

Technical Data Sheet Instantbond™ 115

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Product Description

Hernon® Instantbond™ 115 is a single component, fast curing, clear, medium viscosity cyanoacrylate instant adhesive formulated for electronic applications. **Instantbond™ 115** is designed for use with **Hernon®** accelerators to produce instant cures for tacking electronic components.

Typical Applications

- Tack jumper wires to coil forms.
- Tamper proofing adjustable components.
- Mounting standoffs, edge guides, and stiffeners to circuit boards.

Typical Properties (Uncured)

Property	Value
Chemical Type	Ethyl Cyanoacrylate
Appearance	Clear liquid
Viscosity @ 25°C, cP	700
Specific gravity	1.10
Flash point	See MSDS

Typical Properties (Cured)

Cured 24 Hours @ 22°C

Physical Properties

Property	Value
Coefficient of thermal expansion, K ⁻¹ , ASTM D696	80 × 10 ⁻⁶
Glass transition temperature, °C, ASTM E228	130
Coefficient of thermal conductivity, W/(m·K), ASTM C177	0.11
Temperature range, °C, (°F)	-55 to 82 (-65 to 180)
Gap Fill, mm (in.)	0.152 (0.006)

Electrical Properties

Property	Value
Dielectric Strength, kV/mm ASTM D149	36.6
Dielectric Constant @ 1 kHz ASTM D150	3.0
Dissipation Factor @ 1 kHz ASTM D150	0.028
Volume Resistivity, Ω·cm ASTM D257	7.2 × 10 ¹⁵
Surface Resistivity, Ω ASTM D257	66 × 10 ¹⁵

Typical Cured Performance

Shear Strength

Cured 2 minutes @ 22°C - tested according to ISO 4587

Substrate	Shear Strength N/mm ² (psi)
Steel (grit blasted)	≥ 5.4 (≥ 780)

General Information

This product is not recommended for use in pure oxygen and/or oxygen rich systems and should not be selected as a sealant for chlorine or other strong oxidizing materials.

For safe handling information on this product, consult the Material Safety Data Sheet (MSDS).

Directions For Use

1. Apply one coating of **Hernon® EF® Accelerator 52** to the area to be bonded, by spray, brush or dipping. Prior to application, contaminated surfaces may need special cleaning or degreasing to remove any dissolvable contamination.
Note: Because the solvent base of **EF® Accelerator 52** can affect certain plastics or coatings, checking all surfaces for compatibility is recommended.
2. Allow the accelerator time to evaporate under good ventilation until the surfaces are completely dry (approximately 15 to 30 seconds).

3. Apply **Instantbond™ 115** immediately after solvent has dried.

Note: If **Instantbond™ 115** is not applied to the accelerator within 45 seconds, accelerator should be reapplied.

4. Where possible, move surfaces in relation to each other for a few seconds on assembly to properly distribute the adhesive and for maximum activation.
5. Secure the assembly and await fixturing before any further handling.

Storage

Cyanoacrylate adhesives must be stored under refrigeration at a temperature of 40°F ± 5°F for extended shelf life. Before opening, the containers must be warmed to room temperature, otherwise, water may condense into the bottle and cause hardening of the adhesive. To prevent contamination of unused adhesive, do not return product to its original container.

Dispensing Equipment

Hernon® offers a complete line of semi and fully automated dispensing equipment. Contact **Hernon® Sales** for additional information.

These suggestions and data are based on information we believe to be reliable and accurate, but no guarantee of their accuracy is made. HERNON MANUFACTURING®, INC. shall not be liable for any damage, loss or injury, direct or consequential arising out of the use or the inability to use the product. In every case, we urge and recommend that purchasers, before using any product in full scale production, make their own tests to determine whether the product is of satisfactory quality and suitability for their operations, and the user assumes all risk and liability whatsoever, in connection therewith. Hernon's Quality Management System for the design and manufacture of high performance adhesives and sealants is registered to the ISO9001:2000 Quality Standard.