

HFT-TTA-35

Product Description:

HFT-TTA-35 a very high performance structural adhesive designed to work with “hard to bond” materials like: HDPE (high density polyethylene), LDPE (low density polyethylene), PE, polypropylene, ABS, nylon, Teflon, rubber, TPE’s (like Santoprene), polycarbonate, fiberglass, PVC and it bonds to concrete, steel, aluminum and glass. It is a modified polymer in a proprietary formulation supplied in a 10-1 ratio with cartridges.

Features & Benefits:

- One of top adhesives in the industry
- Bonds polyethylene & polypropylene
- Bonds dissimilar materials
- No special surface preparation necessary
- Very good chemical resistance
- Excellent resistance to water
- Replaces mechanical fasteners



Technical Data:

- VOC Content: 0 % (no solvents)
- Viscosity: Part A & Part B – 20,000 cps
- Color: Part A - White, Part B - Black, Mixed - Gray
- Pot Life/Working time: 3 minutes at 72 degrees F (22 degrees C)
- Time To Handling Strength: 2-3 hours at 72 degrees F (22 degrees C)
- Shore D Hardness: 60

Cured Materials

HDPE TO HDPE
 ABS to ABS
 Polypropylene to Polypropylene
 Nylon to Nylon
 Polycarbonate to Polycarbonate
 Teflon to Teflon
 Styrene to Styrene
 Steel to Steel
 Aluminum to Aluminum
 PVC to PVC

Lap Shear Strength (ASTM D1002) lbs/square inch at 75 degrees F

	24 Hours	48 Hours
HDPE TO HDPE	163	860
ABS to ABS	280	685
Polypropylene to Polypropylene	105	760
Nylon to Nylon	226	310
Polycarbonate to Polycarbonate	286	632
Teflon to Teflon	205	212
Styrene to Styrene	184	337
Steel to Steel	335	1256
Aluminum to Aluminum	320	1025
PVC to PVC	203	1260

Instructions:

If material to be bonded is smooth, first rough up surface with 120 grit sandpaper or emery cloth. Clean surface from dirt, grease, sanding particles, etc. Then place cartridge in dispensing gun and twist off cap. Pump the gun until both the black and white material comes out. Wipe the end of the cartridge clean. Then attach static nozzle mixer with a twisting motion. Apply uniform pressure and dispense adhesive until color and consistency is a uniform gray. (3" to 6" of material) Then apply adhesive to surfaces to be bonded and attach materials within the three minute working time at 72 degrees F (22 degrees C). Storage: store cartridges on their side in the shade or a cool location.

Packaging:

35 ml (1.18 fl oz) and 825 ml (28 fl oz) cartridges, bulk units available

Curing Time:

	42 Degrees F (lbs/sq in)	74 Degrees F (lbs/sq in)	95 Degrees F (lbs/sq in)
1 Hour	9	10	47
2 Hours	21	24	49
3 Hours	22	42	96
4 Hours	26	44	127
5 Hours	31	49	284
6 Hours	35	58	392
7 Hours	39	67	510
8 Hours	42	74	533
9 Hours	44	93	545
24 Hours	74	287	558
48 Hours	141	562	569

Limitations:

Store product on it's side at less than 78 degrees F. (26 degrees C). Substrate and air temperature should be above 40 degrees F (4 degrees C) during application. Cool weather will slow down cure time and hot weather will accelerate it. Always test a small portion of the adhesive to insure it is mixed properly and will gain strength before proceeding.

Warning:

Skin contact may cause irritation, redness or rash. Wash thoroughly with soap and water after handling. Use safety glasses and wear protective gloves. Use with adequate ventilation or if ventilation is poor, refer to MSDS for further information. See MSDS for complete information. For industrial use only. Keep out of reach of children.