

PALM LABS ADHESIVES
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**TURBO FUSE SERIES 190-HT
(4000 cp HIGH TEMPERATURE)**

Palm Lab's Cyanoacrylate is a one component rapid bonding adhesive. TURBO FUSE SERIES 190-HT advanced formula is designed to polymerize instantly by absorbing surface moisture and is recommended for a multitude of applications that have high temperature, humidity, and vibration. The fast curing qualities make it especially desirable in high speed industrial production. TURBO FUSE SERIES 190-HT is ideal for use in applications that require a high temperature adhesive. For extreme gap fill, the use of an accelerator is highly recommended.

Part Numbers for this TDS: 15-190HT, 30-190HT

PHYSICAL PROPERTIES (Liquid State)

Base compound (Resin)	Ethyl Cyanoacrylate
Appearance	Clear liquid
Viscosity cP	3500 – 4500 cP
Specific Gravity	1.06
Flash Point	> 185°F
Shelf Life	1 Year
Soluble in Acetone, MEK, Amide, Methylene Chloride	

PHYSICAL PROPERTIES (Cured State)

Appearance	Clear-Hard
Operating Temperature Range	-58° to 221°F
Hot Strength @ 70°F	100%
Hot Strength @ 221°F	45%
Hot Strength @ 248°F	25%
Hot Strength @ 257°F	Intermittent
Tensile Strength (N/mm ²)	21
Gap Fill	0.008 "

MATERIAL SET UP TIME

Aluminum to Aluminum	20 to 30 seconds
Steel to Steel	45 to 100 seconds
Phenolic to Phenolic	< 90 seconds
Polycarbonate to Polycarbonate	50 to 60 seconds
Rubber to Rubber	15 to 30 seconds

INFORMATION ON THIS PRODUCT AND OTHERS SUPPLIED TO USER IS BASED ON OUR GENERAL EXPERIENCE AND IS GIVEN IN GOOD FAITH, BUT BECAUSE OF THE MANY PARTICULAR FACTORS WHICH ARE OUTSIDE OF OUR KNOWLEDGE AND CONTROL AND AFFECT THE USE OF THE PRODUCT, NO WARRANTY IS GIVEN OR IMPLIED WITH RESPECT TO SUCH INFORMATION. FREEDOM UNDER PATENTS, COPYRIGHTS AND REGISTERED DESIGNS CANNOT BE ASSUMED.

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