

Revised
January 2002



9411 Corsair Road
Frankfort, IL 60423
1-800-552-0299 Phone
1-815-464-5650 Fax

EMERGENCY PHONE 1-800-255-3924

TECHNICAL DATA SHEETS

HT 4000

Description:

HT 4000 combines excellent peel and impact resistance with high shear strength. This product is designed for high stress, temperature, humidity, vibration and impact applications.

Physical Properties:

COLOR	Clear
GAP FILL	.008
RESIN	Ethyl
VISCOSITY	4000 cps
TEMPERATURE	-60°F to +250°F
CURE SPEED	20 to 24 seconds
SPECIFIC GRAVITY	1.09

Handling Characteristics:

Shear Strength, ASTM D1002, DIN 53283	Value	Range
Grit Blasted Steel, N/mm ² (psi)	28 (3770)	24 to 32 (3195 to 4355)
Etched Aluminum, N/mm ² (psi)	20 (3770)	16 to 24 (3195 to 4355)
ABS, N/mm ² *	>7 (>885)	
PVC, N/mm ² *	>5 (>640)	
Polycarbonate, N/mm ² *	>6 (>825)	
Phenolic, N/mm ² *	12 (160)	6 to 18 (775 to 2450)
Neoprene rubber, N/mm ² *	>12 (>1600)	
Nitrile rubber, N/mm ² *	>12 (>1600)	
Tensile Strength, ASTM D2095, DIN 53283		
Grit Blasted Steel, N/mm ² (psi)	20 (3000)	14 to 28 (1900 to 4000)

* Substrate Failure

Engineering Excellence

For technical information
and support call **1-800-552-0299** or visit our website at

www.instantca.com