Corporation
Kapton	E.I. DuPont
Kinel	Rhone Poulenc, Inc.
Matrimid	Ciba - Geigy
Meldin	Furon
NEW-TPI	Mitsui Toastu
Vespel	E.I. DuPont

General Description

PI is an aromatic, linear polymer typically produced by a condensation reaction, such as polymerizing aromatic dianhydride and aromatic diamine. The polymer can then either be cast with solvent evaporation to form a thermoplastic, such as Kapton films, or precipitated to form a “pseudo-thermoplastic”, such as Vespel. This pseudo-thermoplastic is not a true thermoplastic because it thermally degrades before its glass transition temperature and it is not a true thermoset because it is not crosslinked. Specialty grades of PI include antistatic, thermally conductive, corona resistant, and glass, carbon, molybdenum disulfide and PTFE filled. In 2004, the price of Vespel, which is sold as molded parts or machinable stock, ranged approximately from $225 to $365 for a ¼" diameter, 38" long rod or $950 for a 10" by 10" by ⅛” plaque. In addition, the price of Kapton films ranged from $63 (5 mil thickness) to $687 (⅓ mil thickness) per pound.

General Properties

The most notable properties of PI are its solvent resistance, barrier properties, and performance at both high and low temperature extremes. For example, Kapton films have performed outstandingly in field applications at temperatures as low as -452°F (-269°C) and as high as 752°F (400°C). Moreover, unfilled PI has a glass transition temperature of 590°F (310°C), heat deflection temperatures up to 660°F (349°C), a maximum recommended continuous service temperature as high as 500°F (260°C), and can withstand short-term exposures at temperatures up to 700°F (371°C). PI naturally has an extremely low flammability, with a limiting oxygen index of 44 and a UL 94 flammability rating of V-0. PI also has good dielectric properties, which remain constant over a wide range of frequencies, good elongation (up to 10%), and good abrasion resistance. PI is chemically resistant to most organic solvents and dilute acids. However, PI is attacked by strong acids and bases, and is soluble in highly polar solvents. PI is very resistant to radiation, but long-term exposure to corona discharge or combinations of ultraviolet radiation, oxygen, and water have a negative effect on its mechanical and physical properties. The major disadvantages of PI are that it is very expensive, very difficult to process, and most types of PI have volatiles or contain solvents which must be vented during curing. A minor disadvantage of PI is that it is only available in dark colors.

Typical Properties of Polyimide (PI)

	American Engineering	SI
Processing Temperature	350°F to 465°F	177°C to 241°C
Linear Mold Shrinkage	0.001 to 0.004 in./in.	0.001 to 0.004 cm/cm
Melting Point	–	–
Density	82.4 to 106.8 lb./ft.^{3}	1.32 to 1.71 g/cm^3
Tensile Strength, Yield	4.7 to 12.6 lb./in.^{2} x 10^3	3.3 to 8.9 kg/cm^2 x 10^2
Tensile Strength, Break	2.8 to 16.0 lb./in.^{2} x 10^3	2.0 to 11.2 kg/cm^2 x 10^2
Elongation, Break	0.5 to 10.0%	0.5 to 10.0%
Tensile Modulus	1.5 to 3.7 lb./in.^{2} x 10^5	1.1 to 2.6 kg/cm^2 x 10^4
Flexural Strength, Yield	1.1 to 3.7 lb./in.^{2} x 10^3	0.8 to 2.6 kg/cm^2 x 10^2
Flexural Modulus	0.9 to 28.0 lb./in.^{2} x 10^5	0.6 to 19.7 kg/cm^2 x 10^4
Compressive Strength	2.0 to 35.1 lb./in.^{2} x 10^3	1.4 to 24.7 kg/cm^2 x 10^2
Izod Notched, R.T.	0.3 to 1.8 ft.-lb./in.	1.4 to 9.7 kg cm/cm
Hardness	M100 - M125 Rockwell	M100 - M125 Rockwell
Thermal Conductivity	1.5 to 4.4 BTU-in./hr-ft.^{2}-°F	0.22 to 0.63 W/m-°K
Linear Thermal Expansion	0.7 to 2.9 in./in.-°F x 10^{-5}	1.3 to 5.2 cm/cm-°C x10^{-5}
Deflection Temperature @ 264 psi	460°F to 660°F	238°C to 349°C
Deflection Temperature @ 66 psi	–	–
Continuous Service Temperature	480°F to 550°F	249°C to 288°C
Dielectric Strength	200 to 700 V/10^{-3} in.	0.8 to 2.7 V/mm x 10^4
Dielectric Constant @ 1 MHz	3.0 to 5.2	3.0 to 5.2
Dissipation Factor @ 1 MHz	0.001 to 0.010	0.001 to 0.010
Water Absorption, 24 hr.	0.27 to 0.97%	0.27 to 0.97%

Typical Applications

- ***Nuclear –*** Valve seats, thermal and electrical insulators, x-ray fluorescent sample holders
- ***Fibers –*** Flame retardant clothing and filters for hot/corrosive liquids and gases
- ***Miscellaneous –*** Washers, wear strips, compressor valves, ultrasonic transmitting components

ADHESIVE SHEAR STRENGTH (psi) (MPa)

Polyimide

		KAPTON HN *5 ml Thick 500 Gauge Film*	**KAPTON HPP-ST** *5 ml Thick 500 Gauge Film*	**KAPTON HPP-FST** *5 ml Thick 500 Gauge Film*	**VESPEL SP-1** *Unfilled*	**VESPEL SP-21** *15% Graphite*	**VESPEL SP-22** *40% Graphite*	**VESPEL SP-211** *15% Graphite 10% PTFE*
Vespel, Kapton courtesy of DuPont Polymers	**Loctite® 380™ Black Max® Instant Adhesive, Rubber Toughened**	>800◆♓○ >5.5◆♓○	>800◆♓○ >5.5◆♓○	>800◆♓○ >5.5◆♓○	1550 10.7	1400 9.7	550 3.8	400 2.8
	Loctite® 401™ Prism® Instant Adhesive, Surface Insensitive *MEDICAL: Loctite® 4011™ Prism® Instant Adhesive, Surface Insensitive*	>800◆○ >5.5◆○	>800◆○ >5.5◆○	>800◆○ >5.5◆○	2200 15.2	2250 15.5	850 5.9	550 3.8
	Loctite® 401™ Prism® Loctite® 770™ Prism® Primer *MEDICAL: Loctite® 4011™ Prism® / Loctite® 7701™ Prism® Primer*	>650◆○ >4.5◆○	>600◆○ >4.1◆○	>450○ >3.1○	350 2.4	850 5.9	400 2.8	600 4.1
	Loctite® 414™ Super Bonder® Instant Adhesive, General Purpose	>800◆○ >5.5◆○	>800◆○ >5.5◆○	>800◆○ >5.5◆○	1650 11.4	2350 16.2	1000 6.9	700 4.8
	Loctite® 330™ Depend® Adhesive, Two-Part No-Mix Acrylic	>800◆○ >5.5◆○	>800◆○ >5.5◆○	>800◆○ >5.5◆○	1150 7.9	550 3.8	500 3.5	200 1.4
	Loctite® 3105™ Light Cure Adhesive, *MEDICAL: Loctite® 3311™ Light Cure Adhesive*	>800◆♓○ >5.5◆♓○	>800◆○ >5.5◆○	>800◆○ >5.5◆○	800 5.5	1000 6.9	250 1.7	200 1.4
	Loctite® 4307™ Flashcure® Light Cure Adhesive	>550◆ >3.8						
	Loctite® H3000™ Speedbonder™ Structural Adhesive, General Purpose	950 6.6						
	Loctite® H4500™ Speedbonder™ Structural Adhesive, Metal Bonder	600 4.1						
	Loctite® 3032™ Adhesive, Polyolefin Bonder	500 3.5						
	Loctite® E-00CL™ Hysol® Epoxy Adhesive, Low Odor	950 6.6						
	Loctite® E-90FL™ Hysol® Epoxy Adhesive, Flexible	>1750◆ >11.7◆						
	Loctite® E-30CL™ Hysol® Epoxy Adhesive, Glass Bonder *MEDICAL: Loctite® M-31CL™ Hysol® Epoxy Adhesive, Glass Bonder*	>1250◆ >8.6◆						
	Loctite® E-20HP™ Hysol® Epoxy Adhesive, Fast Setting *MEDICAL: Loctite® M-21HP™ Hysol® Epoxy Adhesive, Fast Setting*	>1250◆ >8.6◆						
	Loctite® E-214HP™ Hysol® Epoxy Adhesive, High Strength	>950◆ >6.6◆						
	Loctite® Fixmaster® High Performance Epoxy	>1050◆ >7.2◆						
	Loctite® 1942™ Hysol® Hot Melt Adhesive, EVA Based	200 1.4						
	Loctite® 7804™ Hysol® Hot Melt Adhesive	50 0.3						
	Loctite® 3631™ Hysol® Hot Melt Adhesive, Urethane	>550◆ >3.8◆						
	Loctite® U-05FL™ Hysol® Urethane Adhesive, High Strength	850 5.9						
	Loctite® Fixmaster® Rapid Rubber Repair	550 3.8						
	Loctite® 5900® Flange Sealant, Heavy Body RTV Silicone	200 1.4						

Adhesive Performance

Loctite® 401™ Prism® and 414™ Super Bonder® Instant Adhesives achieved the highest bond strengths on the Vespel polyimide. Loctite® 380™ Black Max® Instant Adhesive achieved the second highest bond strength. Loctite® 330™ Depend® Adhesive and Loctite® 3105™ Light Cure Adhesive achieved the lowest bond strengths on Vespel. Loctite® 380™ Black Max®, 401™ Prism® and 414™ Super Bonder® Instant Adhesives, Loctite® 330™ Depend® Adhesive, Loctite® 3105™ and 4307™ Flashcure® Light Cure Adhesives, Loctite® E-90FL™, E-30FL™, E-20HP™ and E-214HP™ Hysol® Epoxy Adhesives, Loctite® Fixmaster® High Performance Epoxy, and Loctite® 3631™ Hysol® Hot Melt Adhesive all achieved substrate failure on the 5 mil (0.005 in) thick Kapton films.

Surface Treatments

The use of Loctite® 770™ Prism® Primer, in conjunction with Loctite® 401™ Prism® Instant Adhesive, or Loctite® 4011™ Prism® Medical Device Instant Adhesive with Loctite® 7701™ Prism® Primer, resulted in either no effect or a statistically significant decrease in the bondability of polyimide.

Other Important Information

- When bonding polyimide films, an accelerator may be necessary to speed the cure of cyanoacrylates.
- Polyimide is compatible with all Loctite® brand adhesives, sealants, primers, and activators.
- Surface cleaners: isopropyl alcohol, Loctite® ODC-Free Cleaner & Degreaser.

NOTES:

◆ The force applied to the tests' specimens exceeded the strength of the material, resulting in substrate failure before the actual bond strength achieved by the adhesive could be determined.

♓ Loctite® 7452™ Tak Pak® Accelerator was used in conjunction with Loctite® 380™ Black Max® Instant Adhesive.

○ The Kapton films were bonded to aluminum lapshears prior to evaluation.

Polymethylpentene (PMP)

Thermoplastic ♹ OTHER

Trade Names

- TPX

Manufacturer

Mitsui Petrochemical

General Description

Polymethylpentene, a member of the polyolefin family, is manufactured by a catalytic polymerization of 4-methylpentene-1. PMP is known for its transparency and extremely low density. PMP is usually compounded with additives and comonomers to enhance its mechanical and optical properties. Specialty grades available include radiation resistant, as well as mica and glass filled. In 2004, the price of PMP ranged approximately from $6.50 to $7.00 per pound at truckload quantities.

General Properties

Polymethylpentene is a highly transparent polyolefin with light transmission values up to 90%. PMP also has a relatively high melting point of approximately 464°F (240°C), and it retains useful mechanical properties at temperatures as high as 401°F (205°C). Although PMP is degraded by sunlight and high energy irradiation, there are grades available which can withstand medical irradiation sterilization. PMP has good electrical properties and chemical resistance; however, it is attacked by strong oxidizing acids. Unfilled polymethylpentene has a specific gravity of 0.83, which makes it one of the lightest thermoplastic resins.

Typical Properties of Polymethylpentene (PMP)

	American Engineering	SI
Processing Temperature	550°F to 600°F	288°C to 316°C
Linear Mold Shrinkage	0.002 to 0.021 in./in.	0.002 to 0.021 cm/cm
Melting Point	450°F to 465°F	232°C to 241°C
Density	51.8 to 66.8 lb./ft.^{3}	0.83 to 1.07 g/cm^3
Tensile Strength, Yield	2.1 to 3.4 lb./in.^{2} x 10^3	1.5 to 2.4 kg/cm^2 x 10^2
Tensile Strength, Break	3.1 to 6.0 lb./in.^{2} x 10^3	2.2 to 4.2 kg/cm^2 x 10^2
Elongation, Break	1.0 to 120.0%	1.0 to 120.0%
Tensile Modulus	0.7 to 6.2 lb./in.^{2} x 10^5	0.5 to 4.4 kg/cm^2 x 10^4
Flexural Strength, Yield	4930 to 7530 psi	34 to 52 MPa
Flexural Modulus	1.8 to 7.2 lb./in.^{2} x 10^5	1.3 to 5.1 kg/cm^2 x 10^4
Compressive Strength	–	–
Izod Notched, R.T.	0.5 to 23.0 ft.-lb./in.	2.7 to 124.2 kg cm/cm
Hardness	R35 - R90 Rockwell	R35 - R90 Rockwell
Thermal Conductivity	–	–
Linear Thermal Expansion	6.0 to 7.0 in./in.-°F x 10^{-5}	10.8 to 12.6 cm/cm-°C x10^{-5}
Deflection Temperature @ 264 psi	150°F to 250°F	66°C to 121°C
Deflection Temperature @ 66 psi	180°F to 250°F	82°C to 121°C
Continuous Service Temperature	–	–
Dielectric Strength	1650 to 1700 V/10^{-3} in.	6.5 to 6.7 V/mm x 10^4
Dielectric Constant @ 1 MHz	2.0 to 2.2	2.0 to 2.2
Dissipation Factor @ 1 MHz	–	–
Water Absorption, 24 hr.	0.01 to 0.15%	0.01 to 0.15%

Typical Applications

- ***Medical –*** Syringes, connector pieces, hollowware, disposable curettes
- ***Lighting –*** Diffusers, lenses, reflectors
- ***Packaging –*** Microwave and hot air oven containers, food trays, coated paper plates
- ***Miscellaneous –*** Liquid level and flow indicators, fluid reservoirs, machine bearing oiler bottles

ADHESIVE SHEAR STRENGTH (psi) (MPa)

Polymethylpentene

TPX RT-18 courtesy of Mitsui Plastics

LOCTITE®	UNFILLED RESIN 3 rms	ROUGHENED 46 rms	ANTIOXIDANT 0.08% Irganox 1010	UV STABILIZER 0.1% Chimasorb 944	FILLER 23% Mica	ANTISTATIC 0.3% Armostat 475
Loctite® 380™ Black Max® Instant Adhesive, Rubber Toughened	>50 >0.3	100 0.7	<50 <0.3	50 0.3	50 0.3	<50 <0.3
Loctite® 401™ Prism® Instant Adhesive, Surface Insensitive *MEDICAL: Loctite® 4011™ Prism® Instant Adhesive, Surface Insensitive*	150 1.0	500 3.5	50 0.3	100 0.7	150 1.0	150 1.0
Loctite® 401™ Prism® Loctite® 770™ Prism® Primer *MEDICAL: Loctite® 4011™ Prism® / Loctite® 7701™ Prism® Primer*	>1900† >13.1†	1000 6.9	>1900† >13.1†	>1900† >13.1†	>1900† >13.1†	>2100† >14.5†
Loctite® 414™ Super Bonder® Instant Adhesive, General Purpose	250 1.7	350 2.4	100 0.7	100 0.7	250 1.7	250 1.7
Loctite® 330™ Depend® Adhesive, Two-Part No-Mix Acrylic	100 0.7	100 0.7	<50 <0.3	<50 <0.3	150 1.0	<50 <0.3
Loctite® 3105™ Light Cure Adhesive, *MEDICAL: Loctite® 3311™ Light Cure Adhesive*	200 1.4	200 1.4	200 1.4	50 0.3	200 1.4	200 1.4
Loctite® 4307™ Flashcure® Light Cure Adhesive	100 0.7					
Loctite® H3000™ Speedbonder™ Structural Adhesive, General Purpose	50 0.3					
Loctite® H4500™ Speedbonder™ Structural Adhesive, Metal Bonder	<50 <0.3					
Loctite® 3032™ Adhesive, Polyolefin Bonder	1900 13.1					
Loctite® E-00CL™ Hysol® Epoxy Adhesive, Low Odor	50 0.3					
Loctite® E-90FL™ Hysol® Epoxy Adhesive, Flexible	50 0.3					
Loctite® E-30CL™ Hysol® Epoxy Adhesive, Glass Bonder *MEDICAL: Loctite® M-31CL™ Hysol® Epoxy Adhesive, Glass Bonder*	100 0.7					
Loctite® E-20HP™ Hysol® Epoxy Adhesive, Fast Setting *MEDICAL: Loctite® M-21HP™ Hysol® Epoxy Adhesive, Fast Setting*	150 1.0					
Loctite® E-214HP™ Hysol® Epoxy Adhesive, High Strength	150 1.0					
Loctite® Fixmaster® High Performance Epoxy	100 0.7					
Loctite® 1942™ Hysol® Hot Melt Adhesive, EVA Based	300 2.1					
Loctite® 7804™ Hysol® Hot Melt Adhesive	<50 <0.3					
Loctite® 3631™ Hysol® Hot Melt Adhesive, Urethane	300 2.1					
Loctite® U-05FL™ Hysol® Urethane Adhesive, High Strength	150 1.0					
Loctite® Fixmaster® Rapid Rubber Repair	150 1.0					
Loctite® 5900® Flange Sealant, Heavy Body RTV Silicone	50 0.3					

Adhesive Performance

Loctite® 401™ Prism® Instant Adhesive, used in conjunction with Loctite® 770™ Prism® Primer, achieved the highest bond strength on PMP, typically substrate failure. Loctite® 3032™ Adhesive also obtained outstanding bond strength on PMP. Because of the low surface energy of PMP, all other adhesives performed poorly.

Surface Treatments

The use of Loctite® 770™ Prism® Primer, in conjunction with Loctite® 401™ Prism® Instant Adhesive, or Loctite® 4011™ Prism® Medical Device Instant Adhesive with Loctite® 7701™ Prism® Primer, caused a dramatic, statistically significant increase in the bondability of PMP. Surface roughening also resulted in a statistically significant increase in the bond strengths achieved on PMP using cyanoacrylate adhesives, but had no statistically significant effect on acrylic adhesives.

Other Important Information

- PMP can be stress cracked by uncured cyaonacrylate adhesives, so any excess adhesive should be removed from the surface immediately.
- PMP is compatible with acrylic adhesives, but can be attacked by their activators before the adhesive has cured. Any excess activator should be removed from the surface immediately.
- PMP is compatible with anaerobic adhesives.
- Surface cleaners: isopropyl alcohol, Loctite® ODC-Free Cleaner & Degreaser.

NOTES:

† Due to the severe deformation of the block shear specimens, testing was stopped before the actual bond strength achieved by the adhesive could be determined (the adhesive bond never failed).

NOT TESTED: Substrate melted at adhesive cure temperature.

☐ The addition of the indicated additive (or surface roughening) caused a statistically significant increase in the bond strength within 95% confidence limits.

Polyphenylene Oxide (PPO)

Thermoplastic ♹ OTHER

Trade Names

- Noryl

Manufacturer

GE Plastics

General Description

PPO is produced by the oxidative coupling of 2,6-dimethyl phenol. The resulting polymer is oxygen linked and properly called poly (2,6-dimethyl phenyl) 1,4-ether. PPO has excellent thermal stability, flame retardance, impact strength, and electrical properties. PPO also has one of the lowest moisture absorption rates found in any engineering thermoplastic. Specialty grades available include graphite/nickel, glass, glass fiber, carbon fiber, and stainless steel filled. In 2004, the price of PPO ranged approximately from $2.00 to $3.76 per pound at truckload quantities.

General Properties

PPO is an engineering thermoplastic known for its excellent radiation resistance, oxidation resistance, thermal stability, and electrical properties. In addition, PPO has outstanding dimensional stability, impact strength at low temperatures, and endurance. Because PPO homopolymer is very difficult to process, PPO is often copolymerized with styrene, or a combination of butadiene and styrene, which facilitates processing and makes a wide range of physical properties available. PPO is chemically resistant to aqueous solutions, acids, bases and salt solutions, but only mildly compatible with oils and greases. PPO is soluble in trichloroethylene, toluene, and ethylene dichloride, and may be stress cracked by other halogenated solvents, esters, and ketones. Due to PPO's thermal stability and low moisture absorption, products made of PPO can be repeatedly steam sterilized without significant degradation and can also be metal-plated.

Typical Properties of Polyphenylene Oxide (PPO)

	American Engineering	SI
Processing Temperature	450°F to 575°F	232°C to 302°C
Linear Mold Shrinkage	0.004 to 0.009 in./in.	0.004 to 0.009 cm/cm
Melting Point	415°F to 500°F	213°C to 260°C
Density	64.9 to 69.3 lb./ft.^{3}	1.04 to 1.11 g/cm^3
Tensile Strength, Yield	4.6 to 10.1 lb./in.^{2} x 10^3	3.2 to 7.1 kg/cm^2 x 10^2
Tensile Strength, Break	4.1 to 9.7 lb./in.^{2} x 10^3	2.9 to 6.8 kg/cm^2 x 10^2
Elongation, Break	4.4 to 85.0%	4.4 to 85.0%
Tensile Modulus	2.9 to 3.8 lb./in.^{2} x 10^5	2.0 to 2.7 kg/cm^2 x 10^4
Flexural Strength, Yield	7.0 to 15.5 lb./in.^{2} x 10^3	4.9 to 10.9 kg/cm^2 x 10^2
Flexural Modulus	2.6 to 3.6 lb./in.^{2} x 10^5	1.8 to 2.5 kg/cm^2 x 10^4
Compressive Strength	7.3 to 16.6 lb./in.^{2} x 10^3	5.1 to 11.7 kg/cm^2 x 10^2
Izod Notched, R.T.	1.5 to 8.3 ft.-lb./in.	8.1 to 44.8 kg cm/cm
Hardness	R115 - R120 Rockwell	R115 - R120 Rockwell
Thermal Conductivity	0.9 to 1.5 BTU-in./hr.-ft.^{2}-°F	0.13 to 0.22 W/m-°K
Linear Thermal Expansion	2.9 to 4.4 in./in.-°F x 10^{-5}	5.2 to 7.9 cm/cm-°C x10^{-5}
Deflection Temperature @ 264 psi	180°F to 450°F	82°C to 232°C
Deflection Temperature @ 66 psi	200°F to 450°F	93°C to 232°C
Continuous Service Temperature	200°F to 250°F	93°C to 121°C
Dielectric Strength	400 to 600 V/10^{-3} in.	1.6 to 2.4 V/mm x 10^4
Dielectric Constant @ 1 MHz	2.0 to 2.8	2.0 to 2.8
Dissipation Factor @ 1 MHz	0.002 to 0.004	0.002 to 0.004
Water Absorption, 24 hr.	0.06 to 0.10%	0.06 to 0.10%

Typical Applications

- ***Telecommunications –*** Television cabinetry, cable splice boxes, wire board frames
- ***Automotive –*** Grilles, spoilers, wheel covers, fuse blocks
- ***Business –*** Personal computers, printers
- ***Machines –*** Bases, video display terminals

ADHESIVE SHEAR STRENGTH (psi) (MPa)

Polyphenylene Oxide

LOCTITE®		**UNFILLED RESIN** *7 rms*	**ROUGHENED** *25 rms*	**LUBRICANT** *9% Polymist F5A*	**FILLER** *9% 489 Fiberglass*	**ANTISTATIC** *55 Larostat HTS-904*
Noryl 731 produced by GE Plastics	**Loctite® 380™ Black Max® Instant Adhesive, Rubber Toughened**	500 3.5	500 3.5	500 3.5	500 3.5	650 4.5
	Loctite® 401™ Prism® Instant Adhesive, Surface Insensitive ***MEDICAL: Loctite® 4011™ Prism® Instant Adhesive, Surface Insensitive***	2500 17.2	2500 17.2	1150 7.9	2500 17.2	850 5.9
	Loctite® 401™ Prism® **Loctite® 770™ Prism® Primer** ***MEDICAL: Loctite® 4011™ Prism® / Loctite® 7701™ Prism® Primer***	1750 12.1	1750 12.1	1000 6.9	1750 12.1	600 4.1
	Loctite® 414™ Super Bonder® Instant Adhesive, General Purpose	1600 11.0	1600 11.0	1000 6.9	1600 11.0	650 4.5
	Loctite® 330™ Depend® Adhesive, Two-Part No-Mix Acrylic	300 2.1	600 4.1	300 2.1	950 6.5	300 2.1
	Loctite® 3105™ Light Cure Adhesive, ***MEDICAL: Loctite® 3311™ Light Cure Adhesive***	950 6.6	950 6.6	950 6.6	500 3.5	950 6.6
Noryl 731-701 Black produced by GE Polymershapes *3 rms*	**Loctite® 4307™ Flashcure® Light Cure Adhesive**	>1750◆ >12.1◆				
	Loctite® H3000™ Speedbonder™ Structural Adhesive, General Purpose	200 1.4				
	Loctite® H4500™ Speedbonder™ Structural Adhesive, Metal Bonder	300 2.1				
	Loctite® 3032™ Adhesive, Polyolefin Bonder	1350 9.3				
	Loctite® E-00CL™ Hysol® Epoxy Adhesive, Low Odor	200 1.4				
	Loctite® E-90FL™ Hysol® Epoxy Adhesive, Flexible	400 2.8				
	Loctite® E-30CL™ Hysol® Epoxy Adhesive, Glass Bonder ***MEDICAL: Loctite® M-31CL™ Hysol® Epoxy Adhesive, Glass Bonder***	850 5.9				
	Loctite® E-20HP™ Hysol® Epoxy Adhesive, Fast Setting ***MEDICAL: Loctite® M-21HP™ Hysol® Epoxy Adhesive, Fast Setting***	450 2.8				
	Loctite® E-214HP™ Hysol® Epoxy Adhesive, High Strength	1650 11.4				
	Loctite® Fixmaster® High Performance Epoxy	550 3.8				
	Loctite® 1942™ Hysol® Hot Melt Adhesive, EVA Based	50 0.3				
	Loctite® 7804™ Hysol® Hot Melt Adhesive	<50 <0.3				
	Loctite® 3631™ Hysol® Hot Melt Adhesive, Urethane	850 5.9				
	Loctite® U-05FL™ Hysol® Urethane Adhesive, High Strength	650 4.5				
	Loctite® Fixmaster® Rapid Rubber Repair	500 3.5				
	Loctite® 5900® Flange Sealant, Heavy Body RTV Silicone	200 1.4				

Adhesive Performance

Loctite® 401™ Prism® and 414™ Super Bonder® Instant Adhesives, Loctite® 4307™ Flashcure® Light Cure Adhesive (substrate failure), Loctite® 3032™ Adhesive, and Loctite® E-214HP™ Hysol® Epoxy Adhesive achieved the highest bond strengths on PPO. Loctite® 3105™ Light Cure Adhesive, Loctite® E-30CL™ and E-20HP™ Hysol® Epoxy Adhesives, Loctite® U-05FL™ Hysol® Urethane Adhesive, Loctite® 3631™ Hysol® Hot Melt Adhesive, Loctite® Fixmaster® High Performance Epoxy, and Loctite® Fixmaster® Rapid Rubber Repair all also exhibited good adhesion to PPO. The addition of an antistatic agent or internal lubricant to PPO was found to cause a statistically significant decrease in the bond strengths achieved by the cyanoacrylate adhesives. However, the addition of antistatic agent was determined to cause a statistically significant increase in the bond strengths achieved by Loctite® 380™ Black Max® Instant Adhesive.

Surface Treatments

Loctite® 770™ Prism® Primer, when used in conjunction with Loctite® 401™ Prism® Instant Adhesive, or Loctite® 4011™ Prism® Medical Device Instant Adhesive with Loctite® 7701™ Prism® Primer, caused a statistically significant decrease in the bond strengths achieved on PPO. Surface roughening caused a statistically significant increase in the bond strengths achieved by Loctite® Depend® 330™ Adhesive, but had no statistically significant effect on any of the other adhesives evaluated.

Other Important Information

- PPO can be stress cracked by uncured cyanoacrylate adhesives, so any excess adhesive should be removed from the surface immediately.
- PPO is compatible with acrylic adhesives, but can be attacked by their activators before the adhesive has cured. Any excess activator should be removed from the surface immediately.
- PPO is incompatible with anaerobic adhesives.
- Surface cleaners: isopropyl alcohol, Loctite® ODC-Free Cleaner & Degreaser.

NOTES:

◆ The force applied to the tests' specimens exceeded the strength of the material, resulting in substrate failure before the actual bond strength achieved by the adhesive could be determined.

🟧 The addition of the indicated additive (or surface roughening) caused a statistically significant decrease in the bond strength within 95% confidence limits.

▨ The addition of the indicated additive (or surface roughening) caused a statistically significant increase in the bond strength within 95% confidence limits.

Polyphenylene Sulfide (PPS)

Thermoplastic 7 OTHER

Trade Names	Manufacturer
• Fortron	Hoechst Celanese
• Hyvex	Ferro Corporation
• Ryton	Phillips 66 Co.
• Supec	GE Plastics
• Tedur	Miles Inc.

General Description

PPS is produced by reacting p-dichlorobenzene with sodium sulfide. The resulting polymer is a crystalline, aromatic polymer whose backbone is composed of benzene rings para-substituted with sulfur atoms. This molecular structure is highly crystalline and extremely stable, which results in the outstanding heat resistance, chemical resistance, and dimensional stability of PPS. Specialty grades available include ground and fibrous glass, mineral, and carbon filled. In 2004, the price of PPS ranged approximately from $3.00 to $6.00 per pound at truckload quantities.

General Properties

The most notable properties of PPS are its thermal stability, inherent flame resistance, and outstanding chemical resistance. PPS also has good mechanical properties which remain stable during both long and short-term exposure to high temperatures. Although the high tensile strength and flexural modulus associated with PPS decrease somewhat with increasing temperature, they level off at approximately 250°F (121°C), and moderately high mechanical properties are maintained up to 500°F (260°C). In addition, PPS also exhibits a significant increase in its elongation and toughness at elevated temperatures. Although PPS has a low impact strength, glass fibers can be added for applications requiring high impact strength and dielectric properties. Glass and mineral fillers are also used for electrical applications where a high arc resistance and low track rate are required. Although PPS is highly chemically resistant – virtually insoluble below 400°F (204°C) – it can be attacked by chlorinated hydrocarbons. PPS is difficult to process, because of the high melt temperatures required, but the extremely crystalline structure of PPS results in high quality molded parts which are uniform and reproducible.

Typical Properties of Polyphenylene Sulfide (PPS)

	American Engineering	SI
Processing Temperature	600°F to 650°F	316°C to 343°C
Linear Mold Shrinkage	0.001 to 0.003 in./in.	0.001 to 0.003 cm/cm
Melting Point	525°F to 600°F	274°C to 316°C
Density	81.2 to 124.9 lb./ft.^{3}	1.30 to 2.00 g/cm^3
Tensile Strength, Yield	1.4 to 29.0 lb./in.^{2} x 10^3	1.0 to 20.4 kg/cm^2 x 10^2
Tensile Strength, Break	6.4 to 29.0 lb./in.^{2} x 10^3	4.5 to 20.4 kg/cm^2 x 10^2
Elongation, Break	1.0 to 4.0%	1.0 to 4.0%
Tensile Modulus	10.0 to 45.0 lb./in.^{2} x 10^5	7.0 to 31.6 kg/cm^2 x 10^4
Flexural Strength, Yield	6.0 to 40.0 lb./in.^{2} x 10^3	4.2 to 28.1 kg/cm^2 x 10^2
Flexural Modulus	1.2 to 2.4 lb./in.^{2} x 10^5	0.8 to 16.9 kg/cm^2 x 10^4
Compressive Strength	16.0 to 28.0 lb./in.^{2} x 10^3	11.2 to 19.7 kg/cm^2 x 10^2
Izod Notched, R.T.	0.6 to 1.9 ft.-lb./in.	3.2 to 10.3 kg cm/cm
Hardness	R116 - R123 Rockwell	R116 - R123 Rockwell
Thermal Conductivity	2.01 to 2.22 BTU-in./hr.-ft.^{2}-°F	0.29 to 0.32 W/m-°K
Linear Thermal Expansion	0.5 to 1.8 in./in.-°F x 10^{-5}	0.9 to 3.2 cm/cm-°C x10^{-5}
Deflection Temperature @ 264 psi	300°F to 550°F	149°C to 288°C
Deflection Temperature @ 66 psi	400°F to 550°F	204°C to 288°C
Continuous Service Temperature	300°F to 450°F	149°C to 232°C
Dielectric Strength	280 to 510 V/10^{-3} in.	1.1 to 2.0 V/mm x 10^4
Dielectric Constant @ 1 MHz	3.4 to 6.0	3.4 to 6.0
Dissipation Factor @ 1 MHz	0.003 to 0.010	0.003 to 0.010
Water Absorption, 24 hr.	0.010 to 0.060%	0.010 to 0.060%

Typical Applications

- ***Chemical –*** Submersible, centrifugal, vane and gear-type processing pumps
- ***Mechanical –*** Hydraulic components, bearings, cams, valves
- ***Small Appliance –*** Hair dryers, small cooking appliances, range components

ADHESIVE SHEAR STRENGTH (psi) (MPa)

Polyphenylene Sulfide

	LOCTITE®	SUPEC GRADE W331 30% Glass Reinforced, PTFE Filled, 9 rms	GRADE W331 ROUGHENED 24 rms	GRADE G301T 30% Glass Reinforced	GRADE G401 65% Glass Reinforced	GRADE G323 65% Glass/Mineral Reinforced	GRADE CTX530 30% Glass Reinforced PPS/PEI Blend
Supec courtesy of GE Plastics	**Loctite® 380™ Black Max® Instant Adhesive, Rubber Toughened**	100 0.7	150 1.0	200 1.4	200 1.4	250 1.7	150 1.0
	Loctite® 401™ Prism® Instant Adhesive, Surface Insensitive *MEDICAL: Loctite® 4011™ Prism® Instant Adhesive, Surface Insensitive*	150 1.0	500 3.5	400 2.8	300 2.1	400 2.8	250 1.7
	Loctite® 401™ Prism® Loctite® 770™ Prism® Primer *MEDICAL: Loctite® 4011™ Prism® / Loctite® 7701™ Prism® Primer*	400 2.8	400 2.8	150 1.0	300 2.1	900 6.2	400 2.8
	Loctite® 414™ Super Bonder® Instant Adhesive, General Purpose	250 1.7	400 2.8	350 2.4	300 2.1	600 4.1	400 2.8
	Loctite® 330™ Depend® Adhesive, Two-Part No-Mix Acrylic	150 1.0	350 2.4	250 1.7	450 3.1	300 2.1	200 1.4
	Loctite® 3105™ Light Cure Adhesive, *MEDICAL: Loctite® 3311™ Light Cure Adhesive*	550 3.8	550 3.8	1200 8.3	1100 7.6	2050 14.1	900 6.2
Supec W331 PPS (⅛" Thick) produced by GE Polymerland *12 rms*	**Loctite® 4307™ Flashcure® Light Cure Adhesive**	800 5.5					
	Loctite® H3000™ Speedbonder™ Structural Adhesive, General Purpose	300 2.1					
	Loctite® H4500™ Speedbonder™ Structural Adhesive, Metal Bonder	200 1.4					
	Loctite® 3032™ Adhesive, Polyolefin Bonder	600 4.1					
	Loctite® E-00CL™ Hysol® Epoxy Adhesive, Low Odor	150 1.0					
	Loctite® E-90FL™ Hysol® Epoxy Adhesive, Flexible	450 3.1					
	Loctite® E-30CL™ Hysol® Epoxy Adhesive, Glass Bonder *MEDICAL: Loctite® M-31CL™ Hysol® Epoxy Adhesive, Glass Bonder*	800 5.5					
	Loctite® E-20HP™ Hysol® Epoxy Adhesive, Fast Setting *MEDICAL: Loctite® M-21HP™ Hysol® Epoxy Adhesive, Fast Setting*	600 4.1					
	Loctite® E-214HP™ Hysol® Epoxy Adhesive, High Strength	1050 7.2					
	Loctite® Fixmaster® High Performance Epoxy	450 3.1					
	Loctite® 1942™ Hysol® Hot Melt Adhesive, EVA Based	100 0.7					
	Loctite® 7804™ Hysol® Hot Melt Adhesive	50 0.3					
	Loctite® 3631™ Hysol® Hot Melt Adhesive, Urethane	700 4.8					
	Loctite® U-05FL™ Hysol® Urethane Adhesive, High Strength	650 4.5					
	Loctite® Fixmaster® Rapid Rubber Repair	400 2.8					
	Loctite® 5900® Flange Sealant, Heavy Body RTV Silicone	100 0.7					

Adhesive Performance

Loctite® 4307™ Flashcure® Light Cure Adhesive and Loctite® E-30CL™ and E-214HP™ Hysol® Epoxy Adhesives achieved the highest bond strength on the standard grade of PPS tested for all adhesives. In general, all the adhesives tested exhibited good adhesion to PPS. The exceptions are Loctite® 380™ Black Max® Instant Adhesive, the three hot melt adhesives and Loctite® 5900™ Flange Sealant.

Surface Treatments

Surface roughening caused a statistically significant increase in the bond strengths achieved by all the adhesives evaluated, with the exception of Loctite® 3105™ Light Cure Adhesive and Loctite® 401™ Prism® Instant Adhesive, both of which experienced no statistically significant change. The use of Loctite® 770™ Prism® Primer, in conjunction with Loctite® 401™ Prism® Instant Adhesive, or Loctite® 4011™ Prism® Medical Device Instant Adhesive with Loctite® 7701™ Prism® Primer, did not produce any statistically significant change in the bondability of PPS.

Other Important Information

- PPS is compatible with all Loctite® brand adhesives, sealants, primers, activators, and accelerators.
- Surface cleaners: isopropyl alcohol, Loctite® ODC-Free Cleaner & Degreaser.

NOTES:

☐ The addition of the indicated additive (or surface roughening) caused a statistically significant increase in the bond strength within 95% confidence limits.

Polypropylene (PP)

Thermoplastic ♷ PP

Trade Names	Manufacturer
• Adpro	Genesis Polymers
• Astryn	Himont USA, Inc.
• Azdel	Azdel, Inc.
• Endura	PPG Industries, Inc.
• Fortilene	Solvay Polymers
• HiGlass	Himont USA, Inc.
• Marlex	Phillips 66 Company
• Moplen	Himont USA, Inc.
• Nortuff	Quantum Chemical
• Petrothene	Quantum Chemical
• Polyfort FPP	A. Schulman, Inc.
• Rexene PP	Rexene
• Tonen	Tonen Petrochem
• Unipol PP	Shell Chemical Company
• Valtec	Himont USA, Inc.

General Description

PP is manufactured by the polymerization of gaseous PP monomer, in the presence of an organometallic catalyst, at low pressure. The key to PP's properties is its crystallinity, which is determined by the degree of organization of the methyl groups on the polymer's backbone. Syndiotactic PP is formed when the methyl groups alternate above and below the plane of the main polymer chain. On the other hand, isotactic PP is formed when the methyl groups all lie above (or below) the plane. Finally, atactic PP results when the methyl groups are randomly positioned. Specialty grades available include calcium carbonate, carbon, copper, glass, mica, mineral, and glass bead filled. In 2004, the price of PP ranged approximately from $0.70 to $10.50 per pound at truckload quantities.

General Properties

PP is known for its good mechanical properties, heat resistance, and chemical resistance. In addition, PP has the highest flexural modulus of the polyolefins, is among the lightest of the engineering thermoplastics (SG=0.90), and has excellent moisture resistance. One of the major disadvantages of PP is its poor impact strength at low temperatures. However, PP/elastomer blends are available with much improved impact resistance. PP's mechanical properties are very dependent on its degree of crystallinity. Isotactic PP is harder, stiffer, and has a higher tensile strength than atactic PP, while atactic PP exhibits better impact strength and elongation under stress. Random copolymers are produced by introducing small amounts of ethylene into the polymerization reactor and result in much improved clarity and toughness at the expense of stiffness. PP is chemically resistant to most substances including nonoxidizing inorganics, detergents, low-boiling hydrocarbons, and alcohols. Unfilled PP is flammable and degraded by UV light; however, flame retardant and UV stabilized grades are available.

Typical Properties of Polypropylene (PP)

	American Engineering	SI
Processing Temperature	390°F to 460°F	199°C to 238°C
Linear Mold Shrinkage	0.011 to 0.020 in./in.	0.011 to 0.020 cm/cm
Melting Point	320°F to 360°F	160°C to 182°C
Density	56.2 to 56.8 lb./ft.^{3}	0.90 to 0.91 g/cm^3
Tensile Strength, Yield	2.8 to 5.4 lb./in.^{2} x 10^3	2.0 to 3.8 kg/cm^2 x 10^2
Tensile Strength, Break	2.5 to 5.4 lb./in.^{2} x 10^3	1.8 to 3.8 kg/cm^2 x 10^2
Elongation, Break	1.8 to 500%	1.8 to 500%
Tensile Modulus	1.4 to 2.1 lb./in.^{2} x 10^5	1.0 to 1.5 kg/cm^2 x 10^4
Flexural Strength, Yield	3.7 to 7.5 lb./in.^{2} x 10^3	2.6 to 5.3 kg/cm^{2}x 10^2
Flexural Modulus	1.1 to 2.5 lb./in.^{2} x 10^5	0.8 to 1.8 kg/cm^2 x 10^4
Compressive Strength	3.5 to 4.7 lb./in.^{2} x 10^3	2.5 to 3.3 kg/cm^{2}x 10^2
Izod Notched, R.T.	0.3 to 1.0 ft.-lb./in.	1.6 to 5.4 kg cm/cm
Hardness	R65 - R105 Rockwell	R65 - R105 Rockwell
Thermal Conductivity	0.8 to 1.6 BTU-in./hr.-ft.^{2}-°F	0.12 to 0.23 W/m-°K
Linear Thermal Expansion	2.1 to 6.5 in./in.-°F x 10^{-5}	3.8 to 11.7 cm/cm-°C x10^{-5}
Deflection Temperature @ 264 psi	140°F to 300°F	60°C to 149°C
Deflection Temperature @ 66 psi	225°F to 310°F	107°C to 154°C
Continuous Service Temperature	200°F to 250°F	90°C to 121°C
Dielectric Strength	580 to 990 V/10^{-3} in.	2.3 to 3.9 V/mm x 10^4
Dielectric Constant @ 1 MHz	2.1 to 2.7	2.1 to 2.7
Dissipation Factor @ 1 MHz	0.0002 to 0.0005	0.0002 to 0.0005
Water Absorption, 24 hr.	0.01 to 0.03%	0.01 to 0.03%

Typical Applications

- ***Fibers –*** Carpet backing, diaper coverstock, rope
- ***Packaging –*** Packaging films, bottles, prescription vials
- ***Appliance –*** Washer agitators, dishwasher components
- ***Miscellaneous –*** Straws, luggage, syringes, toys, storage battery cases

ADHESIVE SHEAR STRENGTH (psi) (MPa)

Polypropylene

Profax 6323 produced by Himont

LOCTITE®	UNFILLED RESIN *5 rms*	ROUGHENED *26 rms*	ANTIOXIDANT *0.1% Irganox 1010 0.3% Cyanox STDP*	UV STABILIZER *0.5% Cyasorb UV531*	IMPACT MODIFIER *9% Novalene EPDM*	FLAME RETARDANT *9% PE-68 4% Antimony Oxide*	SMOKE SUPPRESSANT *13% Firebrake ZB*	LUBRICANT *0.1% Calcium Stearate 24-26*	FILLER *20% Cimpact 600 Talc*	COLORANT *0.1% Watchung Red RT-428-D*	ANTISTATIC *0.2% Armostat 475*
Loctite® 380™ Black Max® Instant Adhesive, Rubber Toughened	50 0.3	50 0.3	50 0.3	50 0.3	50 0.3	50 0.3	50 0.3	50 0.3	50 0.3	50 0.3	50 0.3
Loctite® 401™ Prism® Instant Adhesive, Surface Insensitive *MEDICAL: Loctite® 4011™ Prism® Instant Adhesive, Surface Insensitive*	50 0.3	1950 13.5	1950 13.5	50 0.3	1350 9.3	50 0.3	50 0.3	50 0.3	50 0.3	50 0.3	200 1.4
Loctite® 401™ Prism® Loctite® 770™ Prism® Primer *MEDICAL: Loctite® 4011™ Prism® / Loctite® 7701™ Prism® Primer*	>1950† >13.5†	1300 9.0	>1950† >13.5†	>1950† >13.5†	>1950† >13.5†	>1950† >13.5†	>1950† >13.5†	>1950† >13.5†	>1950† >13.5†	>1950† >13.5†	>1950† >13.5†
Loctite® 414™ Super Bonder® Instant Adhesive, General Purpose	50 0.3	300 2.1	50 0.3	50 0.3	200 1.4	50 0.3	50 0.3	50 0.3	100 0.7	50 0.3	200 1.4
Loctite® 330™ Depend® Adhesive, Two-Part No-Mix Acrylic	200 1.4	200 1.4	200 1.4	200 1.4	200 1.4	200 1.4	200 1.4	200 1.4	200 1.4	200 1.4	200 1.4
Loctite® 3105™ Light Cure Adhesive, *MEDICAL: Loctite® 3311™ Light Cure Adhesive*	100 0.7	450 3.1	100 0.7	100 0.7	100 0.7	250 1.7	100 0.7	100 0.7	100 0.7	100 0.7	100 0.7
Loctite® 4307™ Flashcure® Light Cure Adhesive	200 1.4										
Loctite® H3000™ Speedbonder™ Structural Adhesive, General Purpose	<50 <0.3										
Loctite® H4500™ Speedbonder™ Structural Adhesive, Metal Bonder	<50 <0.3										
Loctite® 3032™ Adhesive, Polyolefin Bonder	1800 12.4										
Loctite® E-00CL™ Hysol® Epoxy Adhesive, Low Odor	150 1.0										
Loctite® E-90FL™ Hysol® Epoxy Adhesive, Flexible	50 0.3										
Loctite® E-30CL™ Hysol® Epoxy Adhesive, Glass Bonder *MEDICAL: Loctite® M-31CL™ Hysol® Epoxy Adhesive, Glass Bonder*	50 0.3										
Loctite® E-20HP™ Hysol® Epoxy Adhesive, Fast Setting *MEDICAL: Loctite® M-21HP™ Hysol® Epoxy Adhesive, Fast Setting*	50 0.3										
Loctite® E-214HP™ Hysol® Epoxy Adhesive, High Strength	50 0.3										
Loctite® Fixmaster® High Performance Epoxy	100 0.7										
Loctite® 1942™ Hysol® Hot Melt Adhesive, EVA Based	250 1.7										
Loctite® 7804™ Hysol® Hot Melt Adhesive	50 0.3										
Loctite® 3631™ Hysol® Hot Melt Adhesive, Urethane	100 0.7										
Loctite® U-05FL™ Hysol® Urethane Adhesive, High Strength	100 0.7										
Loctite® Fixmaster® Rapid Rubber Repair	100 0.7										
Loctite® 5900® Flange Sealant, Heavy Body RTV Silicone	<50 <0.3										

Adhesive Performance

Loctite® 401™ Prism® Instant Adhesive, used in conjunction with Loctite® 770™ Prism® Primer, achieved the highest bond strengths on PP, typically substrate failure. Loctite® 3032™ Adhesive (a polyolefin bonding adhesive) achieved comparable strength but no substrate failure.

Surface Treatments

The use of Loctite® 770™ Prism® Primer, in conjunction with Loctite® 401™ Prism® Instant Adhesive, or Loctite® 4011™ Prism® Medical Device Instant Adhesive with Loctite® 7701™ Prism® Primer, resulted in a dramatic, statistically significant increase in the bond strengths achieved on PP, typically substrate failure. Surface roughening resulted in either no effect or a statistically significant increase in the bond strengths achieved on PP.

Other Important Information

- Polypropylene is compatible with all Loctite® brand adhesives, sealants, primers, and activators.
- Surface cleaners: isopropyl alcohol, Loctite® ODC-Free Cleaner & Degreaser.

NOTES:

† Due to the severe deformation of the block shear specimens, testing was stopped before the actual bond strength achieved by the adhesive could be determined (the adhesive bond never failed).

☐ The addition of the indicated additive (or surface roughening) caused a statistically significant decrease in the bond strength within 95% confidence limits.

☐ The addition of the indicated additive (or surface roughening) caused a statistically significant increase in the bond strength within 95% confidence limits.

Polystyrene (PS)

Thermoplastic

Trade Names	Manufacturer
Dylark	ARCO Chemical
Esbrite	Sumitomo Chemical
Kaofulex	Kaofu Chemical
Polyrex	Chi Mei Industrial
Polysar	Novacor Chemicals
Styron	Dow Chemical
Styronol	Allied Resinous

General Description

The types of polystyrene commercially available can be broken down into three main categories, namely crystal, impact (HIPS), and expandable polystyrene (EPS). Crystal polystyrene is an amorphous polymer produced by the polymerization of styrene monomer at elevated temperatures. It is a rigid, glossy material, with superior clarity, but is limited by poor impact resistance. For applications requiring higher impact resistance, impact polystyrene is used. Impact polystyrene is produced by blending polybutadiene rubber with the polystyrene monomer prior to polymerization. Polystyrene also finds widespread use as “styrofoam.” Styrofoam is predominately produced using expandable polystyrene (EPS) beads. EPS beads are polystyrene beads which contain a blowing agent. When heated, the blowing agent vaporizes, expanding the polystyrene and forming a low density foam. Specialty grades available include ignition resistant, glass fiber, silicone, and calcium carbonate filled. In 2004, the price of PS ranged from $0.70 to $1.25 per pound at truckload quantities.

General Properties

Polystyrene is known for its optical clarity, rigidity, and ability to be processed by all thermoplastic processes. Flexural modulii as high as approximately 500,000 psi (35,000 kg/cm^2), a tensile strength of 8,000 psi, and an elongation generally between 3% and 5% are typical of crystal polystyrene. However, the impact resistance of crystal polystyrene is very low, usually between 0.3 to 0.5 ft.-lb./in. (1.62 to 2.7 kg cm/cm). Impact resistant grades are available with elongations of up to 50%, and notched izod impact strengths as high as 5 ft.-lb./in. (27 kg cm/cm), but the optical clarity and tensile strength decrease. Crystal grades of polystyrene transmit up to 90% of visible light, but are susceptible to weathering and ultraviolet light degradation. Protective coatings or UV stabilizers are recommended for outdoor applications. In general, polystyrene has poor solvent resistance and is attacked by hydrocarbons, phenols, ketones, esters, ethers, and some acids. Due to its low melting point, polystyrene is not recommended for use in high temperature applications. Polystyrene is a good insulator and has a low dielectric loss factor.

Typical Properties of Polystyrene (PS)

	American Engineering	SI
Processing Temperature	300°F to 500°F	149°C to 260°C
Linear Mold Shrinkage	0.002 to 0.008 in./in.	0.002 to 0.008 cm/cm
Melting Point	212°F to 545°F	100°C to 241°C
Density	63.7 to 66.2 lb./ft.^{3}	1.02 to 1.06 g/cm^3
Tensile Strength, Yield	2.4 to 6.2 lb./in.^{2} x 10^3	1.7 to 4.4 kg/cm^2 x 10^2
Tensile Strength, Break	2.7 to 7.6 lb./in.^{2} x 10^3	1.9 to 5.3 kg/cm^2 x 10^2
Elongation, Break	2.0 to 80.0%	2.0 to 80.0%
Tensile Modulus	2.2 to 4.8 lb./in.^{2} x 10^5	1.5 to 3.4 kg/cm^2 x 10^4
Flexural Strength, Yield	4.3 to 13.0 lb./in.^{2} x 10^3	3.0 to 9.1 kg/cm^2 x 10^2
Flexural Modulus	2.0 to 4.8 lb./in.^{2} x 10^5	1.4 to 3.4 kg/cm^2 x 10^4
Compressive Strength	7.0 to 12.0 lb./in.^{2} x 10^3	4.9 to 8.4 kg/cm^2 x 10^2
Izod Notched, R.T.	0.2 to 2.2 ft.-lb./in.	1.1 to 11.9 kg cm/cm
Hardness	M50 - M100 Rockwell	M50 - M100 Rockwell
Thermal Conductivity	1.4 to 3.0 BTU-in./hr.-ft.^{2}-°F	0.20 to 0.43 W/m-°K
Linear Thermal Expansion	3.7 to 8.4 in./in.-°F x 10^{-5}	6.7 to 15.1 cm/cm-°C x10^{-5}
Deflection Temperature @ 264 psi	150°F to 275°F	66°C to 135°C
Deflection Temperature @ 66 psi	170°F to 275°F	77°C to 135°C
Continuous Service Temperature	–	–
Dielectric Strength	300 to 575 V/10^{-3} in.	1.2 to 2.3 V/mm x 10^4
Dielectric Constant @ 1 MHz	2.5 to 2.6	2.5 to 2.6
Dissipation Factor @ 1 MHz	0.0001 to 0.0010	0.0001 to 0.0010
Water Absorption, 24 hr.	0.05 to 0.10%	0.05 to 0.10%

Typical Applications

- ***Packaging –*** Processed food and produce containers, foam for meat and produce trays
- ***Construction –*** Window moldings and frames, doors and door frames, footing profiles, structural foam sections for insulating walls
- ***Household –*** Styrofoam plates, toys, food containers, television housings
- ***Medical –*** Labware, diagnostic equipment, tissue culture flasks, vacuum canisters

Polystyrene

	LOCTITE®	UNFILLED RESIN 4 rms	ROUGHENED 32 rms	ANTIOXIDANT 0.06% Irganox 245 0.02% Irganox 1076	UV STABILIZER 0.31% Tinuvin 328 0.31% Tinuvin 770	IMPACT MODIFIER 15% Kraton D1101	FLAME RETARDANT 4% Saytex HBCD-SF 1% Antimony Oxide	LUBRICANT 0.5% Zinc Stearate	COLORANT 4% CP204230
XC2245-HIY-9100 produced by Huntsman	**Loctite® 380™ Black Max® Instant Adhesive, Rubber Toughened**	450 3.1	750 5.2	450 3.1	450 3.1	900 6.2	450 3.1	450 3.1	450 3.1
	Loctite® 401™ Prism® Instant Adhesive, Surface Insensitive *MEDICAL: Loctite® 4011™ Prism® Instant Adhesive, Surface Insensitive*	1350 9.3	>800◆ >5.5◆	>1450◆ >10.0◆	1350 9.3	>2100◆ >14.5◆	750 5.2	>1200◆ >8.3◆	450 3.1
	Loctite® 401™ Prism® Loctite® 770™ Prism® Primer *MEDICAL: Loctite® 4011™ Prism® / Loctite® 7701™ Prism® Primer*	>1750◆ >12.1◆	750 5.2	>3300◆ >22.8◆	>1750◆ >12.1◆	>1750◆ >12.1◆	>1750◆ >12.1◆	>1750◆ >12.1◆	1500 10.3
	Loctite® 414™ Super Bonder® Instant Adhesive, General Purpose	500 3.5	800 5.5	1250 8.6	500 3.5	>2300◆ >15.9◆	>850◆ >5.9◆	500 3.5	500 3.5
	Loctite® 330™ Depend® Adhesive, Two-Part No-Mix Acrylic	350 2.4	350 2.4	350 2.4	350 2.4	150 1.0	50 0.3	50 0.3	350 2.4
	Loctite® 3105™ Light Cure Adhesive, *MEDICAL: Loctite® 3311™ Light Cure Adhesive*	1350 9.3	1350 9.3	1350 9.3	500 3.5	>2000◆ >13.8◆	1350 9.3	1350 9.3	1000 6.9
GP CPS 2511 courtesy of Nova Chemicals 2 rms	**Loctite® 4307™ Flashcure® Light Cure Adhesive**	>950◆ >6.6◆							
	Loctite® H3000™ Speedbonder™ Structural Adhesive, General Purpose	700 4.8							
	Loctite® H4500™ Speedbonder™ Structural Adhesive, Metal Bonder	550 3.8							
	Loctite® 3032™ Adhesive, Polyolefin Bonder	900 6.2							
	Loctite® E-00CL™ Hysol® Epoxy Adhesive, Low Odor	350 2.4							
	Loctite® E-90FL™ Hysol® Epoxy Adhesive, Flexible	250 1.7							
	Loctite® E-30CL™ Hysol® Epoxy Adhesive, Glass Bonder *MEDICAL: Loctite® M-31CL™ Hysol® Epoxy Adhesive, Glass Bonder*	500 3.5							
	Loctite® E-20HP™ Hysol® Epoxy Adhesive, Fast Setting *MEDICAL: Loctite® M-21HP™ Hysol® Epoxy Adhesive, Fast Setting*	300 2.1							
	Loctite® E-214HP™ Hysol® Epoxy Adhesive, High Strength	NOT TESTED							
	Loctite® Fixmaster® High Performance Epoxy	250 1.7							
	Loctite® 1942™ Hysol® Hot Melt Adhesive, EVA Based	300 2.1							
	Loctite® 7804™ Hysol® Hot Melt Adhesive	<50 <0.3							
	Loctite® 3631™ Hysol® Hot Melt Adhesive, Urethane	700 4.8							
	Loctite® U-05FL™ Hysol® Urethane Adhesive, High Strength	200 1.4							
	Loctite® Fixmaster® Rapid Rubber Repair	400 2.8							
	Loctite® 5900® Flange Sealant, Heavy Body RTV Silicone	100 0.7							

Adhesive Performance

Loctite® 401™ Prism® Instant Adhesive, when used in conjunction with Loctite® 770™ Prism® Primer, and Loctite® 4307™ Flashcure® Light Cure Adhesive achieved the highest bond strengths on PS, typically substrate failure. Loctite® 401™ Prism® Instant Adhesive, Loctite® 3105™ Light Cure Adhesive, Loctite® 3032™ Adhesive, and Loctite® 3631™ Hysol® Hot Melt Adhesive achieved the second highest bond strengths. Loctite® 7804™ Hysol® Hot Melt Adhesive obtained the lowest bond strength. The addition of an impact modifier additive increased the bondability of PS with cyanoacrylate and light curing acrylic adhesives.

Surface Treatments

The use of Loctite® 770™ Prism® Primer, when used in conjunction with Loctite® 401™ Prism® Instant Adhesive, or Loctite® 4011™ Prism® Medical Device Instant Adhesive with Loctite® 7701™ Prism® Primer, caused a statistically significant increase in the bondability of all the formulations of PS evaluated, except for the roughened PS, where Prism® Loctite® 770™ or 7701™ Prism® Primers caused a statistically significant decrease in its bondability. Surface roughening caused a statistically significant increase in the bond strengths achieved on unprimed PS when using cyanoacrylate adhesives, but had no statistically significant effect when using acrylic adhesives.

Other Important Information

- Polystyrene is compatible with acrylic adhesives, but can be attacked by their activators before the adhesive has cured. Any excess activator should be removed from the surface immediately.
- Polystyrene is incompatible with anaerobic adhesives.
- Surface cleaners: isopropyl alcohol, Loctite® ODC-Free Cleaner & Degreaser.

NOTES:

◆ The force applied to the tests' specimens exceeded the strength of the material, resulting in substrate failure before the actual bond strength achieved by the adhesive could be determined.

NOT TESTED: Substrate melted at adhesive cure temperature.

☐ The addition of the indicated additive (or surface roughening) caused a statistically significant decrease in the bond strength within 95% confidence limits.

☐ The addition of the indicated additive (or surface roughening) caused a statistically significant increase in the bond strength within 95% confidence limits.

Polyurethane (PU)

Thermoplastic ♹ OTHER

Trade Names	Manufacturer
• Bayflex	Bayer Corporation
• Estane	B. F. Goodrich Chemical
• Isoplast	Dow Chemical
• Mor-Thane	Morton
• Neuthane	New England Urethane
• Pellethane	Dow Chemical
• Tecoflex	Thermedics Inc.
• Tecothane	Thermedics Inc.
• Texin	Bayer Corporation

General Description

Polyurethanes are produced by the condensation reaction of an isocyanate and a material with a hydroxyl functionality, such as a polyol. PU can have the chemical structure of either a thermoplastic or thermoset and can have the physical structure of a rigid solid, a soft elastomer, or a foam. The chemical composition of PU can also vary widely, depending on the specific polyol and isocyanate bearing species which are reacted to form the PU. The many different chemical structures and physical forms possible for PU make it a versatile, widely used polymer. Specialty grades available include flame retardant, clay, silica, and glass filled. In 2004, the price of PU ranged approximately from $1.20 to $6.50 per pound at truckload quantities.

General Properties

The major benefits offered by PU are that it retains its high impact strength at low temperatures, it is readily foamable, and it is resistant to abrasion, tear propagation, ozone, oxidation, fungus, and humidity. Although thermoplastic PU is attacked by steam, fuels, ketones, esters and strong acids and bases, it is resistant to aliphatic hydrocarbons and dilute acids and bases. The highest recommended use temperature of thermoplastic PU is approximately 220°F (104°C), rendering it inappropriate for most high temperature applications. Furthermore, thermoplastic PU has poor weatherability stemming from its poor resistance to UV degradation. Since PU can be painted with flexible PU paints without pretreatment, it has found use in many automotive exterior parts.

Typical Properties of Polyurethane (PU)

	American Engineering	SI
Processing Temperature	385°F to 450°F	196°C to 232°C
Linear Mold Shrinkage	0.004 to 0.014 in./in.	0.004 to 0.014 cm/cm
Melting Point	400°F to 450°F	204°C to 232°C
Density	69.9 to 77.4 lb./ft.^{3}	1.12 to 1.24 g/cm^3
Tensile Strength, Yield	4.9 to 35.0 lb./in.^{2} x 10^3	3.4 to 24.6 kg/cm^2 x 10^2
Tensile Strength, Break	4.9 to 35.0 lb./in.^{2} x 10^3	3.4 to 24.6 kg/cm^2 x 10^2
Elongation, Break	100 to 500%	100 to 500%
Tensile Modulus	0.6 to 45.0 lb./in.^{2} x 10^5	0.4 to 31.6 kg/cm^2 x 10^4
Flexural Strength, Yield	6.0 to 60.0 lb./in.^{2} x 10^3	4.2 to 42.2 kg/cm^2 x 10^2
Flexural Modulus	0.1 to 0.4 lb./in.^{2} x 10^5	0.0 to 0.2 kg/cm^2 x 10^4
Compressive Strength	1.2 to 29.5 lb./in.^{2} x 10^3	0.8 to 20.7 kg/cm^2 x 10^2
Izod Notched, R.T.	1.5 to (No Break) ft.-lb./in.	8.1 to (No Break) kg cm/cm
Hardness	A55 - A95 Rockwell	A55 - A95 Rockwell
Thermal Conductivity	1.7 to 2.3 BTU-in./hr.-ft.^{2}-°F	0.25 to 0.33 W/m-°K
Linear Thermal Expansion	1.8 to 8.4 in./in.-°F x 10^{-5}	3.2 to 15.1 cm/cm-°C x10^{-5}
Deflection Temperature @ 264 psi	100°F to 330°F	38°C to 166°C
Deflection Temperature @ 66 psi	115°F to 370°F	46°C to 188°C
Continuous Service Temperature	180°F to 220°F	82°C to 104°C
Dielectric Strength	430 to 730 V/10^{-3} in.	1.7 to 2.9 V/mm x 10^4
Dielectric Constant @ 1 MHz	4.4 to 5.1	4.4 to 5.1
Dissipation Factor @ 1 MHz	0.060 to 0.100	0.060 to 0.100
Water Absorption, 24 hr.	0.10 to 0.60%	0.10 to 0.60%

Typical Applications

- ***Automotive –*** Fascias, padding, seats, gaskets, body panels, bumpers
- ***Medical –*** Implantable devices, tubing, blood bags, dialysis membrane
- ***Machinery –*** Bearings, nuts, wheels, seals, tubing
- ***Consumer –*** Furniture padding, mattress goods, roller skate wheels, athletic shoes

ADHESIVE SHEAR STRENGTH (psi) (MPa)

Polyurethane

Pellethane 2363-55 courtesy of Dow Chemical

LOCTITE®	**UNFILLED RESIN (SHORE D)** *14 rms*	**ROUGHENED** *167 rms*	**UV STABILIZER** *1% Tinuvin 328*	**FLAME RETARDANT** *15% BT-93 2% Antimony Oxide*	**PLASTICIZER** *13% TP-95*	**LUBRICANT #1** *0.5% Mold Wiz INT-33PA*	**LUBRICANT #2** *0.5% FS1235 Silicone*	**UNFILLED RESIN (SHORE A)** *Estrane 58630 B.F. Goodrich*
Loctite® 380™ Black Max® Instant Adhesive, Rubber Toughened	200 1.4	350 2.4	100 0.7	200 1.4	50 0.3	200 1.4	450 3.1	200 1.4
Loctite® 401™ Prism® Instant Adhesive, Surface Insensitive *MEDICAL: Loctite® 4011™ Prism® Instant Adhesive, Surface Insensitive*	350 2.4	1350 9.3	200 1.4	450 3.1	150 1.0	800 5.5	>2250† >15.5†	>850† >5.9†
Loctite® 401™ Prism® **Loctite® 770™ Prism® Primer** *MEDICAL: Loctite® 4011™ Prism® / Loctite® 7701™ Prism® Primer*	1400 9.7	1950 13.5	950 6.6	>1850† >12.8†	>750† >5.2†	>2150† >14.8†	>2900† >20.0†	>1300† >9.0†
Loctite® 414™ Super Bonder® Instant Adhesive, General Purpose	350 2.4	1300 9.0	150 1.0	600 4.1	150 1.0	700 4.8	1250 8.6	550 3.8
Loctite® 330™ Depend® Adhesive, Two-Part No-Mix Acrylic	350 2.4	1500 10.3	350 2.4	>1400† >9.7†	200 1.4	900 6.2	>2650† >18.3†	450 3.1
Loctite® 3105™ Light Cure Adhesive, *MEDICAL: Loctite® 3311™ Light Cure Adhesive*	1150 7.9	1700 11.7	750 5.2	>1350† >9.3†	450 3.1	>1800† >12.4†	>2350† >16.2†	800 5.5
Loctite® 4307™ Flashcure® Light Cure Adhesive	750 5.2							
Loctite® H3000™ Speedbonder™ Structural Adhesive, General Purpose	350 2.4							
Loctite® H4500™ Speedbonder™ Structural Adhesive, Metal Bonder	700 4.8							
Loctite® 3032™ Adhesive, Polyolefin Bonder	700 4.8							
Loctite® E-00CL™ Hysol® Epoxy Adhesive, Low Odor	400 2.8							
Loctite® E-90FL™ Hysol® Epoxy Adhesive, Flexible	750 5.2							
Loctite® E-30CL™ Hysol® Epoxy Adhesive, Glass Bonder *MEDICAL: Loctite® M-31CL™ Hysol® Epoxy Adhesive, Glass Bonder*	750 5.2							
Loctite® E-20HP™ Hysol® Epoxy Adhesive, Fast Setting *MEDICAL: Loctite® M-21HP™ Hysol® Epoxy Adhesive, Fast Setting*	500 3.5							
Loctite® E-214HP™ Hysol® Epoxy Adhesive, High Strength	600 4.1							
Loctite® Fixmaster® High Performance Epoxy	800 5.5							
Loctite® 1942™ Hysol® Hot Melt Adhesive, EVA Based	50 0.3							
Loctite® 7804™ Hysol® Hot Melt Adhesive	100 0.7							
Loctite® 3631™ Hysol® Hot Melt Adhesive, Urethane	950 6.6							
Loctite® U-05FL™ Hysol® Urethane Adhesive, High Strength	700 4.8							
Loctite® Fixmaster® Rapid Rubber Repair	250 1.7							
Loctite® 5900® Flange Sealant, Heavy Body RTV Silicone	100 0.3							

Adhesive Performance

Loctite® 401™ Prism® Instant Adhesive, used in conjunction with Loctite® 770™ Prism® Primer, created bonds which were stronger than the substrate for most of the polyurethane formulations which were evaluated. Typically, most of the adhesives tested achieved good bond strengths. Loctite® 1942™ Hysol® Hot Melt Adhesive achieved the lowest bond strength on unfilled polyurethane.

Surface Treatments

The use of Loctite® 770™ Prism® Primer, in conjunction with Loctite® 401™ Prism® Instant Adhesive, or Loctite® 4011™ Prism® Medical Device Instant Adhesive with Loctite® 7701™ Prism® Primer, resulted in a large, statistically significant increase in the bond strengths achieved on polyurethane. Surface roughening also resulted in a statistically significant increase in the bond strengths achieved on polyurethane for all the adhesives which were evaluated.

Other Important Information

- Polyurethane can be stress cracked by uncured cyanoacrylate adhesives, so any excess adhesive should be removed from the surface immediately.
- Polyurethane is compatible with acrylic adhesives, but can be attacked by their activators before the adhesive has cured. Any excess activator should be removed from the surface immediately.
- Polyurethane is incompatible with anaerobic adhesives.
- Surface cleaners: isopropyl alcohol, Loctite® ODC-Free Cleaner & Degreaser.

NOTES:

† Due to the severe deformation of the block shear specimens, testing was stopped before the actual bond strength achieved by the adhesive could be determined (the adhesive bond never failed).

🟧 The addition of the indicated additive (or surface roughening) caused a statistically significant decrease in the bond strength within 95% confidence limits.

▨ The addition of the indicated additive (or surface roughening) caused a statistically significant increase in the bond strength within 95% confidence limits.

Polyvinyl Chloride (PVC)

Thermoplastic ♵

Trade Names	Manufacturer
• Alpha	Dexter Plastics
• Fiberloc	B. F. Goodrich
• Geon	B. F. Goodrich
• Novablend	Novatec Plastics
• Polyvin	A. Schulman
• Quirvil	Rukmianca SpA
• Superkleen	Alpha Chemical
• Tenneco	Rimtech Corporation
• Unichem	Colorite Plastics
• Vythene	Alpha Chemical

General Description

Polyvinyl chloride, the most widely used of the vinyl resins, is formed via the free radical polymerization of vinyl chloride monomer. Unmodified PVC is a hard, brittle, glass-like material which is unsuitable for most engineering applications. However, the addition of plasticizers, such as dioctyl phthalate (DOP), give PVC sufficient flexibility to be used for many applications. PVC is one of the most economical and versatile plastics in use today. It has become a very popular construction material, with major applications including piping and home siding. Specialty grades available include impact modified, filled, pigmented, and flame retardant. In 2004, the prices of PVC ranged approximately from $0.60 to $1.50 per pound at truckload quantities.

General Properties

Polyvinyl chloride offers good physical properties at a fraction of the cost of some of the more expensive engineering resins. A wide variety of fillers and additives are commonly used with PVC to tailor its characteristics to meet the needs of the end user. PVC is resistant to water, weathering and corrosion, has a high strength-to-weight ratio, and is a good electrical and thermal insulator. Most grades of PVC are non-flammable and receive a UL94 rating of V-0. With a maximum recommended continuous service temperature no higher than 220°F (104°C), PVC is not recommended for high temperature applications. It has good resistance to alcohols, mild acids and bases, and salts, but is attacked by halogenated hydrocarbons, phenols, ketones, esters, and ethers. PVC is easily processed by a wide variety of thermoplastic methods, however, stabilizers must be added to scavenge the HCl released during high temperature processing which could degrade the resin.

Typical Properties of Polyvinyl Chloride (PVC)

	American Engineering	SI
Processing Temperature	315°F to 410°F	157°C to 210°C
Linear Mold Shrinkage	0.001 to 0.005 in./in.	0.001 to 0.005 cm/cm
Melting Point	270°F to 405°F	132°C to 207°C
Density	72.4 to 91.8 lb./ft.^{3}	1.16 to 1.47 g/cm^3
Tensile Strength, Yield	1.3 to 7.4 lb./in.^{2} x 10^3	0.9 to 5.2 kg/cm^2 x 10^2
Tensile Strength, Break	1.1 to 7.4 lb./in.^{2} x 10^3	0.8 to 5.2 kg/cm^2 x 10^2
Elongation, Break	5.0 to 500.0%	5.0 to 500.0%
Tensile Modulus	2.7 to 4.5 lb./in.^{2} x 10^5	1.9 to 3.2 kg/cm^2 x 10^4
Flexural Strength, Yield	10.7 to 12.0 lb./in.^{2} x 10^3	7.5 to 8.4 kg/cm^2 x 10^2
Flexural Modulus	3.0 to 5.4 lb./in.^{2} x 10^5	2.1 to 3.8 kg/cm^2 x 10^4
Compressive Strength	6.5 to 10.1 lb./in.^{2} x 10^3	4.6 to 7.1 kg/cm^2 x 10^2
Izod Notched, R.T.	0.3 to 17.6 ft.-lb./in.	1.6 to 95.0 kg cm/cm
Hardness	A50 - A95 Rockwell	A50 - A95 Rockwell
Thermal Conductivity	1.0 to 1.3 BTU-in./hr.-ft.^{2}-°F	0.14 to 0.19 W/m-°K
Linear Thermal Expansion	3.6 to 7.3 in./in.-°F x 10^{-5}	6.5 to 13.1 cm/cm-°C x10^{-5}
Deflection Temperature @ 264 psi	100°F to 311°F	38°C to 155°C
Deflection Temperature @ 66 psi	113°F to 311°F	45°C to 155°C
Continuous Service Temperature	130°F to 220°F	54°C to 104°C
Dielectric Strength	350 to 725 V/10^{-3} in.	1.4 to 2.8 V/mm x 10^4
Dielectric Constant @ 1 MHz	3.9 to 5.2	3.9 to 5.2
Dissipation Factor @ 1 MHz	0.019 to 0.090	0.019 to 0.090
Water Absorption, 24 hr.	0.08 to 0.60%	0.08 to 0.60%

Typical Applications

- ***Construction –*** Water supply, agricultural irrigation and chemical processing piping, siding, window sashes, gutters, interior moldings, flooring
- ***Packaging –*** Films for food wrap, bottles, food containers
- ***Consumer goods –*** Furniture parts, wall coverings, upholstery, sporting goods, toys
- ***Medical –*** Tubing, blood and solution bags, dialysis devices, connectors

ADHESIVE SHEAR STRENGTH (psi) (MPa)

Polyvinyl Chloride

		UNFILLED RESIN 3 rms	ROUGHENED 27 rms	UV STABILIZER 1% UV-531	IMPACT MODIFIER 7% Paraloid BTA753	FLAME RETARDANT 0.3% Antimony Oxide	SMOKE SUPPRESSANT 0.3% Ammonium Octamolybdate	LUBRICANT 1% Calcium Stearate 24-46	FILLER % OmyaCarb F	PLASTICIZER 5% Drapex 6.8	COLORANT 0.5% FD&C Blue #1	ANTISTATIC 1.5% Markstat AL48
Oxychem 160 produced by Occidental Chemical	**Loctite® 380™ Black Max® Instant Adhesive, Rubber Toughened**	>1600◆ >11.0◆	>1600◆ >11.0◆	>1600◆ >11.0◆	>1100◆ >7.6◆	>1600◆ >11.0◆	1250 8.6	>1600◆ >11.0◆	>1600◆ >11.0◆	>1600◆ >11.0◆	>1600◆ >11.0◆	>1600◆ >11.0◆
	Loctite® 401™ Prism® Instant Adhesive, Surface Insensitive *MEDICAL: Loctite® 4011™ Prism® Instant Adhesive, Surface Insensitive*	>3650◆ >25.2◆	>1850◆ >12.8◆	>2800◆ >19.3◆	>4300◆ >29.7◆	>3050◆ >21.0◆	>3650◆ >25.2◆	>3650◆ >25.2◆	>4250◆ >29.3◆	>2250◆ >15.5◆	>3650◆ >25.2◆	>3650◆ >25.2◆
	Loctite® 401™ Prism® Loctite® 770™ Prism® Primer *MEDICAL: Loctite® 4011™ Prism® / Loctite® 7701™ Prism® Primer*	>2850◆ >19.7◆	>1400◆ >9.7◆	>1400◆ >9.7◆	>3650◆ >25.2◆	>2850◆ >19.7◆	>2850◆ >19.7◆	>2850◆ >19.7◆	>1750◆ >12.1◆	>1550◆ >10.7◆	>2850◆ >19.7◆	>1200◆ >8.3◆
	Loctite® 414™ Super Bonder® Instant Adhesive, General Purpose	>2900◆ >20.0◆	>2900◆ >20.0◆	>2900◆ >20.0◆	>2900◆ >20.0◆	>2900◆ >20.0◆	>2900◆ >20.0◆	>2900◆ >20.0◆	>4400◆ >30.3◆	>2900◆ >20.0◆	>2900◆ >20.0◆	>2900◆ >20.0◆
	Loctite® 330™ Depend® Adhesive, Two-Part No-Mix Acrylic	>2650◆ >18.3◆	>1550◆ >10.7◆	>1850◆ >12.8◆	1050◆ 7.2◆	>2050◆ >14.1◆	>1800◆ >12.4◆	>1900◆ >13.1◆	>2650◆ >18.3◆	>1500◆ >10.3◆	>1050◆ >7.2◆	>900◆ >6.2◆
	Loctite® 3105™ Light Cure Adhesive, *MEDICAL: Loctite® 3311™ Light Cure Adhesive*	>2550◆ >17.6◆	>2550◆ >17.6◆	>2550◆ >17.6◆	>3000◆ >20.7◆	>2550◆ >17.6◆	>2550◆ >17.6◆	>2550◆ >17.6◆	>3150◆ >21.7◆	>2550◆ >17.6◆	>2550◆ >17.6◆	>2550◆ >17.6◆
	Loctite® 4307™ Flashcure® Light Cure Adhesive	>2800◆ >19.3◆										
	Loctite® H3000™ Speedbonder™ Structural Adhesive, General Purpose	2350 16.2										
	Loctite® H4500™ Speedbonder™ Structural Adhesive, Metal Bonder	900 6.2										
	Loctite® 3032™ Adhesive, Polyolefin Bonder	1450 10.0										
	Loctite® E-00CL™ Hysol® Epoxy Adhesive, Low Odor	400 2.8										
	Loctite® E-90FL™ Hysol® Epoxy Adhesive, Flexible	1600 11.0										
	Loctite® E-30CL™ Hysol® Epoxy Adhesive, Glass Bonder *MEDICAL: Loctite® M-31CL™ Hysol® Epoxy Adhesive, Glass Bonder*	1350 9.3										
	Loctite® E-20HP™ Hysol® Epoxy Adhesive, Fast Setting *MEDICAL: Loctite® M-21HP™ Hysol® Epoxy Adhesive, Fast Setting*	250 1.7										
	Loctite® E-214HP™ Hysol® Epoxy Adhesive, High Strength	NOT TESTED										
	Loctite® Fixmaster® High Performance Epoxy	700 4.8										
	Loctite® 1942™ Hysol® Hot Melt Adhesive, EVA Based	300 2.1										
	Loctite® 7804™ Hysol® Hot Melt Adhesive	150 1.0										
	Loctite® 3631™ Hysol® Hot Melt Adhesive, Urethane	>4300◆ >29.7◆										
	Loctite® U-05FL™ Hysol® Urethane Adhesive, High Strength	850 5.9										
	Loctite® Fixmaster® Rapid Rubber Repair	1050 7.2										
	Loctite® 5900® Flange Sealant, Heavy Body RTV Silicone	150 1.0										

Adhesive Performance

Loctite® 380™ Black Max®, 401™ Prism® and 414™ Super Bonder® Instant Adhesives, Loctite® 330™ Depend® Adhesive, and Loctite® 4307™ Flashcure® and 3105™ Light Cure Adhesives all created bonds which were stronger than the rigid PVC substrate for most of the formulations tested. Excellent bond strength was also obtained on PVC by Loctite® H3000™ Speedbonder™ Structural Adhesive, Loctite® 3032™ Adhesive, Loctite® E-90FL™ and E-30CL™ Hysol® Epoxy Adhesives, Loctite® 3631™ Hysol® Hot Melt Adhesive and Loctite® Fixmaster® Rapid Rubber Repair.

Surface Treatments

Surface roughening and/or the use of Loctite® 770™ or 7701™ Prism® Primers resulted in either no statistically significant effect or in the rigid PVC failing at a statistically significant lower bond strength than the untreated PVC.

Other Important Information

- PVC can be stress cracked by uncured cyanoacrylate adhesives, so any excess adhesive should be removed from the surface immediately.
- PVC is compatible with acrylic adhesives, but can be attacked by their activators before the adhesive has cured. Any excess activator should be removed from the surface of the PVC immediately.
- PVC is incompatible with anaerobic adhesives.
- Surface cleaners: isopropyl alcohol, Loctite® ODC-Free Cleaner & Degreaser.

NOTES:

◆ The force applied to the tests' specimens exceeded the strength of the material, resulting in substrate failure before the actual bond strength achieved by the adhesive could be determined.

NOT TESTED: Substrate melted at adhesive cure temperature.

☐ The addition of the indicated additive (or surface roughening) caused a statistically significant decrease in the bond strength within 95% confidence limits.

☐ The addition of the indicated additive (or surface roughening) caused a statistically significant increase in the bond strength within 95% confidence limits.

Styrene-Acrylonitrile (SAN)

Thermoplastic ♹ OTHER

Trade Names	Manufacturer
• Luran	BASF
• Lustran	Bayer Corporation
• Styvex	Ferro Corporation
• Suprel	Vista Chemical Company
• Tyril	Dow Chemical

General Description

SAN is a high performance polymer of the styrene family, which is formed via the copolymerization of styrene and acrylonitrile monomers. The general properties of SAN are similar to polystyrene, but the addition of the polar acrylonitrile group adds superior chemical resistance, high temperature performance, and toughness. Typical of copolymers, the properties of SAN can be varied by changing the molecular weight and composition. An increase in the acrylonitrile content will improve the resin's physical properties but will make processing more difficult and decrease its transparency. SAN can be used as a color carrier for other thermoplastics and as an additive to improve the flow characteristics of ABS, PVC, and some other resins. Specialty grades available include those with UV stabilizers, elastomers, glass fibers, and flow aids. In 2004, the price ranged approximately from \$1.09 to \$1.45 per pound at truckload quantities.

General Properties

The major benefits of SAN are its stiffness, strength, and clarity. However, like polystyrene, SAN has a low impact strength, typically 0.3 to 1.2 ft.-lb./in. The use of reinforcing fillers, such as glass fiber, can be used to increase its impact strength, as well as the heat resistance, hardness, and modulus of SAN. The continuous service temperature of SAN is dependent on the load and specific chemical environment which it will be exposed to, normally varying between 120°F (49°C) and 180°F (82°C). SAN plastics are chemically resistant to aliphatic hydrocarbons, battery acids, bases, and most detergents. However, they are attacked by aromatic and chlorinated hydrocarbons, ketones, and esters.

Typical Properties of Styrene-Acrylonitrile (SAN)

	American Engineering	SI
Processing Temperature	415°F to 515°F	213°C to 268°C
Linear Mold Shrinkage	0.001 to 0.005 in./in.	0.001 to 0.005 cm/cm
Melting Point	212°F to 480°F	100°C to 249°C
Density	65.6 to 87.4 lb./ft.^{3}	1.05 to 1.40 g/cm^3
Tensile Strength, Yield	9.3 to 17.0 lb./in.^{2} x 10^3	6.5 to 12.0 kg/cm^2 x 10^2
Tensile Strength, Break	8.3 to 17.6 lb./in.^{2} x 10^3	5.8 to 12.4 kg/cm^2 x 10^2
Elongation, Break	0.9 to 3.1%	0.9 to 3.1%
Tensile Modulus	4.5 to 15.1 lb./in.^{2} x 10^5	3.2 to 10.6 kg/cm^2 x 10^4
Flexural Strength, Yield	12.9 to 22.8 lb./in.^{2} x 10^3	9.1 to 16.0 kg/cm^{2}x 10^2
Flexural Modulus	4.5 to 15.0 lb./in.^{2} x 10^5	3.2 to 10.5 kg/cm^2 x 10^4
Compressive Strength	12.5 to 23.2 lb./in.^{2} x 10^3	8.8 to 16.3 kg/cm^{2}x 10^2
Izod Notched, R.T.	0.3 to 1.2 ft.-lb./in.	1.6 to 6.5 kg cm/cm
Hardness	M80 - M98 Rockwell	M80 - M98 Rockwell
Thermal Conductivity	1.4 to 2.2 BTU-in./hr.-ft.^{2}-°F	0.20 to 0.32 W/m-°K
Linear Thermal Expansion	1.5 to 3.8 in./in.-°F x 10^{-5}	2.7 to 6.8 cm/cm-°C x10^{-5}
Deflection Temperature @ 264 psi	185°F to 226°F	85°C to 108°C
Deflection Temperature @ 66 psi	210°F to 235°F	99°C to 113°C
Continuous Service Temperature	120°F to 180°F	49°C to 82°C
Dielectric Strength	490 to 520 V/10^{-3} in.	1.9 to 2.0 V/mm x 10^4
Dielectric Constant @ 1 MHz	2.7 to 3.7	2.7 to 3.7
Dissipation Factor @ 1 MHz	0.008 to 0.010	0.008 to 0.010
Water Absorption, 24 hr.	0.08 to 0.26%	0.08 to 0.26%

Typical Applications

- ***Appliances –*** Knobs, refrigerator compartments, blender and mixer bowls
- ***Electronics –*** Cassette cases, meter lenses, tape windows
- ***Medical –*** Syringe components, blood aspirators, dialyzer housings
- ***Packaging –*** Cosmetic containers, closures, bottles, jars
- ***Miscellaneous –*** Safety glazing, battery cases, typewriter keys, pen and pencil barrels

ADHESIVE SHEAR STRENGTH (psi) (MPa)

Styrene-Acrylonitrile

		UNFILLED RESIN *3 rms*	**ROUGHENED** *18 rms*	**UV STABILIZER** *0.31% Tinuvin 770 0.31% Tinuvin 328*	**FLAME RETARDANT** *4% Saytex HBCD-SF 1% Antimony Oxide*	**IMPACT MODIFIER** *29% Paraloid EXL3330*	**LUBRICANT** *0.1% Calcium Stearate 24-46*	**INTERNAL MOLD RELEASE** *5% Mold Wiz INT-33PA*	**GLASS FILLER** *17% Glass Type 3540*	**COLORANT** *1% OmniColor Fuschia*	**ANTISTATIC** *3% Armostat 550*
Lustran 31 produced by Monsanto	**Loctite® 380™ Black Max® Instant Adhesive, Rubber Toughened**	500 3.5	>850◆ >5.9◆	>2050◆ >14.1◆	500 3.5	1000 6.9	500 3.5	750 5.2	500 3.5	500 3.5	>1850◆ >12.8◆
	Loctite® 401™ Prism® Instant Adhesive, Surface Insensitive *MEDICAL: Loctite® 4011™ Prism® Instant Adhesive, Surface Insensitive*	>3800◆ >26.2◆	>3800◆ >26.2◆	>3800◆ >26.2◆	1850 12.8	>3800◆ >26.2◆	>3800◆ >26.2◆	>3800◆ >26.2◆	>3800◆ >26.2◆	>3800◆ >26.2◆	>3800◆ >26.2◆
	Loctite® 401™ Prism® Loctite® 770™ Prism® Primer *MEDICAL: Loctite® 4011™ Prism® / Loctite® 7701™ Prism® Primer*	450 3.1	1150 7.9	450 3.1	>1000◆ >6.9◆	>1450◆ >10.0◆	>750◆ >5.2◆	450 3.1	450 3.1	1400 9.7	450 3.1
	Loctite® 414™ Super Bonder® Instant Adhesive, General Purpose	>3650◆ >25.2◆	>3650◆ >25.2◆	>5950◆ >41.0◆	1550 10.7	>3650◆ >25.2◆	>3650◆ >25.2◆	>3650◆ >25.2◆	>4550◆ >31.4◆	>3650◆ >25.2◆	>3650◆ >25.2◆
	Loctite® 330™ Depend® Adhesive, Two-Part No-Mix Acrylic	800 5.5	800 5.5	>1200◆ >8.3◆	800 5.5	>1100◆ >7.6◆	800 5.5	800 5.5	800 5.5	>900◆ >6.2◆	800 5.5
	Loctite® 3105™ Light Cure Adhesive, *MEDICAL: Loctite® 3311™ Light Cure Adhesive*	2800 19.3	>2900◆ >20.0◆	2800 19.3	>2900◆ >19.3◆	2800 19.3	2800 19.3	1750 12.1	2800 19.3	2800 19.3	>3000◆ >20.7◆
Lustran 31 Natural courtesy of Bayer Corporation	**Loctite® 4307™ Flashcure® Light Cure Adhesive**	>3350◆ >23.1◆									
	Loctite® H3000™ Speedbonder™ Structural Adhesive, General Purpose	1500 10.4									
	Loctite® H4500™ Speedbonder™ Structural Adhesive, Metal Bonder	1400 9.7									
	Loctite® 3032™ Adhesive, Polyolefin Bonder	>2300◆ >15.9◆									
	Loctite® E-00CL™ Hysol® Epoxy Adhesive, Low Odor	250 1.7									
	Loctite® E-90FL™ Hysol® Epoxy Adhesive, Flexible	400 2.8									
	Loctite® E-30CL™ Hysol® Epoxy Adhesive, Glass Bonder *MEDICAL: Loctite® M-31CL™ Hysol® Epoxy Adhesive, Glass Bonder*	250 1.7									
	Loctite® E-20HP™ Hysol® Epoxy Adhesive, Fast Setting *MEDICAL: Loctite® M-21HP™ Hysol® Epoxy Adhesive, Fast Setting*	350 2.4									
	Loctite® E-214HP™ Hysol® Epoxy Adhesive, High Strength	850 5.9									
	Loctite® Fixmaster® High Performance Epoxy	450 3.1									
	Loctite® 1942™ Hysol® Hot Melt Adhesive, EVA Based	100 0.7									
	Loctite® 7804™ Hysol® Hot Melt Adhesive	50 0.3									
	Loctite® 3631™ Hysol® Hot Melt Adhesive, Urethane	>1300◆ >9.0◆									
	Loctite® U-05FL™ Hysol® Urethane Adhesive, High Strength	550 3.8									
	Loctite® Fixmaster® Rapid Rubber Repair	400 2.8									
	Loctite® 5900® Flange Sealant, Heavy Body RTV Silicone	200 1.4									

Adhesive Performance

Loctite® 401™ Prism® and 414™ Super Bonder® Instant Adhesives, and Loctite® 4307™ Flashcure® Light Cure Adhesive created bonds stronger than the SAN substrate for all the formulations which were evaluated, with the exception of the formulation containing the flame retardant additive. Loctite® 3105™ Light Cure Adhesive and Loctite® 3032™ Adhesive achieved the second highest bond strengths. The overall bondability of all the tested adhesives on various grades of SAN is very good with the exception being Loctite® 7804™ Hysol® Hot Melt Adhesive.

Surface Treatments

Surface roughening caused either no effect or a statistically significant increase in the bond strengths achieved on SAN. The use of Loctite® 770™ Prism® Primer, in conjunction with Loctite® 401™ Prism® Instant Adhesive, or Loctite® 4011™ Prism® Medical Device Instant Adhesive with Loctite® 7701™ Prism® Primer, caused a statistically significant decrease in the bond strengths achieved on SAN for all the formulations which were evaluated.

Other Important Information

- SAN is compatible with acrylic adhesives, but can be attacked by their activators before the adhesive has cured. Any excess activator should be removed from the surface immediately.
- SAN is incompatible with anaerobic adhesives.
- Surface cleaners: isopropyl alcohol, Loctite® ODC-Free Cleaner & Degreaser.

NOTES:

◆ The force applied to the tests' specimens exceeded the strength of the material, resulting in substrate failure before the actual bond strength achieved by the adhesive could be determined.

🟧 The addition of the indicated additive (or surface roughening) caused a statistically significant decrease in the bond strength within 95% confidence limits.

▨ The addition of the indicated additive (or surface roughening) caused a statistically significant increase in the bond strength within 95% confidence limits.

Vinyl Ester

Thermoset ♵ V

Trade Names	Manufacturer
• Acpol	Cook Composites
• Corezyn	Interplastic Corporation
• Corrolite	Reichhold Chemical
• Derakane	Dow Chemical
• Hetron	Ashland Chemical Company
• Nupol	Cook Composites
• Polycor	Industrial Dielectrics

General Description

Vinyl esters are unsaturated esters of epoxy resins which are usually glass filled to increase their rigidity and decrease their mold shrinkage. Such fiber reinforced plastics (FRP) are usually formed by curing the vinyl ester in layers with variously configured sheets of glass. The glass sheets typically used are surfacing veils, chopped strands, chopped strand mats, woven rovings, biaxial mats, continuous strands, unidirectional mats and/or a combination of these. Other specialty grades available include UV absorbing, pigmented, and flame retardant grades. In 2004, the price of vinyl esters ranged approximately from $1.50 to $2.00 per pound at truckload quantities.

General Properties

Vinyl esters are known for their outstanding resistance to corrosion and a wide range of chemicals. Vinyl esters also have high impact strengths, good elongations (3 to 10%), and high weight to strength ratios (SG = 1.1 to 1.3). The properties of vinyl ester resins are extremely versatile, and properties can be tailored to specific applications by modifying the base resin and the composite glass fiber structure. For example, by adding an elastomer to the bisphenol A backbone, the tensile elongation, impact resistance, and abrasion resistance of vinyl esters are greatly increased. The addition of an epoxy novolac resin to its backbone results in superior oxidation, heat, and solvent resistance. The ignition resistance of vinyl esters is greatly improved by adding bromated resins to the polymer's backbone and/or by adding antimony oxide. Unfilled vinyl esters are slow burning and have low smoke emission. Vinyl esters are excellent electrical and thermal insulators and have outstanding resistance to thermal aging. Vinyl esters are chemically resistant to a wide variety of chemicals, including acids, alkalis, halogenated organics, caustics, and solvents.

Typical Properties of Vinyl Ester

	American Engineering	SI
Processing Temperature	250°F to 300°F	121°C to 149°C
Linear Mold Shrinkage	0.0005 to 0.0010 in./in.	0.0005 to 0.0010 cm/cm
Melting Point	–	–
Density	64.3 to 71.2 lb./ft.^{3}	1.03 to 1.14 g/cm^3
Tensile Strength, Yield	9.1 to 12.6 lb./in.^{2} x 10^3	6.4 to 8.9 kg/cm^2 x 10^2
Tensile Strength, Break	9.9 to 12.1 lb./in.^{2} x 10^3	7.0 to 8.5 kg/cm^2 x 10^2
Elongation, Break	3.4 to 5.5%	3.4 to 5.5%
Tensile Modulus	4.4 to 5.2 lb./in.^{2} x 10^5	3.1 to 3.7 kg/cm^2 x 10^4
Flexural Strength, Yield	16.0 to 21.9 lb./in.^{2} x 10^3	11.2 to 15.4 kg/cm^{2}x 10^2
Flexural Modulus	4.4 to 5.7 lb./in.^{2} x 10^5	3.1 to 4.0 kg/cm^2 x 10^4
Compressive Strength	16.5 to 42.0 lb./in.^{2} x 10^3	11.6 to 29.5 kg/cm^{2}x 10^2
Izod Notched, R.T.	0.4 to 0.6 ft.-lb./in.	2.2 to 3.2 kg cm/cm
Hardness	M110 - M115 Rockwell	M110 - M115 Rockwell
Thermal Conductivity	–	–
Linear Thermal Expansion	1.8 to 2.1 in./in.-°F x 10^{-5}	3.2 to 3.8 cm/cm-°C x10^{-5}
Deflection Temperature @ 264 psi	200°F to 248°F	93°C to 220°C
Deflection Temperature @ 66 psi	–	–
Continuous Service Temperature	–	–
Dielectric Strength	400 to 470 V/10^{-3} in.	1.6 to 1.8 V/mm x 10^4
Dielectric Constant @ 1 MHz	2.8 to 3.5	2.8 to 3.5
Dissipation Factor @ 1 MHz	0.002 to 0.020	0.002 to 0.020
Water Absorption, 24 hr.	0.10 to 0.30%	0.10 to 0.30%

Typical Applications

- ***Chemical –*** Adsorption towers, process vessels, storage equipment tanks piping, hood scrubbers
- ***Miscellaneous –*** Sheet molding compounds, electrical equipment, flooring, fans

ADHESIVE SHEAR STRENGTH (psi) (MPa)

Vinyl Ester

Derekane 411-350M courtesy of Dow Chemical Company

LOCTITE®	**DEREKANE 411-45** *Vinyl Ester Resin with C-Glass Veil, 15 rms courtesy of Dow Chemical*	**411-45 ROUGHENED** *Vinyl Ester Resin with C-Glass Veil, 27 rms*	**DEREKANE 470-36** *High Temperature / Corrosion Resistant Grade with C-Glass Veil*	**C-695 BLACK 229** *20 to 30% Glass Fiber Mineral Filled courtesy of American Cyanamid*
Loctite® 380™ Black Max® Instant Adhesive, Rubber Toughened	950 6.6	1950 13.5	550 3.8	>1650◆ >11.4◆
Loctite® 401™ Prism® Instant Adhesive, Surface Insensitive *MEDICAL: Loctite® 4011™ Prism® Instant Adhesive, Surface Insensitive*	1900 13.1	1900 13.1	>2200◆ >15.2◆	>2100◆ >14.5◆
Loctite® 401™ Prism® Loctite® 770™ Prism® Primer *MEDICAL: Loctite® 4011™ Prism® / Loctite® 7701™ Prism® Primer*	800 5.5	800 5.5	650 4.5	750 5.2
Loctite® 414™ Super Bonder® Instant Adhesive, General Purpose	1950 13.5	1950 13.5	>2450◆ >16.9◆	>1850◆ >12.8◆
Loctite® 330™ Depend® Adhesive, Two-Part No-Mix Acrylic	400 2.8	1000 6.9	350 2.4	600 4.1
Loctite® 3105™ Light Cure Adhesive, *MEDICAL: Loctite® 3311™ Light Cure Adhesive*	1950 13.5	1950 13.5	1500 10.3	1750 12.1
Loctite® 4307™ Flashcure® Light Cure Adhesive	>2850◆ >19.7◆			
Loctite® H3000™ Speedbonder™ Structural Adhesive, General Purpose	1450 10.0			
Loctite® H4500™ Speedbonder™ Structural Adhesive, Metal Bonder	1300 9.0			
Loctite® 3032™ Adhesive, Polyolefin Bonder	2150 14.8			
Loctite® E-00CL™ Hysol® Epoxy Adhesive, Low Odor	750 5.2			
Loctite® E-90FL™ Hysol® Epoxy Adhesive, Flexible	>1150◆ >7.9◆			
Loctite® E-30CL™ Hysol® Epoxy Adhesive, Glass Bonder *MEDICAL: Loctite® M-31CL™ Hysol® Epoxy Adhesive, Glass Bonder*	>2150◆ >14.8◆			
Loctite® E-20HP™ Hysol® Epoxy Adhesive, Fast Setting *MEDICAL: Loctite® M-21HP™ Hysol® Epoxy Adhesive, Fast Setting*	>2300◆ >15.9◆			
Loctite® E-214HP™ Hysol® Epoxy Adhesive, High Strength	1000 6.9			
Loctite® Fixmaster® High Performance Epoxy	>2600◆ >17.9◆			
Loctite® 1942™ Hysol® Hot Melt Adhesive, EVA Based	100 0.7			
Loctite® 7804™ Hysol® Hot Melt Adhesive	200 1.4			
Loctite® 3631™ Hysol® Hot Melt Adhesive, Urethane	>2800◆ >19.3◆			
Loctite® U-05FL™ Hysol® Urethane Adhesive, High Strength	>1200◆ >8.3◆			
Loctite® Fixmaster® Rapid Rubber Repair	>1050◆ >7.2◆			
Loctite® 5900® Flange Sealant, Heavy Body RTV Silicone	200 1.4			

Adhesive Performance

Loctite® 4307™ Flashcure® Light Cure Adhesive, Loctite® E-90FL™, E-30CL™ and E-20HP™ Hysol® Epoxy Adhesives, Loctite® U-05FL™ Hysol® Urethane Adhesive, Loctite® 3631 Hysol® Hot Melt Adhesive, and Loctite® Fixmaster® High Performance Epoxy all achieved bond strengths which were greater than the grade of vinyl ester tested. The overall bondability of vinyl ester is good to excellent. The exceptions are the Loctite® 7804™ and 1942™ Hysol® Hot Melt Adhesives and Loctite® 5900® Flange Sealant.

Surface Treatments

Surface roughening caused either no effect or a statistically significant increase in the bond strengths achieved on vinyl ester. The use of Loctite® 7701™ Prism® Primer, in conjunction with Loctite® 401™ Prism® Instant Adhesive, or Loctite® 4011™ Prism® Medical Device Instant Adhesive with Loctite® 7701™ Prism® Primer, caused a statistically significant decrease in the bondability of all the grades of vinyl ester which were evaluated.

Other Important Information

- Vinyl ester is compatible with all Loctite® brand adhesives, sealants, primers, and activators.
- Surface cleaners: isopropyl alcohol, Loctite® ODC-Free Cleaner & Degreaser.

NOTES:

◆ The force applied to the tests' specimens exceeded the strength of the material, resulting in substrate failure before the actual bond strength achieved by the adhesive could be determined.

☐ The addition of the indicated additive (or surface roughening) caused a statistically significant increase in the bond strength within 95% confidence limits.

Stress Cracking Resistance of Various Plastics

	Cyanoacrylates	Acrylics
Acrylonitrile-Butadiene-Styrene (ABS)	●	●
Acetal	○	○
Acrylic (PMMA)	●	●
Acrylic-Styrene-Acrylonitrile (ASA)	○	●
Allylic Ester (DAP, DAIP)	○	○
Cellulosic (CAP)	●	●
Epoxy	○	○
Fluoropolymers (PTFE, FEP, PFA, ETFE)	○	○
Ionomer	●	●
Liquid Crystal Polymer (LCP)	○	○
Phenolic	○	○
Polyamide (Nylon)	○	○
Polybutylene Terephthalate (PBT)	○	○
Polycarbonate (PC)	●	●
Polyester, Thermoset	○	○
Polyetheretherketone (PEEK)	○	○
Polyetherimide (PEI)	●	○
Polyethersulfone (PES)	●	●
Polyethylene (PE)	○	○
Polyethylene Terephthalate (PET)	○	○
Polyimide (PI)	○	○
Polymethylpentene (PMP)	○	○
Polyphenylene Oxide (PPO)	●	●
Polyphenylene Sulfide (PPS)	○	○
Polypropylene (PP)	○	○
Polystyrene (PS)	○	●
Polyurethane (PU)	●	●
Polyvinyl Chloride (PVC)	●	●
Styrene-Acryonitrile (SAN)	○	●
Vinyl Ester	○	○

Legend = ○ - Normally Compatible ● - Should Be Tested

Surface Treatments

Adhesive Abrading

Adhesive abrading is performed by abrading the plastic's surface prior to the presence of liquid adhesive. Two of the abraded, adhesive-coated adherends are then mated, and the adhesive is allowed to cure. This increases the bond strengths achieved on PTFE by approximately 700 percent. It is speculated that when abrasion is carried out in the presence of the adhesive, free radicals are created which react directly with the adhesive. This does not normally occur because the free radicals are scavenged by the oxygen present in air, or decay, before the adhesive is applied.

Common uses: Fluorocarbons

Chromic Acid Etching

Chromic acid etching increases the bondability of a plastic by introducing reactive sites, such as hydroxyl, carbonyl, carboxylic acid, and SO_2H groups, to the plastic's surface and forming root-like cavities which provide sites for mechanical interlocking. The effects of this treatment vary from substrate to substrate. For example, increasing the etch time and temperature increase only the etch depth when etching polypropylene. On the other hand, both the degree of oxidation and etch depth increase with time for polyethylene.

Common uses: Polyolefins, ABS, Polystyrene, Polyphenyloxide, Acetals

Corona Discharge

In a corona discharge process, the plastic is exposed to an electrical discharge, usually in the presence of air and at atmospheric pressure so as to create a plasma "field." This roughens the surface, which provides sites for mechanical interlocking, and introduces reactive sites on the plastic's surface, consequently increasing the wettability and reactivity of the surface. The reactive functionalities which are theorized to be introduced to the surface may include, but are not proven to be, carbonyl, hydroxyl, hydroperoxide, aldehyde, ether, ester, and carboxylic acid groups, as well as unsaturated bonds.

Common uses: Polyolefins

Flame Treatment

Flame treatment increases the bondability of a plastic by oxidizing the surface through brief exposure to flame. The oxidation is proceeded by a free radical mechanism, accompanied by chain scissions and some crosslinking. The functionalities introduced by oxidation are hydroxyl, carbonyl, carboxyl, and amide groups with a typical oxidation depth of approximately 4 to 9 nanometers. The improved bondability results from increased wettability, due to increased surface energy, and interfacial diffusivity, caused by chain scissions.

Common uses: Polyolefins, Polyacetals, Polyethylene Terephthalate

Iodine Treatment

Iodine treatment increases the bond strengths achieved on a substrate by altering the surface crystallinity from alpha form (where the N-H groups lie parallel to the surface) to beta form (where the N-H groups stand perpendicular to the surface). The surface remains relatively smooth after treatment, so it is believed that increased chemical reactivity, rather than mechanical interlocking, is the mechanism for improved adhesion.

Common uses: Nylon

Plasma Treatment

Plasma treatment increases the bondability of a substrate by bombarding the substrate surface with ions of a gas, such as Ar_2, He_2, N_2, and O_2 at low pressure. Several mechanisms have been proposed to explain the enhanced bondability created by plasma treating. For example, plasma treatment is hypothesized to crosslink the substrate's surface, which strengthens the joint boundary and prevents a thin layer of substrate from peeling off. In addition, the surface oxidation caused by plasma treatment is thought to introduce reactive functionalities which then increase the surface's reactivity and wettability. Another theory attributes plasma treatment's effectiveness to an increased interfacial diffusion which is created by chain scissions in the substrate's surface. Chain scissions increase the interfacial diffusion by lowering the surface viscosity and increasing the molecular mobility of the plastic's surface.

Common uses: Polyolefins, Polyesters, many more

Primers

Primers typically consist of a reactive chemical species dispersed in a solvent. To use the primer, the solution is brushed or sprayed onto the substrate surface. The carrier solvent is then allowed to flash off, leaving the active species behind. Depending on the type of primer, the surface may be ready to bond immediately, as in the case of polyolefin primers for cyanoacrylates, or may require time to react with atmospheric moisture before the application of the adhesive. Primers that must react with atmospheric moisture include silane and isocyanate-based primers which are typically used for silicone and polyurethane-based adhesives respectively. Surface primers generally improve substrate bondablility by acting as a chemical bridge between the substrate and the adhesive. Typically, the reactive species in a primer will be multifunctional, with one set of reactive groups that will preferentially react with the substrate surface, and additional groups that will have a high affinity for the adhesive.

Common uses: Acetals, Fluoropolymers, Polybutylene, Terephthalate, Polyolefins, Polyurethanes, Silicones

Sodium Treatment

Sodium treatment is carried out by immersing the substrate in an aggressive etching solution containing either a sodium-naphthalene complex dissolved in tetrahydrofuran or a sodium-ammonia complex dissolved in ammonia. The etching process results in the dissolution of the amorphous regions of the substrate's surface, consequently increasing the substrate's surface roughness and potential for mechanical interlocking. Moreover, sodium treatment introduces unsaturated bonds, carbonyl groups, and carboxyl groups to the substrate's surface, which increases the substrate's reactivity and wettability. Due to carbonaceous residue which results from the defluorination of the surface, sodium treatment darkens the surface to an approximate depth of 1 micrometer. The on-part life of the treatment is very long (years), however, heating and UV exposure rapidly degrade the treated surface. Major disadvantages of using sodium treatments are extended exposure to the solution will result in a substantial degradation of the substrate's surface, the etchants are highly hazardous, and the solution degrades very rapidly in the presence of oxygen.

Common uses: Fluorocarbons

Surface Grafting

Surface grafting is accomplished by grafting a chemical species to the substrate's surface which increases the substrate's bondability. For example, polyethylene can be exposed to gamma radiation in the presence of vinyl acetate monomer, which then becomes chemically grafted to the polyethylene surface.

Common uses: Vinylic Compounds on Polyolefins

Surface Roughening

Surface roughening is a simple, low cost method of increasing the bondability of many plastics. Surface roughening increases the bondability by dramatically increasing the number of mechanical interlocking sites.

Common uses: Effective for many plastics

Thermal Treatment

Thermal treatment increases the bondability of plastics by exposing the plastic to a blast of hot air (approximately 500°C), which oxidizes the surface. This mainly introduces carbonyl, carboxyl, and amide groups to the surface, but some hydroperoxide groups are also formed. Very similar to flame treatments, this process also utilizes a free radical mechanism accompanied by chain scission and some crosslinking. The improved bondability results from increased wettability, due to the introduction of polar groups, and interfacial diffusivity, caused by chain scissions.

Common uses: Polyolefins

Transcrystalline Growth

Transcrystalline growth improves bondability of a plastic by molding adherends against a high energy metallic substrate that induces trancrystalline growth in the plastic's surface regions. The metallic substrate induces the formation of crystallites at the plastic's surface and results in rod-like or columnar spherulites that form inward from the interface. This is thought to strengthen the surface by driving low molecular weight material into the interior. In addition, some metallic substrates may oxidize the plastic's surface, resulting in a substantial increase in the reactivity and wettability of the plastic's surface. The effectiveness of this treatment is dependent on such molding conditions as the cooling rate and mold surface.

Common uses: Polyolefins, Polyamides, Polyurethanes

UV Exposure

UV exposure increases the bondability of plastics by irradiating them with high intensity UV light. However, the effectiveness of UV exposure is very dependent on the wavelength of light being used. For example, light with a wavelength of 184 nm will crosslink the surface of polyethylene, while light at 253.7 nm will not. UV irradiation causes chain scissions, crosslinking and oxidation of the polymer's surface, even in inert gases. Many different mechanisms describing why UV exposure increases the bondability of plastics have been proposed, including: increasing the wettability; strengthening the plastic's boundary layer through crosslinking; and inducing hydrogen bonding. The predominant view is that the bondability is improved by the formation of polymeric scission products, which promote interfacial flow, interdiffusion, and polar interactions.

Common uses: Polyolefins

Adhesive Joint Design

Introduction

In this section, the terms and concepts related to joint design are divided into three categories which include:

- Types of Joints
- Joint Stress Distribution
- Design Guidelines

Before looking at different types of joints, a few terms need to be explained:

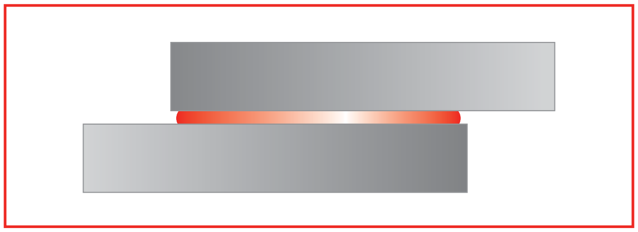
Joint: A joint is the location where an adhesive joins two substrates.

Joint Geometry: Joint geometry refers to the general shape of an adhesive bond. Is the shape of the bond long and narrow, short and wide, thick or thin?

Types of Joints

The specific types of joints which will be examined in this section include:

- Lap/Overlap
- Offset
- Butt
- Scarf
- Strap/Double Strap
- Cylindrical

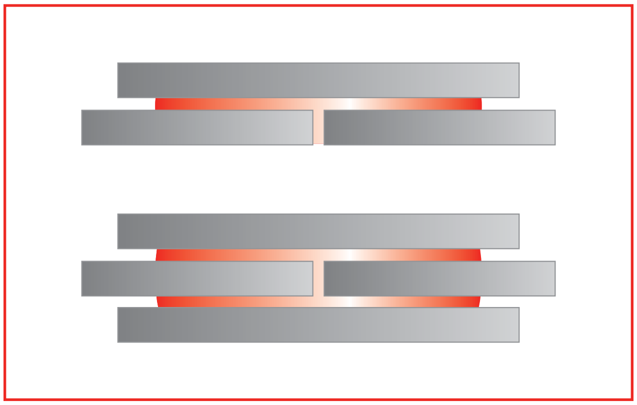


LAP/OVERLAP JOINT: A lap joint, also called an overlap joint, is formed by placing one substrate partially over another substrate.

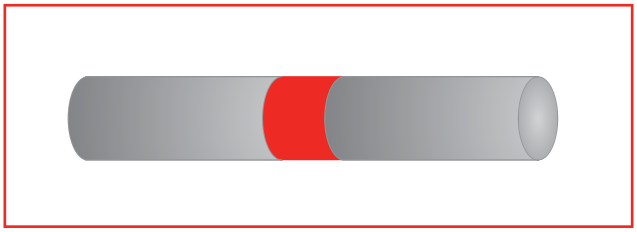
OFFSET JOINT: The offset joint is very similar to the lap joint.

BUTT JOINT: A butt joint is formed by bonding two objects end to end.

SCARF JOINT: A scarf joint is an angular butt joint. Cutting the joint at an angle increases the surface area.



STRAP JOINT (SINGLE OR DOUBLE): A strap joint is a combination overlap joint with a butt joint.



CYLINDRICAL JOINT: A cylindrical joint uses a butt joint to join two cylindrical objects.

Joint Stress Distribution

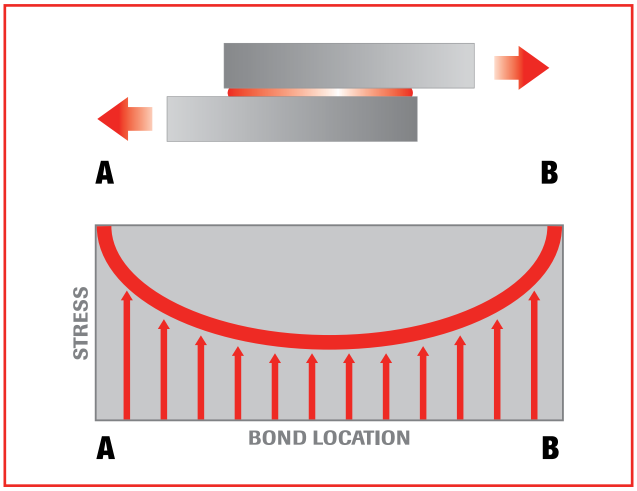
Joint stress distribution is the location of stresses within a bond.

Stress: Usually expressed as Newtons per square meter (N/M^2), which is equivalent to a Pascal (Pa.) In the English system, stress is normally expressed in pounds per square inch (psi).

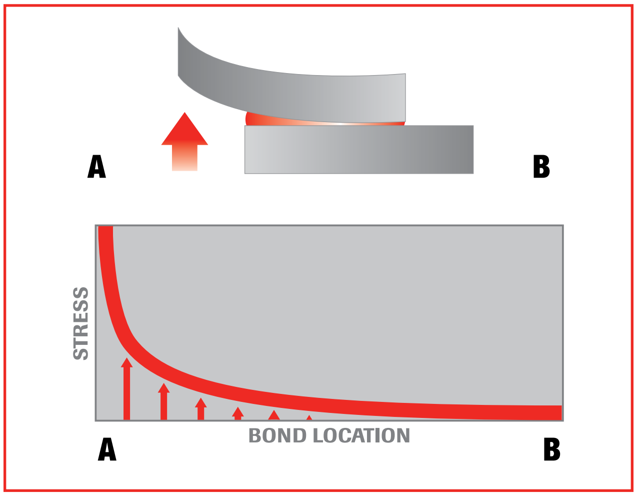
Types of Stresses

There are several types of stresses commonly found in adhesive bonds which include:

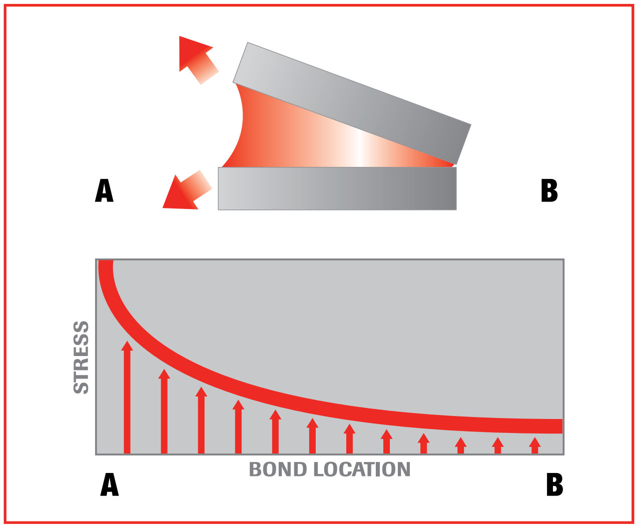
- Shear
- Tensile
- Compressive
- Peel
- Cleavage



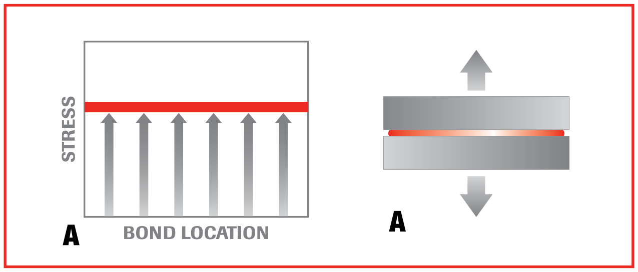
SHEAR STRESS: A shear stress results in two surfaces sliding over one another.



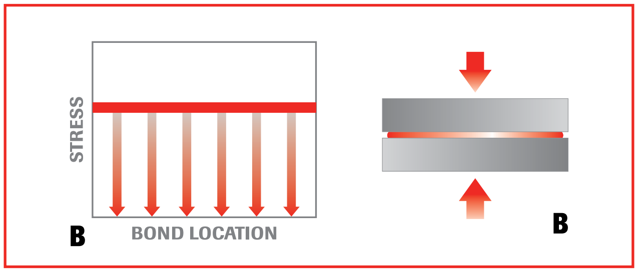
PEEL STRESS: A peel stress occurs when a flexible substrate is being lifted or peeled from the other substrate. *NOTE: The stress is concentrated at one end.*



CLEAVAGE STRESS: A cleavage stress occurs when rigid substrates are being opened at one end. *NOTE: The stress is concentrated at one end.*



TENSION STRESS DISTRIBUTION: When a bond experiences a tensile stress, the joint stress distribution is illustrated as a straight line. The stress is evenly distributed across the entire bond. Tensile stress also tends to elongate an object.



COMPRESSION STRESS DISTRIBUTION: When a bond experiences a compressive stress, the joint stress distribution is illustrated as a straight line. The stress is evenly distributed across the entire bond.

Design Guidelines

Design Guidelines

Engineers must have a good understanding of how stress is distributed across a joint which is under an applied force. There are several design guidelines which should be considered when designing an adhesive joint.

- ***Maximize Shear/Minimize Peel and Cleavage***
  Note from the stress distribution curve for cleavage and peel, that these bonds do not resist stress very well. The stress is located at one end of the bond line. Whereas, in the case of shear, both ends of the bond resist the stress.

- ***Maximize Compression/Minimize Tensile***
  Note from the stress distribution curve for compression and tension, that stress was uniformly distributed across the bond. In most adhesive films, the compressive strength is greater than the tensile strength. An adhesive joint which is feeling a compressive force is less likely to fail than a joint undergoing tension.

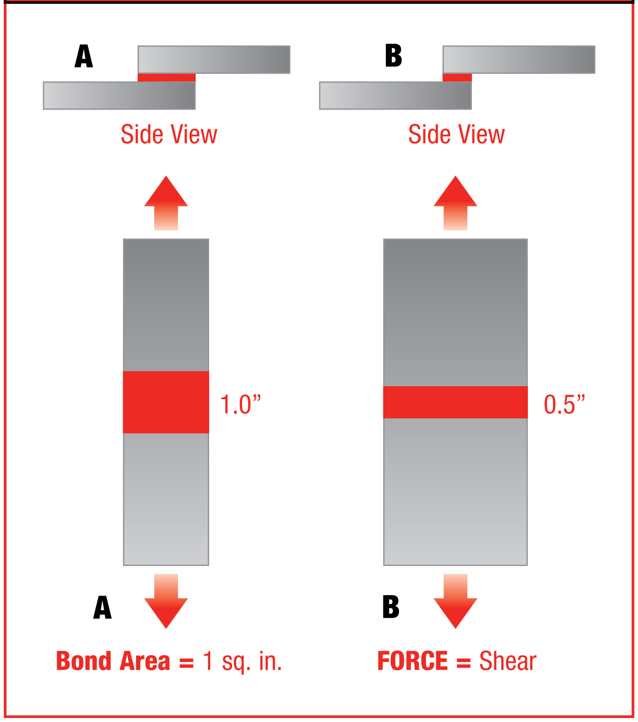
- ***Joint Width More Important Than Overlap***
  Note from the shear stress distribution curve, that the ends of the bond receives a greater amount of stress than does the middle of the bond. If the width of the bond is increased, stress will be reduced at each end and the overall result is a stronger joint.

  In this same overlap joint, if the overlapping length is greatly increased, there is little, if any, change in the bond strength. The contribution of the ends is not increased. The geometry of the ends has not changed, thus their contribution to the bond strength has not changed.

Bond Shear Strength Width vs Overlap

As a general rule, increase the joint width rather than the overlap area ("wider is better").

JOINT AREA – WIDTH VS. OVERLAP



Processor Rules for Good Adhesive Assembly

Richard Thompson, Senior Product Engineer (Retired)

There's more to reliable adhesive assembly than picking the right adhesive. Processors with assembly operations will boost their quality batting average by understanding all the ground rules.

Today's new and better plastic materials offer plastic-parts assemblers many opportunities to produce more reliable and durable products, often at lower cost. These new materials call for techniques that differ greatly from those used with traditional materials.

Assemblers must understand that plastics, compared to traditional materials, such as metals, have lower tensile strength, are usually more flexible, have higher coefficients of expansion, and often are harder to adhere to. These differences greatly influence the way joints are designed and adhesives are selected.

Why plastic fails before joint

The lower tensile strengths of plastics make it common to create bonded joints that are stronger than the plastic itself. Consider a joint between two strips of plastic 1 inch wide x ⅛ inch thick, as illustrated on page 81. Because of the large joint overlap, the substrate will fail before the bond. The same overall assembly strength could be achieved with an overlap of only 0.58 inch.

This situation shows why adhesive manufacturers often report "substrate failure" in a table of bonding strengths on plastics. Most of the standard test methods were originally designed for metals and have no instructions for adjusting the bond area used according to the tensile strength of the material.

Flex modulus stresses joints

With an elastic modulus of about 300,000 psi, a typical unreinforced plastic part is over 100 times more flexible than steel for identically shaped components. In designing lap joints, this added flexibility means that more bending and differential shearing will occur in the bonded joint as the assembly is placed under load.

This flexibility leads to increased stress concentration near the ends of the overlap. However, the stress ratios of plastic overlap joints are far greater than those of steel joints (see table below). These concentrations can lead to joint failure at relatively low loads.

The disadvantages of these high stress concentrations can be reduced effectively in many cases by careful selection of the other joint design parameters. Most important among these are: the elastic modulus of the adhesive, length of the overlap, and thickness of the bondline between the two substrates (see drawing on page 81).

A lower modulus adhesive reduces stress concentrations by accommodating the relative motion of the two substrates with greater shear compliance (see table below). The extreme case is when a rubbery adhesive is used. Such an adhesive is so flexible that shear deformations can be accommodated without creating significant stress concentrations. But an adhesive this flexible may not be able to accommodate the structural loads on an actual assembly without excessive deformation.

Effects of Bondline Gap

Bondline Gap (Inches)	Stress Ratio (Maximum)
0.001	18.40
0.002	13.00
0.005	8.31
0.010	5.93
0.020	4.25
0.040	3.06

Effects of Substrate Modulus

Material	Modulus psi	Stress Ratio
Steel Glass-filled	30,7000,000	1.69
Plastic Unfilled	1,000,000	7.77
Plastic	300,000	13.03

Effects of Joint Overlap

Overlap Length (Inches)	Stress Ratio (Maximum)
1.000	22.50
0.500	13.00
0.250	7.17
0.125	3.78

Effects of Adhesive Modulus

Adhesive Modulus (psi)	Stress Ratio (Maximum)
300,000	22.40
100,000	13.03
50,000	9.27
20,000	5.93
200	1.13

Constants for Tables

Adhesive Modulus	= 100,000 psi
Overlap	= 0.5 in.
Bondline	= 0.002 in.
Load	= 100 lbs.
Substrate Thickness	= 0.125 in.
Substrate Modulus	= 300,000 psi

Shortening bond overlaps reduces both the bending and the differential shearing effects which are present in lap joints (see table on page 80). If larger bond areas are needed to carry the load, it is better to increase bond width rather than bond overlap. Increased width adds very little to stress distribution in the bond.

Thicker bondlines make the joint more compliant to shear stress. The extra thickness spreads the shear strain over a larger dimension, resulting in less unit strain on the adhesive and, therefore, less stress concentration (see table on page 80). This is similar to using a lower modulus adhesive; a more compliant joint results in both cases.

By using a combination of the methods described previously, stress concentrations in plastic lap joints can be reduced to levels comparable to those in steel joints. For example, a joint made with an adhesive having a modulus of 20,000 psi, and overlap of 0.25 inch and a bondline thickness of 0.010 inch would have a maximum stress factor of 1.64. This compares favorably with the value for a typical bonded steel joint.

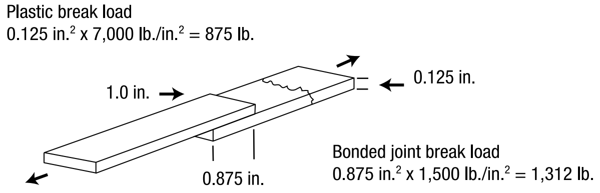
Good wet out gives good bond

Good wetting of the substrate surface is essential for developing reliable bonds. Adhesives that do not wet the surface will not spread out and fill substrate surface irregularities.

Wetting occurs when the surface tension of the liquid adhesive is lower than the critical surface tension of the substrates being bonded. If this condition is not met, the liquid does not spread, but forms a round droplet on the surface, much like water beads up on a newly-waxed car.

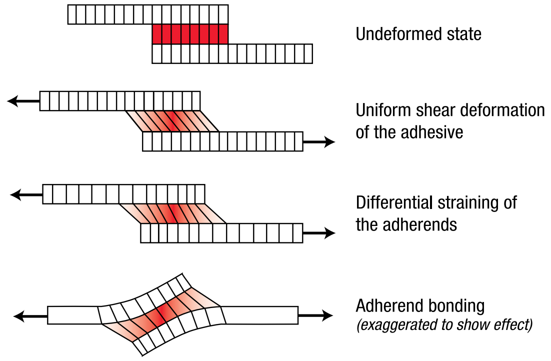
Wetting of plastic surfaces is much more complex than wetting clean metal surfaces. Plastics and adhesives are both polymeric materials and thus have similar physical properties, including wetting tensions. Plastic bonded joints do not have the large difference between the critical surface tension of the substrate and that of the adhesive, which insures wetting for metals. In addition, many plastics have notoriously low critical wetting tensions. Polyethylene (PE) and polypropylene (PP), with critical surface tensions of 31 and 29 dynes/cm respectively, present serious wetting challenges for most adhesives. Other plastics such as polystyrene (PS) and polyvinyl chloride (PVC) have higher critical surface tensions and present less of a problem.

Plastic fails before bond when large overlaps are used

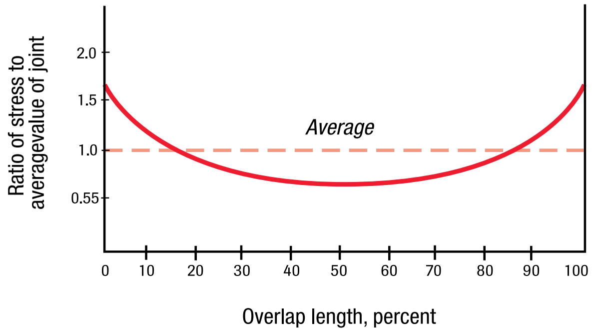


- Plastic breaks at 875 lbs.
- Same overall assembly strength achieved with only 0.58 in. overlap

Bonded tensile lap-shear specimens



Stress concentrations near end of overlap joints



When poor wetting occurs, there are methods to treat the surface for better bonding. One of these is simply cleaning and abrading the surface. The most common procedure is a solvent wipe, followed by abrasion and then a final solvent wipe. The solvent selected should not craze or soften the plastic. Grit blasting is the most effective abrasion method, although using aluminum oxide cloth also works well. Sandpaper should not be used because it often contains lubricants to assist in finishing wood. The final solvent rinse removes residue from abrasion.

Using cleaning and abrasion first insures that wetting problems are not caused by surface contamination. Another potential benefit is that removing the surface layer of plastic may expose material with better wetting characteristics due to a different crystalline microstructure.

Flame treatment is often used to change the surface characteristics of plastics. It involves passing the surface of the plastic through the oxidizing portion of a natural gas flame. The surface is rapidly melted and quenched by the process; some oxidation of the surface may occur at the same time. Exposure to the flame is only a few seconds.

Flame treatment is widely used for PE and PP, but has also been applied to other plastics, including thermoplastic polyester, polyacetal, and polyphenylene sulfide. Specially designed gas burners are available for this process, but butane torches can be used for laboratory trials.

Chemical surface treatments have often been used to improve the bonding of plastics. The most common involve strong oxidating agents such as chromic acid to etch the surface. While often effective, these methods are difficult to justify economically due to the cost of maintaining tanks and chemical solutions.

Polytetrafluoroethylene (PTFE) and other fluoropolymers are often treated with etching solutions based on dispersions of metallic sodium in organic solvents. This method dramatically improves surface wetting characteristics, and the plastic can readily be bonded using a wide range of adhesives. In some cases, PTFE pre-treated in this way can be purchased.

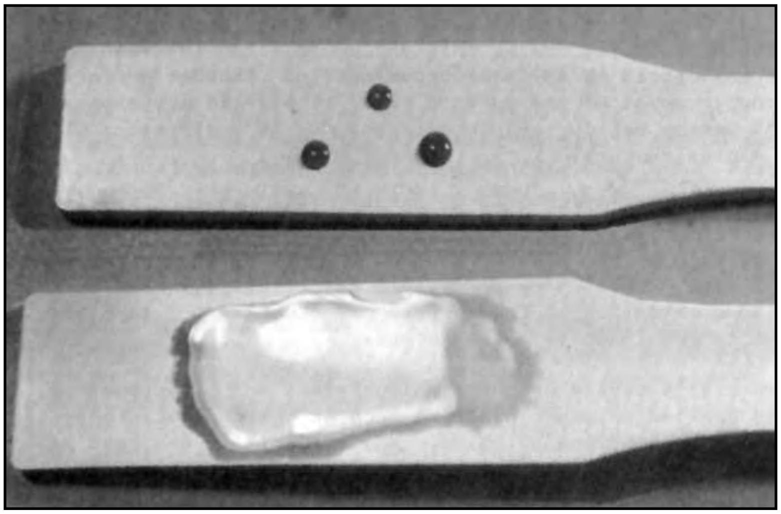
Plasma surface treatment is a relatively new technology for improving wetting on plastic surfaces. In this process, parts are exposed to ionized gases generated by radio frequency energy in a sealed chamber under extremely low pressures. By selecting appropriate gases and exposure conditions, the surface can be cleaned, etched, or chemically activated. Results include significant differences in surface wetting (see photo), and a two to threefold increase in bond shear strength.

Because plasma treatment involves a closed and evacuated chamber, the process is excellent for treating large numbers of small, high-value parts at one time. It is harder to economically justify for larger parts since fewer can be treated in the same cycle.

Visual observation is often enough to determine if wetting is adequate, but it is sometimes desirable to measure the value. One test is the ASTM D2578, “Wetting Tension of Polyethylene and Polypropylene films.” This method uses a series of test liquids with known surface tensions to determine the level required to just wet the surface. The critical wetting tension of a surface is approximated by the surface tension of the fluid selected. Although this method is intended for PE and PP, the same type of procedure can be used on other plastics.

Adhesive/plastic fit is a must

When bonding metals and other inorganic materials, the issue of adhesive-substrate compatibility seldom arises. Cases of damage to these materials are few, and generally are the result of some unusual interactions. However, when bonding plastics, care must be taken to avoid stress cracking, which can occur when incompatible adhesives are applied to the surface of a stressed plastic part.



Softening and weakening of the surface occur, leading to the formation of cracks. Liquid adhesive may penetrate into the crack causing further damage. Eventually, the crack may propagate through the entire part and cause failure.

The following are some guidelines that will help to minimize the potential for stress cracking:

- Work with parts that are in a low stress condition. Molded-in stresses can be reduced by modifying the molding cycle or annealing parts after molding.
- Use the minimum quantity of adhesive required and cure it as quickly as possible, cleaning up any excess adhesive at once. Cured adhesive will not cause cracking.
- Use only cleaning solvents/primers compatible with the plastics.
- Do not use anaerobic threadlocking compounds with crack-susceptible plastics. Uncured adhesive outside the threaded joint combined with high stresses caused by the threads almost guarantees stress cracking will occur.
- When in doubt, consult adhesive suppliers.

Expansion rate must be similar

When materials with different coefficients of thermal expansion (CTE) are joined, shear stresses result when the assembly is heated or cooled. With plastics, extreme differences can occur. For example, a sheet of G-10 epoxy glass laminate with a CTE of $5x10^{-6}$ in./in./°F bonded to acrylic with a CTE of $60x10^{-6}$ will result in rapid stress increases due to the twelvefold difference in expansion rate.

If expansion problems cannot be solved by revising material selections, using thicker bondlines and more flexible adhesives can help reduce problems. However, a thin film of adhesive between two components is only a small part of the total assembled joint, and as such, it is incapable of restraining or accommodating large relative motions between substrates.

By taking into consideration the differences between plastics and the compatibility of various adhesives, product assemblers can produce bonded joints that improve product performance while reducing manufacturing costs.

Coefficient of Thermal Expansion for Various Materials

Material	Thermal Expansion 10^{-6} in./in./°F
Polyethylene	167
Cellulose Acetate	90
Acrylic	60
Polypropylene	58
Thermoplastic Polyester (PBT)	53
Nylon	50
Styrene	48
Acetal	45
Polycarbonate	38
Polysulfone	31
Polyphenylene Sulfide	30
30% Glass-Filled Nylon	25
Phenolic	23
Zinc	15
Aluminum	13
Copper	12
40% Glass-Filled Polycarbonate	9
Steel	7
Glass	5
Graphite	2

Reprinted from May 1985 issue of Plastics World

Test Methodology

Determining The Experimental Matrix

The Selection of Adhesives

It was desired to evaluate adhesives from all families that are best suited for bonding plastics. The families were identified as ethyl cyanoacrylates, light cure, two part and no mix acrylics, silicones, hot melts, epoxies, polyurethanes, and static mix acrylics. From each of these categories, an adhesive was then selected which was believed to be representative of the performance of that family of adhesives when bonding plastics. The adhesives which were selected are tabulated below:

ADHESIVE	DESCRIPTION
Loctite® 380™ Black Max® Instant Adhesive	Rubber-toughened ethyl instant adhesive
Loctite® 401™ Prism® Instant Adhesive, *MEDICAL: Loctite® 4011™ Prism® Instant Adhesive*	Surface insensitive ethyl instant adhesives
Loctite® 401™ Prism® and 770™ Prism® Primer *MEDICAL: Loctite® 4011™ Prism® / Loctite® 7701™ Prism® Primer*	Surface insensitive ethyl adheisves used in conjunction with polyolefin primer
Loctite® 414™ Super Bonder® Instant Adhesive	General-purpose ethyl instant adhesive
Loctite® 330™ Depend® Adhesive	Two-part, no-mix acrylic adhesive
Loctite® 3105™ Light Cure Adhesive, *MEDICAL: Loctite® 3311™ Light Cure Adhesive*	Light curing acrylic adhesives
Loctite® 4307™ Flashcure® Light Cure Adhesive	Light cure adhesives
Loctite® H3000™ Speedbonder™ Structural Adhesive	Two-part acrylic adhesive
Loctite® H4500™ Speedbonder™ Structural Adhesive	Two-part acrylic adhesive
Loctite® 3032™ Adhesive	Polyolefin bonder
Loctite® E-00CL™ Hysol® Epoxy Adhesive	Fast setting epoxy adhesive
Loctite® E-90FL™ Hysol® Epoxy Adhesive	Tough, flexible epoxy adhesive
Loctite® E-30CL™ Hysol® Epoxy Adhesive *MEDICAL: Loctite® M-31CL™ Hysol® Epoxy Adhesive*	Clear, glass bonding epoxy adhesive
Loctite® E-20HP™ Hysol® Epoxy Adhesive *MEDICAL: Loctite® M-21HP™ Hysol® Epoxy Adhesive*	High strength epoxy adhesives
Loctite® E-214HP™ Hysol® Epoxy Adhesive	One component heat cure epoxy adhesive
Loctite® 1942™ Hysol® Hot Melt Adhesive	EVA hot melt epoxy adheisve
Loctite® 7804™ Hysol® Hot Melt Adhesive	Polyamide hot melt adhesive
Loctite® 3631™ Hysol® Hot Melt Adhesive	Reactive urethane hot melt adhesive
Loctite® U-05FL™ Hysol® Urethane Adhesive	Two-part high performance urethane adhesive
Loctite® Fixmaster® Rapid Rubber Repair	Rapid rubber repair urethane adhesive
Loctite® 5900® Flange Sealant	Heavy body RTV flange sealant

The Selection of Plastics

The various types of plastics which are currently available were surveyed, and 30 of the most commonly used plastic types were selected for testing. The specific formulations of these plastics which were evaluated were chosen in one of the two following ways:

Specialty Formulations

Seventeen of the 30 materials were compounded specifically to determine the effect different additives and fillers had on the bondability of the base resin using the following procedure:

1. A grade of the plastic which had no fillers or additives was selected and tested for bond strength performance with the aforementioned adhesives.
2. The most common additives and fillers used with each plastic were identified.
3. A separate formulation of the plastic was compounded with a high fill level of each of the identified common additives and fillers.
4. Adhesive bond strength evaluations were performed on the various formulations which were compounded.
5. The results were analyzed to determine if the filler or additive resulted in a statistically significant change in the bondability of the plastic from the unfilled resin within 95% confidence limits.

Commercially Available Grades

For 13 of the 30 plastics, commercially available grades were selected to represent each major category available for that plastic. For example, when testing ionomer, grades were evaluated which represented each of the major cation types. Moreover, while evaluating phenolics, a grade was selected to represent each of the end use applications, such as general-purpose, glass-filled, heat resistant, and electric grades.

Determining The Test Method

The lap shear test method ASTM D1002 is typically used to determine adhesive shear strengths. However, because it was designed for use with metals, it has several serious limitations when evaluating plastics. For example, because plastics have much lower tensile strength than metals, the plastic lap shear specimens are much more likely to experience substrate failure than the metal lap shear specimens. This makes the comparative analysis of different adhesives on a plastic very difficult because many of the adhesives will achieve substrate failure, rendering it impossible to identify the adhesive best suited for that material. Another major disadvantage to using the lap shear test method is that because plastics have much lower modulii than metals, they deform more during testing, which introduces peel and cleavage forces on the joint. Consequently, the lower the modulus of the plastic, the more it will deform under load, and the less representative the experimental shear strength will be of the actual shear strength which should have been achieved on that material.

Due to these limitations, a block shear test method (ASTM D4501) was chosen. Since block shear testing places the load on a thicker section of the test specimen, the specimen can withstand higher loads before experiencing substrate failure. In addition, due to the geometry of the test specimens and the block shear fixture, peel and cleavage forces in the joint are minimized.

Limitations

While the bond strengths in this guide give a good indication of the typical bond strengths that can be achieved with many plastics, as well as the effect of many fillers and additives, they also face several limitations. For example, while the additives and fillers were selected because they were believed to be representative of the most commonly used additives and fillers, there are many types of each additive and filler produced by many different companies, and different types of the same additive or filler may not have the same effect on the bondability of a material. In addition, the additives and fillers were tested individually in this guide, so the effect of interactions between these different fillers and additives on the bondability of materials could not be gauged.

Another consideration that must be kept in mind when using this data to select an adhesive/plastic combination is how well the block shear test method will reflect the stresses that an adhesively bonded joint will see in “real world” applications. Adhesively bonded joints are designed to maximize tensile and compressive stresses, and to minimize peel and cleavage stresses, so the magnitude of the former two are generally much larger than the latter two. Thus, the shear strength of an adhesive is generally most critical to adhesive joint performance, but since all joints experience some peel and cleavage stresses, their effects should not be disregarded.

Finally, selecting the best adhesive for a given application involves more than selecting the adhesive which provides the highest bond strength. Other factors such as speed of cure, environmental resistance, thermal resistance, suitability for automation, and price will play a large role in determining the optimum adhesive system for a given application. It is suggested that the reader refer to the chapters which explain the properties of the various adhesives in greater detail before choosing the best adhesive for an application.

Although there are some limitations to the degree the information provided in this guide can be extrapolated, the data contained here should be invaluable in helping the end user quickly make comparative evaluations of the bond strengths that various adhesive/plastic combinations provide. Once the most promising combinations of adhesives and plastics have been identified, it is important that testing be performed on assemblies to insure that they will meet or exceed all performance requirements.

Test Methods

Substrate Preparation

1. Substrates were cut into 1" x 1" x 0.125" block shear test specimens.
2. All bonding surfaces were cleaned with isopropyl alcohol.

Surface Roughness

1. The test specimens were manually abraded using a 3M Heavy-Duty Stripping Pad.
2. The surface roughness was determined using a Surfanalyzer 4000 with a traverse distance of 0.03 in. and a traverse speed of 0.01 in. per second.

Adhesive Application and Cure Method

CYANOACRYLATES

(Loctite® 380™ Black Max®, 401™ Prism®, 4011™ Prism® and 414™ Super Bonder® Instant Adhesives)

1. Adhesive was applied in an even film to one test specimen.
2. A second test specimen was mated to the first with a 0.5" overlap (bond area = 0.5 in.^{2}).
3. The block shear assembly was clamped with two Brink and Cotton No. 1 clamps.
4. The bonded assembly was allowed to cure at ambient conditions for one week before testing.

CYANOACRYLATES WITH POLYOLEFIN PRIMERS

(Loctite® 401™ Prism® Instant Adhesive and Loctite® 770™ Prism® Primer)

1. Polyolefin primer was brushed onto each bonding surface.
2. The polyolefin primer's carrier solvent was allowed to flash off.
3. Adhesive was applied in an even film to one substrate.
4. The second test specimen was mated to the first with a 0.5" overlap (bond area = 0.5 in.^{2}).
5. The block shear assembly was clamped with two Brink and Cotton No. 1 clamps.
6. The bonded assembly was allowed to cure at ambient conditions for one week before testing.

TWO-PART, NO-MIX ACRYLIC

(Loctite® 330™ Depend® Adhesive)

1. Loctite® 7387™ Depend® Activator was sprayed on one test specimen.
2. The activator's carrier solvent was allowed to flash off for more than two minutes.
3. Loctite® 330™ Depend® Adhesive was applied in an even film to a second test specimen.
4. Within 30 minutes, the second test specimen was mated to the first with a 0.5" overlap (bond area = 0.5 in.^{2}).
5. The block shear assembly was clamped with two Brink and Cotton No. 1 clamps.
6. The bonded assembly was allowed to cure at ambient conditions for one week before testing.

LIGHT CURE ADHESIVES

(Loctite® 3105™ Light Cure Adhesive and Loctite® 4307™ Flashcure® Light Cure Adhesive)

1. Adhesive was applied in an even film to one test specimen.
2. A UV transparent, medical polycarbonate 1" x 1" x 0.125" test specimen was cleaned with isopropyl alcohol.
3. The second test specimen was mated to the first with a 0.5" overlap (bond area = 0.5 in.^{2}).
4. The block shear assembly was irradiated (through the polycarbonate) by an ultraviolet light source for 30 seconds to cure the adhesive. The ultraviolet light source used was a Fusion UV Curing System, equipped with an H-bulb having an irradiance of approximately 100 mW/cm^2 @ 365 nm.
5. The assembly was left at ambient conditions for one week prior to testing.

Block Shear Test Method

1. Assemblies were tested on an Instron 4204 mechanical properties tester, equipped with a 50 kN load cell, and a pull speed of 0.05" per minute.
2. Five replicates of each assembly were tested.

TWO-PART STATIC MIX ADHESIVES

(Loctite® E-20HP™ Hysol® Epoxy Adhesive, Loctite® E-00CL™ Hysol® Epoxy Adhesive, Loctite® E-90FL™ Hysol® Epoxy Adhesive, Loctite® E-30CL™ Hysol® Epoxy Adhesive, Loctite® U-05FL™ Hysol® Urethane Adhesive, Loctite® H4500™ Speedbonder™ Structural Adhesive, Loctite® H3000™ Speedbonder™ Structural Adhesive, Polyolefin Bonder, Loctite® Fixmaster® High Performance Epoxy, Loctite® Fixmaster® Rapid Rubber Repair)

1. The adhesive was dispensed onto the end of one block shear through an appropriate static mixing nozzle to achieve thorough mixing of the two adhesive components.
2. A second block shear was mated to the first with an overlap area of 0.5 in.^{2}.
3. The mated assembly was clamped with two clamps that exerted a clamping force of approximately 20 lb.
4. The bonded assembly was allowed to cure for one week at ambient conditions before conditioning and testing.

ONE-PART HEAT CURE EPOXY ADHESIVE

(Loctite® H-214HP™ Hysol® Epoxy Adhesive)

1. Adhesive was applied in an even film to the end of one block shear.
2. A second block shear was mated to the first with an overlap area of 0.5 in.^{2}.
3. The mated assembly was clamped with two clamps that exerted a clamping force of approximately 20 lb.
4. The clamped assembly was heated at 350°F (177°C) for one hour.
5. The assembly was left at ambient conditions for one week prior to conditioning and testing.

MOISTURE CURE PRODUCTS

(Loctite® 5900® Flange Sealant and Loctite® 3631™ Hysol® Hot Melt Adhesive)

1. Adhesive was applied in an even film to the end of one block shear.
2. A short length of 10 mil thick wire was embedded in the sealant to induce a 10 mil gap between the bonded block shears (except for Loctite® 3631™ Hysol® Hot Melt Adhesive).
3. A second block shear was mated to the first with an overlap area of 0.5 in.^{2}.
4. The mated assembly was clamped with two clamps that exerted a clamping force of approximately 20 lb.
5. The mated assembly was allowed to moisture cure for one week prior to conditioning and testing.

HOT MELT PRODUCTS

(Loctite® 7804™ and 1942™ Hysol® Hot Melt Adhesives)

1. The adhesive was heated to its dispense temperature in the appropriate hot melt dispenser.
2. Adhesive was applied in an even film to the end of one block shear.
3. A second block shear was mated to the first with an overlap area of 0.5 in.^{2}.
4. The mated assembly was clamped with two clamps that exerted a clamping force of approximately 20 lb.
5. The assemblies were left at ambient conditions for one week prior to conditioning and testing.

Did You Know?

Durometer Hardness

Durometer hardness is a property presented on technical data sheets that shows how hard the resin is in the cured state. A durometer gauge is the actual measuring device consisting of a small drill or blunt indentor point under pressure. Different measurement scales are used for different materials depending on how soft or hard the material. The following chart compares three (3) different graduated measurement scales and relates hardness values to some common objects as well as Loctite® brand products.

Shore A	Shore D	Rockwell M	Reference Object	Loctite® Brand Product
30			Art Gum Eraser	5140™
40			Pink Pearl Eraser	5900®
50	15		Rubber Stamp	–
60			Pencil Eraser	5699™
70	30		Rubber Heel	–
80			Rubber Sole	–
90	45		Typewriter Roller	366™
100	55		Pipe Stem	3106™
	74	0	Textbook Cover	334™
	78	32	Douglas Fir Plywood	–
	82	63		E-60HP™
	86	95	Hardwood Desktop	–
	90	125	Glass or Formica	–

The higher the number within each scale, the harder the material. Shore readings are typically used for plastics. Shore A is for softer materials; Shore D is for harder materials. Rockwell readings are typically used for metals.

Mathematical Conversions

The following are some common conversions that might be helpful when utilizing Loctite® brand products:

- 1 milliliter (ml) = 1 cubic centimeter (cc)
- 1,000 ml = 1 liter
- 29.5 ml = 1 fl. oz.
- 3.78 liters = 1 gallon
- 473 ml = 1 pint
- 454 grams = 1 lb.
- 947 ml = 1 quart
- 1 kilogram = 2.2 lbs.
- Weight to Volume: grams ÷ specific gravity = cc (ml)
- Volume to Weight: cc (ml) x specific gravity = grams
- Density = specific gravity x 0.99823
- Centipoises = centistokes x density (at a given temp.)
- Temperature: degrees F - 32 x 0.556 = degrees C
  degrees C x 2 - 10% + 32 = degrees F
- Square Inches to Square Feet: ÷ by 144
- Square Feet to Square Inches: x by 144
- In./lbs. ÷ 12 = ft./lbs.
- Ft./lbs. x 12 = in./lbs.
- 16 in. oz. = 1 in. lb.
- 192 in. oz. = 1 ft. lb.

Area Coverage

Flat Parts:

Length (in.) x Width (in.) x Bondline Thickness (in.) x 16.4 = cc/ml requirement per part

Non-threaded Cylindrical Parts:

Diameter x Engagement Length x Bondline Thickness (on radius/per side) x 3.14 x 16.4 = cc/ml requirement per part

Potting/ Encapsulating Applications:

Area (3.14 x R2) x Potting Depth x 16.4 = cc/ml requirement per part

For no induced gap, make the bondline thickness figure 0.001".
16.4 is a constant for converting cubic inches to cubic centimeters.

Viscosity

Viscosity is a product property you'll find associated with all Loctite® brand adhesive/sealants. Viscosity is defined as a measure of the resistance of a fluid to flow (usually through a specific orifice). A measure of this fluid "thickness" is expressed in centipoise values. The higher the number, the thicker the product. Thicker products are less flowable, and in most cases, will fill a larger gap if necessary. The following chart relates viscosity to some products we are all familiar with:

Loctite® Brand Product Examples

Product	Approximate Viscosity in Centipose (cP)	Cyanoacrylates	Anaerobics
Water at 70°C	1-5	420™	–
Blood or Kerosene	10	–	290™
Anti-Freeze or Ethylene Glycol	15	406™	Letter Grade A
Motor Oil SAE 10 or Corn Oil	50-100	414™ / 496™	609™
Motor Oil SAE 30 or Maple Syrup	150-200	–	675™
Motor Oil SAE 40 or Castor Oil	250-500	4203™ / 4471™	640™
Motor Oil SAE 60 or Glycerin	1,000-2,000	403™ / 422™	222MS™ / 242® / 262™
Corn Syrup or Honey	2,000-3,000	410™ / 4211™	635™
Blackstrap Molasses	5,000-10,000	411™ / 382™	277™ / 620™
Chocolate Syrup	10,000-25,000	–	324™ / 326™
Ketchup or Mustard	50,000-70,000	409™	330™
Tomato Paste or Peanut Butter	150,000-250,000	–	592™
Shortening or Lard	1,000,000-2,000,000	–	660™
Caulking Compound	5,000,000-10,000,000	–	593™
Window Putty	100,000,000	–	–

Some products are considered thixotropic. This describes materials that are gel-like at rest but fluid when agitated. Ketchup is a good example that exhibits this property. Loctite® brand products include Loctite® 262™ Threadlocker and Loctite® 509™ Flange Sealant.

Shelf Life

What is the Henkel shelf life policy for Loctite® brand products?

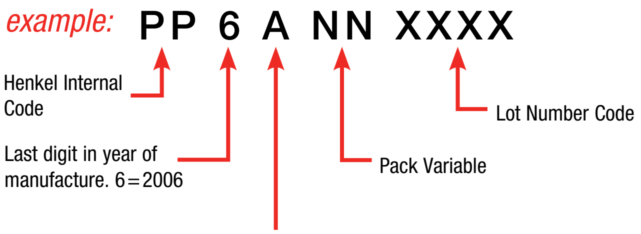
The shelf life period for Loctite® brand products is one year from date of shipment from Henkel facilities or as indicated by package labeling. For optimal storage, maintain product at a temperature between 8°C (46°F) to 21°C (70°F). Storage below 8°C (46°F) or greater than 28°C (82°F) can adversely affect product properties. Cyanoacrylate products must be stored under refrigerated conditions at 2°C (36°F) to 8°C (46°F). Storage below 2°C (36°F) or greater than 8°C (46°F) can adversely affect product properties. Products requiring storage at conditions other than those specified here are labeled accordingly. Material removed from containers may be contaminated during use. Do not return product to original containers. Henkel cannot assume responsibility for product which has been contaminated or stored under conditions other than as recommended. This policy supersedes all previous policies regarding shelf life and storage of Loctite® brand products.

Do the 10 character batch codes on containers signify the date of shipment?

NO... This code signifies date of manufacture. Certified shelf life is based on this code only if date of shipment cannot be determined. This is generally two (2) years from date of manufacturing for most products.

In most cases this process of checking batch codes predates the adoption of a "Use by Date" which is on the unit label and case cartons of most Loctite® Brand Industrial Products.

How do you read this 10 character batch code?



Month within year of manufacture, (e.g. A = January, B = February, C = March, etc., excluding the letter I, J = September).

NOTE: The Batch Code may be truncated on small package sizes, but the year and date will not be compromised when this is done.

Once a product reaches its "1 year from date of shipment" date, does this mean it can no longer be used?

No... Henkel offers a policy for extension of shelf life.
Contact Customer Service 1.800.LOCTITE (562.8483) for details.

Glossary

Compressive Strength (ASTM D695)

"Test Method for Compressive Properties of Rigid Plastics"

Continuous Service Temperature

The recommended continuous service temperature is an estimate of the highest temperature a plastic can continuously withstand over the life of an application. It is usually reported by the manufacturer and can be derived from the melting point, deflection temperature, and temperature at which a material's properties begin to severely diminish.

Deflection Temperature @ 66 psi (ASTM D648)

"Test Method for Deflection Temperature of Plastics Under Load"

Deflection Temperature @ 264 psi (ASTM D648)

"Test Method for Deflection Temperature of Plastics Under Load"

Density (ASTM D792)

"Test Method for Specific Gravity and Density of Plastics by Displacement"

Dielectric Constant (ASTM D150)

"Test Methods for A-C Loss Characteristics and Permittivity (Dielectric Constant) of Solid Electrical Insulating Materials"

Dielectric Strength (ASTM D149)

"Test Methods for Dielectric Breakdown Voltage and Dielectric Strength of Solid Electrical Insulating Materials at Commercial Power Frequencies"

Dissipation Factor (ASTM D150)

"Test Methods for A-C Loss Characteristics and Permittivity (Dielectric Constant) of Solid Electrical Insulating Materials"

Elongation, Break (ASTM D638)

"Test Method for Tensile Properties of Plastics"

Flexural Modulus (ASTM D790)

"Test Method for Flexural Properties of Unreinforced and Reinforced Plastics and Electrical Insulating Materials"

Flexural Strength, Yield (ASTM D790)

"Test Method for Flexural Properties of Unreinforced and Reinforced Plastics and Electrical Insulating Materials"

Hardness (ASTM D785)

"Test Method for Rockwell Hardness of Plastic and Electrical Insulating Materials"

Durometer (ASTM D2240)

"Test Method for Rubber Property Durometer Hardness"

Linear Mold Shrinkage (ASTM D955)

"Test Method for Measuring Shrinkage from Mold Dimensions of Molded Plastics"

Linear Thermal Expansion (ASTM D696)

"Test Method for Coefficient of Linear Thermal Expansion of Plastics"

Melting Point (ASTM D789)

"Test Method for Determination of Relative Viscosity, Melting Point, and Moisture Content of Polyamide"

Melting Point (ASTM D2117)

"Test Method for Melting Point of Semicrystalline Polymers by the Hot Stage Microscopy Method"

Notched Izod Impact Strength, R.T. (ASTM D256)

"Test Method for Impact Resistance of Plastics and Electrical Insulating Materials"

Processing Temperature

This is the average processing temperature recommended by manufacturers for commonly used processing methods.

Tensile Modulus (ASTM D638)

"Test Method for Tensile Properties of Plastics"

Tensile Strength, Break (ASTM D638)

"Test Method for Tensile Properties of Plastics"

Tensile Strength, Yield (ASTM D638)

"Test Method for Tensile Properties of Plastics"

Thermal Conductivity (ASTM C177)

"Test Method for Steady-State Heat Flux Measurements and Thermal Transmission Properties by Means of the Guarded-Hot-Plate Apparatus"

Thermoplastics

Thermoplastics are distinguished by their ability to be softened and reshaped through the application of heat and pressure. They can be processed in this manner because, unlike thermosets, they are made up of polymeric chains which are not joined by covalent bonds (crosslinks).

Thermosets

Thermosets are plastics whose polymeric chains are joined by covalent bonds (crosslinks) to form a three-dimensional network. Due to the formation of this three-dimensional network, thermoset resins cannot be softened or reshaped through the application of heat or pressure.

Water Absorption (ASTM D570)

"Test Method for Water Absorption of Plastics"

Index of Trade Names

Trade Name	Plastic Type	Manufacturer	Page Number
Epoxylite	Epoxy	Epoxylite Corporation	26
Ertalon	Polyamide (Nylon)	ERTA Inc.	36
Esbrite	Polystyrene	Sumitomo Chemical	64
Escorene	PE, PP	Exxon Mobil Chemical	50, 62
Estane	Polyurethane	BF Goodrich Chemical	66
Ferrex	Polypropylene	Ferro Corporation	62
Fibercore	Polyester, thermoset	American Cyanamid	42
Fiberite FM	Phenolic	ICI/Fiberite	34
Fiberloc	PVC	B. F. Goodrich	68
Fluon	PTFE	ICA Americas Inc.	28
Formion	Ionomer	A. Schulman	30
Fortiflex	Polyethylene	Solvay Polymers	50
Fortilene	Polypropylene	Solvay Polymers	62
Fortron	PPS	Hoechst Celanese	60
Fusabond	Polypropylene	DuPont Canada	62
Geloy	ASA	GE Plastics	18
Geon	PVC	B. F. Goodrich	68
Glastic	Polyester, thermoset	Glastic Company	42
Granlar	Polyester (LCP)	Granmont Inc.	32
Grilamid	Polyamide (Nylon)	EMS	36
Grilon	Polyamide (Nylon)	EMS	36
Halar	ECTFE	Ausimont USA, Inc.	28
Halon	ETFE	Ausimont USA, Inc.	28
Haysite	Polyester, thermoset	Haysite Reinforced Plastics	42
Hetron	Vinyl ester	Ashland Chemical Company	72
Hi-Zex	Polyethylene	Mitsui Petrochemical	50
HiGlass	Polypropylene	Himont USA, Inc.	62
Hostaflon	PTFE	Hoechst Celanese	28
Hostan GUR	Polyethylene	Hoechst Celanese	50
HX Series	Polyester (LCP)	E.I. DuPont	32
Hyflon	PFA	Ausimont USA, Inc.	28
Hyvex	PPS	Ferro Corporation	60
Impet	Polyester (PET)	Hoechst Celanese	52
Insultruc	Polyester, thermoset	Industrial Dielectrics	42
Interpol	Polyester, thermoset	Cook Composites	42
Isoplast	Polyurethane	Dow Chemical	66
Iupital	Acetal	Mitsubishi Gas	14
Jet	Polyester, thermoset	Jet Moulding	42
Kaofulex	Polystyrene	Kaofu Chemical	64
Kapton	Polyimide	E.I. DuPont	54
Karlex	Polycarbonate	Ferro Corporation	40
Kematal	Acetal	Hoechst Celanese	14
Kemlex	Acetal	Ferro Corporation	14
Kibisan	ASA	Chi Mei Industrial	18
Kinel	Polyimide	Rhone Poulenc, Inc.	54
Kodapak PET	Polyester (PET)	Eastman Chemical Products	52
Kodar	Polyester, thermoset	Eastman Chemical Products	42
Lexan	Polycarbonate	General Electric	40
Lumirror	Polyester (PET)	Toray Industries	52
Luran	ASA, SAN	BASF	18, 70
Lustran	ABS, SAN	Monsanto Chemical	20, 70
Lytex	Epoxy	Premix, Inc.	26
Magnum	ABS	Dow Chemical	20
Makrolon	Polycarbonate	Bayer Corp.	40
Maraglas	Epoxy	Acme	26
Maranyl	Polyamide (Nylon)	ICI Americas	36
Marlex	PE, PP	Phillips 66 Company	50, 62
Matrimid	Polyimide	Ciba - Geigy	54
Meldin	Polyimide	Furon	54
Microthene	Polyethylene	Quantum Chemical	50
Minlon	Nylon, PBT	E.I. DuPont	36, 38
Mirason	Polyethylene	Mitsui Petrochemical	50
Modar	Acrylic	ICI Acrylics	16
Moplen	Polypropylene	Himont USA, Inc.	62
Mor-Thane	Polyurethane	Morton	66
Mylar	Polyester (PET)	E.I. DuPont	52
Neo-zex	Polyethylene	Mitsui Petrochemical	50
Neuthane	Polyurethane	New England Urethane	66

Trade Name	Plastic Type	Manufacturer	Page Number
NEW-TPI	Polyimide	Mitsui Toastu	54
Nissan	Polyethylene	Maruzen	50
Nivionplast	Polyamide (Nylon)	Enichem Elastomers	36
Noblen	Polypropylene	Mitsubishi Petroleum	62
Norchem	PE, PP	Quantum Chemical	50, 62
Nortuff	Polypropylene	Quantum Chemical	62
Noryl	PPO	GE Plastics	58
Novablend	PVC	Novatec Plastics	68
Novamid	Polyamide (Nylon)	Mitsubishi Chemical	36
Novapol	Polyethylene	Novacor Chemicals	50
Novarex	Polycarbonate	Mitsubishi Chemical	40
Novatec-L	Polyethylene	Mitsubishi Chemical	50
Nupol	Vinyl ester	Cook Composites	72
Nybex	Polyamide (Nylon)	Ferro Corporation	36
Nylamid	Polyamide (Nylon)	Polymer Service	36
Nylatron	Polyamide (Nylon)	Polymer Corporation	36
Nyloy	Nylon, PP	Nytex Composites	36, 62
Nypel	Polyamide (Nylon)	Allied-Signal Corporation	36
Nyrim	Polyamide (Nylon)	DSM Engineering	36
Nytron	Polyamide (Nylon)	Nytex Composites	36
PA	Polyamide (Nylon)	Bay Resins	36
Panlite	Polycarbonate	Teijin Chem Ltd.	40
Paraplast	Epoxy	Hexcel Corporation	26
Paxon	Polyethylene	Allied-Signal Corporation	50
Pellethane	Polyurethane	Dow Chemical	66
Petlon	Polyester (PET)	Albis Corporation	52
Petra	Polyester (PET)	Allied-Signal Corporation	52
Petrothene	PE, PP	Quantum Chemical	50, 62
Plaslok	Phenolic	Plaslok Corporation	34
Plenco	Phenolic	Plastics Engineering Company	34
Plexiglas	Acrylic	Atofina	16
Pocan	Polyester (PBT)	Albis Corporation	38
Polychem	Phenolic	Budd Company	34
Polycor	Vinyl ester	Industrial Dielectrics	72
Polycure	Polyethylene	BP Performance	50
Polyfine	Polypropylene	Advanced Web Products	62
Polyflam	Polypropylene	A. Schulman, Inc.	62
Polyfort FLP	Polyethylene	A. Schulman, Inc.	50
Polyfort FPP	Polypropylene	A. Schulman, Inc.	62
Polylite	Polyester, thermoset	Reichhold Chemical	42
Polypro	Polypropylene	Mitsui Petrochemical	62
Polyrex	Polystyrene	Chi Mei Industrial	64
Polyrite	Polyester, thermoset	Polyply Inc.	42
Polysar	Polystyrene	Novacor Chemicals	64
Polystruc	Polyester, thermoset	Industrial Dielectrics	42
Polytron	Polyester, thermoset	Industrial Dielectrics	42
Polyvin	PVC	A. Schulman	68
Poxy Pak	Epoxy	Henkel Corporation	26
Premi-Glas	Polyester, thermoset	Premix, Inc.	42
Premi-Ject	Polyester, thermoset	Premix, Inc.	42
PRO-FAX	Polypropylene	Himont USA, Inc.	62
Pyrotex	Phenolic	Raymark Friction Company	34
Quatrex	Epoxy	Dow Chemical	26
Quirvil	PVC	Rukmianca SpA	68
Ren	Epoxy	Ciba-Geigy Corporation	26
Reny	Polyamide (Nylon)	Mitsubishi Gas	36
Rexene PP	Polypropylene	Rexene	62
Rexene PE	Polyethylene	Rexene	50
Rilsan	Polyamide (Nylon)	Atochem N. America	36
Rogers RX	Phenolic	Rogers Corporation	34
Rosite	Polyester, thermoset	Rostone Corporation	42
Rumiten	Polyethylene	Rumianca SpA	50
Rynite	Polyester (PET)	E.I. DuPont	52
Ryton	PPS	Phillips 66 Company	60
Sclair	Polyethylene	Novacor Chemical	50
Sclairfilm	Polyethylene	Novacor Chemical	50
Scotchply	Epoxy	3M Industrial Chemicals	26
Selar	Polyester (PET)	E.I. DuPont	52

Trade Name	Plastic Type	Manufacturer	Page Number
Shinko-Lac	ABS	Mitsubishi Rayon	20
Shinkolite	Acrylic	Mitsubishi Rayon	16
Silmar	Polyester, thermoset	BP Chemicals Inc.	42
Sinvet	Polycarbonate	Enichem Elastomers	40
Stanuloy	Polyester (PET)	MRC Polymers Inc.	52
Stanyl	Polyamide (Nylon)	DSM Engineering	36
Stycast	Epoxy	Emerson & Cuming	26
Stypol	Polyester, thermoset	Cook Composites	42
Styron	Polystyrene	Dow Chemical	64
Styronol	Polystyrene	Allied Resinous	64
Styvex	SAN	Ferro Corporation	70
Sumikathene	Polyethylene	Sumitomo Chemical	50
Sumipex	Acrylic	Sumitomo Chemical	16
Supec	PPS	GE Plastics	60
Superkleen	PVC	Alpha Chemical	68
Suprel	SAN	Vista Chemical Company	70
Surlyn	Ionomer	E.I. DuPont	30
Tactix	Epoxy	Dow Chemical	26
Taitalac	ABS	Taita Chemical Company	20
Technyl	Polyamide (Nylon)	Rhone Poulenc, Inc.	36
Tecoflex	Polyurethane	Thermedics Inc.	66
Tecolite	Phenolic	Toshiba Chemical Products	34
Tecothane	Polyurethane	Thermedics Inc.	66
Tedur	PPS	Bayer Corp.	60
Teflon	PTFE, FEP, PFA	E.I. DuPont	28
Tefzel	ETFE	E.I. DuPont	28
Tenac	Acetal	Asahi Chemical	14
Tenite	Cellulosic, PE, PP	Eastman Chemical Products	24, 50, 62
Tenite PET	Polyester (PET)	Eastman Chemical Products	52
Tenneco	PVC	Rimtech Corporation	68
Terblend	ASA	BASF	18
Texalon	Polyamide (Nylon)	Texapol Corporation	36
Texin	Polyurethane	Bayer Corp.	66
Tonen	Polypropylene	Tonen Petrochem	62
Toray	Polyester (PBT)	Toray Industries	38
Toyolac	ABS	Toray Industries	20
TPX	PMP	Mitsui Petrochemical	56
Traytuf	Polyester (PET)	Goodyear	52
Tuflin	Polyethylene	Union Carbide	50
Tyril	SAN	Dow Chemical	70
Ultem	Polyetherimide	GE Plastics	46
Ultradur	Polyester (PBT)	BASF	38
Ultraform	Acetal	BASF	14
Ultramid	Polyamide (Nylon)	BASF	36
Ultrason	Polyethersulfone	BASF	48
Ultra-wear	Polyethylene	Polymer Corporation	50
Unichem	PVC	Colorite Plastics	68
Unipol PP	Polypropylene	Shell Chemical Company	62
Unival	Polyethylene	Union Carbide	50
Valox	Polyester (PBT, PET)	GE Plastics	38, 52
Valtec	Polypropylene	Himont USA, Inc.	62
Vectra	Polyester (LCP)	Hoechst Celanese	32
Vekton	Polyamide (Nylon)	Norton Performance	36
Verton	Polyamide (Nylon)	LNP Engineering	36
Vespel	Polyimide	E.I. DuPont	54
Vestamid	Polyamide (Nylon)	Huls America	36
Victrex PEEK	PEEK	Victrex, USA	44
Victrex PES	Polyethersulfone	Victrex, USA	48
Volara	Polypropylene	Voltek	62
Vybex	Polyester (PBT)	Ferro Corporation	38
Vydyne	Polyamide (Nylon)	Monsanto Chemical	36
Vythene	PVC	Alpha Chemical	68
Wellamid	Polyamide (Nylon)	Wellman, Inc.	36
Xydar	Polyester (LCP)	Amoco Perform. Products	32
Yukalon	Polyethylene	Mitsubishi Petroleum	50
Zemid	Polyethylene	DuPont Canada	50
Zylar	Acrylic	Novacor Chemicals	16
Zytel	Polyamide (Nylon)	E.I. DuPont	36

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Suggestions concerning the compatibility of plastics with adhesives is based on test data and general knowledge concerning the chemical resistance of plastics. All thermoplastics have the potential to stress crack when exposed to uncured adhesive depending on the exposure time, part geometry, stresses, and plastic composition variables. Consequently, it is important that the end user evaluate the suitability of the adhesive in their process to insure that the adhesive does not detrimentally affect the performance of the plastic.

Suggestions for surface cleaners to be evaluated are based on test data and general information concerning the chemical resistance of the plastics. The chemical resistance of plastics can be affected by the exposure time, temperature, stress levels, and plastic composition variables. Consequently, it is important that the end user evaluate the suitability of the cleaning solvent in their process to insure that the solvent does not detrimentally affect the performance of the plastic.

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