



FASTENER SOLUTIONS, INC.

Phone (866)463-2910

Email: sales@fastenersolutions.com

FAS-BOND 120 Cyanoacrylate Adhesive

Medium Viscosity, Surface Insensitive

FAS-BOND 120 is a medium viscosity, fast curing, surface insensitive cyanoacrylate adhesive (CA). It is specifically formulated to bond difficult surfaces with high industrial strength.

APPLICATIONS:

- ✓ Ideal for bonding rough, porous and acidic surfaces including Wood, Cardboard, Balsa Wood, Rubbers, Plastics, Metals, Leather, etc.
- ✓ Wide variety of industrial manufacturing and repairing applications
- ✓ Meets Military specification A 46050C Type II Class II

BONDING TIMES:

Plastics	2-5 seconds	Rubbers	< 3 seconds
Wood	1-5 seconds	Leather	5-15 seconds
Metals	8-10 seconds	Ceramics	12-18 seconds

PHYSICAL PROPERTIES

Liquid

Composition	Surface insensitive Ethyl Cyanoacrylate
Appearance	Colorless liquid
Viscosity@ 25 °C	80-120 cps
Brookfield LVF, Spindle 1-60 rpm	

Cured Adhesive

Gap Filling	0.2 mm
Tensile Shear Strength	18-28 N/mm ²
Service Temperature Range	-60 to +80 °C
Full Cure	24 hours
Melting Point Temperature	160 to 170 °C

Shear Strength ASTM D 1002/DIN 53283

Grit Blasted Steel	> 20 N/mm ²
Etched Aluminum	> 18 N/mm ²
Rubbers	> 22 N/mm ²
Wood	> 25 N/mm ²
Polycarbonate	> 12 N/mm ²

Physical Properties:

Coefficient of thermal conductivity, ASTM C177, W.m ⁻¹ K ⁻¹	0.1
Glass Transition Temperature, ASTM E228,	120 °C
Coefficient of thermal expansion, ASTM D696, K ⁻¹	75 x 10 ⁻⁶

Electrical Properties:

Dielectric strength, ASTM D149, kV/mm	25
Volume resistivity, ASTM D257, Ohm.cm	1 x 10 ¹⁶
Dielectric constant, 25 °C, ASTM D150	2.7

APPLICATION INSTRUCTIONS

- ✓ All surfaces must be clean, dry, dust and grease free. Best result will be achieved with surfaces that have been lightly abraded immediately prior to bonding.
- ✓ If using accelerator apply to one component surface only. Apply thin film of adhesive to the other surface and bring the pieces together immediately. Hold for few seconds without disturbing the joints.
- ✓ When bonding "O" rings, cut a fresh surface onto each end of the rubber to gain the best possible strength.

The data contained herein are furnished for information only and are believed to be reliable. We cannot assume responsibility for the results obtained by others over whose methods we have no control. It is the user's responsibility to determine suitability for the user's purpose of any production methods mentioned herein and to adopt such precautions as may be advisable for the protection of property and of persons against any hazards that may be involved in the handling and use thereof. Heartland Adhesives, Inc. specifically disclaims all warranties expressed or implied, including warranties of merchantability or fitness for a particular purpose, arising from sale or use of Heartland Adhesives, Inc. products. Heartland Adhesives, Inc. specifically disclaims any liability for consequential or incidental damages of any kind, including lost profits. We recommend that each prospective user test his proposed application before repetitive use, using this data as a guide.