



## 2028

2028 is a single component medium viscosity cyanoacrylate adhesive. It is fast setting and ideal for rubber and plastic bonding applications. 2028 is also formulated for use in medical applications, as it is certified to ISO biocompatibility standards 10993-5, 10993-10, and 10993-11.

<b>Technology / Base</b>	Ethyl
<b>Type of Product</b>	Cyanoacrylate
<b>Components</b>	One Component
<b>Curing</b>	Humidity
<b>Appearance / Color</b>	Clear
<b>Consistency</b>	Wicking Liquid

### Technical Data

Rheology	Value	Condition/Method
Viscosity	200 +/- 40 cPs	
<b>Density</b>		
Specific Gravity	1.06	
<b>Uncured Material Characteristics</b>		
Flash Point	85°C (185°F)	
Set Time	Steel 20 - 50 sec ABS 2 - 4 sec EPDM 1 - 4 sec	
Shelf Life	12 mo	
<b>Cured Material Characteristics</b>		
Full Cure Time	24 hours	
Cure Appearance	Clear	
Service Temperature	-55 to 95°C	
RoHS Compliant	yes	
<b>Cured Mechanical Properties</b>	See Graphs and Table Below	

### General Instructions

Surfaces to be bonded should be clean and dry. Dispense a drop or drops to one surface only. Apply only enough to leave a thin film layer after compression. Press parts together and hold firmly for a few seconds. Good contact is essential. An adequate bond develops in less than one minute and maximum strength is attained in 24 hours. Wipe off excess adhesive from the top of the container and recap. Products if left uncapped may deteriorate by contamination from moisture in the air. Because products cure by polymerization, whitening may appear on the surface of the container or the bonded materials. This will not affect adhesive performance.

### Curing Performance

Ambient surface moisture initiates the curing process. Handling strength is reached in a short time, and will vary based on environmental conditions, bond line gap, and other factors. Product will continue to cure for at least 24 hours before full strength and solvent resistance is developed.

### Storage

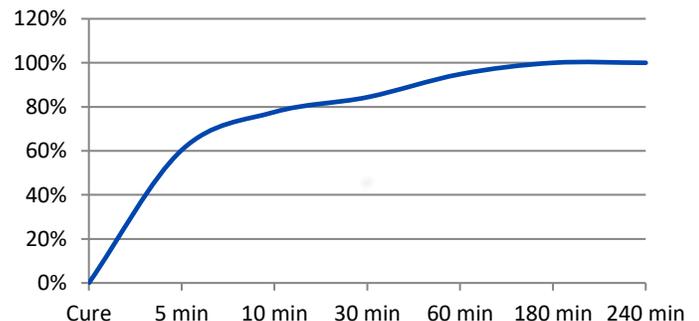
Containers should be stored in a cool, dry, dark area. Storage temperature 15.5°C - 25°C (60°F - 77°F), without exposure to direct light or heat. Do not refrigerate.

### Specifications and Approvals

10993-5, 10993-10, 10993-11

Mil-A-46050C, Type II Class II, A-A-3097, Type II Class 2

### Time Until Full Cure (% of RT strength)

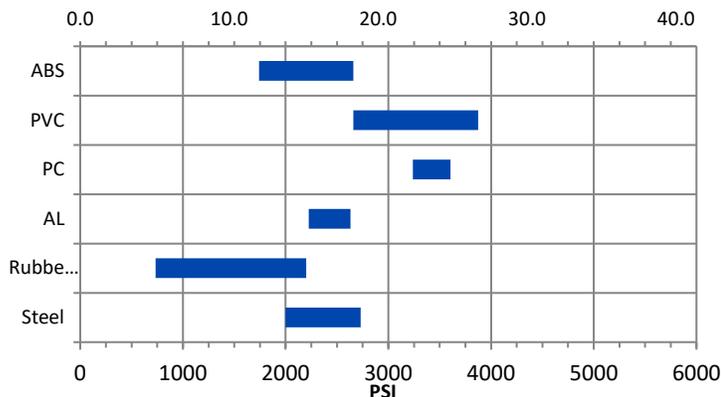


### Safety & Disposal

For safe handling information and disposal instructions on this product, consult the Safety Data Sheet (SDS)



## Performance Range by Substrate (N/mm<sup>2</sup>)



## Performance of Cured Adhesive

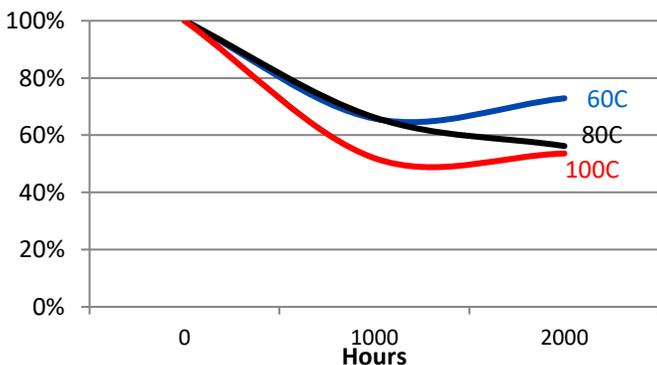
Substrate	N/mm <sup>2</sup>		PSI	
Steel	13.8	to 18.8	2000	to 2730
Rubber*	5.1	to 15.2	735	to 2200
AL	15.3	to 18.1	2225	to 2630
PC**	22.3	to 24.9	3240	to 3605
PVC**	18.3	to 26.7	2660	to 3875
ABS**	12.0	to 18.3	1740	to 2660

\*Rubber figures given are typical. Your results may vary by specific rubber type.

\*\*Tested to ASTM 4501

\*\*\*n/r = not recommended

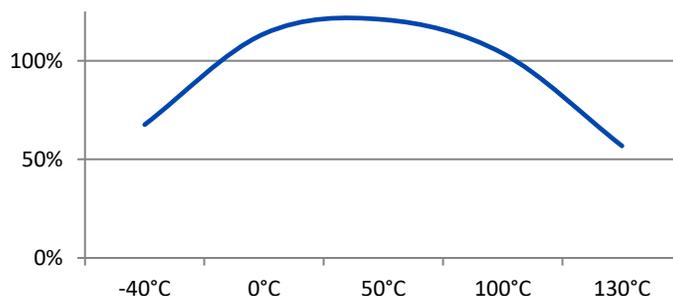
## Heat Aging (aged at temp indicated and tested @ 22°C)



## Solvent Resistance

Solvent	Example	Resistance
Alcohol	Ethanol, Methanol	+++
Ester (aromatic)	Ethylacetate	+++
Ketone (aromat)	Acetone, Benzophenone	---
Aliphatic hydrocarbon	Petrol, Heptanes, Hexane	+-
Aromatic hydrocarbons	Benzyl, Toluol, Xylol	+-
Halogenated hydrocarbons	Methylenchloride, Chloroform, Chlorobenzol	---
Weak aqueous	Nitrite, muriatic acid, sulphuric acid, phosphoric acid	+++ (--- if concentrated)
Weak aqueous base	sodium hydroxide solution, caustic potash	+++ (--- if concentrated)

## Hot Strength (%RT strength, tested at temperature)



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