



2077

2077 is a single component, medium viscosity cyanoacrylate adhesive. It is suitable for general-purpose bonding, particularly providing excellent strength and speed on all rubber compounds. 2077 is certified to ISO 10993-5, 10993-10 and 10993-11 for biocompatibility, making it suitable for use in medical applications.

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

Technical Data

Rheology	Value	Condition/Method
Viscosity	800 +/- 150 cPs	
Density		
Specific Gravity	1.06	
Uncured Material Characteristics		
Flash Point	85°C (185°F)	
Set Time	35 sec	
	6 sec	
	4 sec	
Shelf Life	12 mo	
Cured Material Characteristics		
Full Cure Time	24 hours	
Cure Appearance	Clear	
Service Temperature	-55 to 95°C	
RoHS Compliant	yes	
Cured Mechanical Properties	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

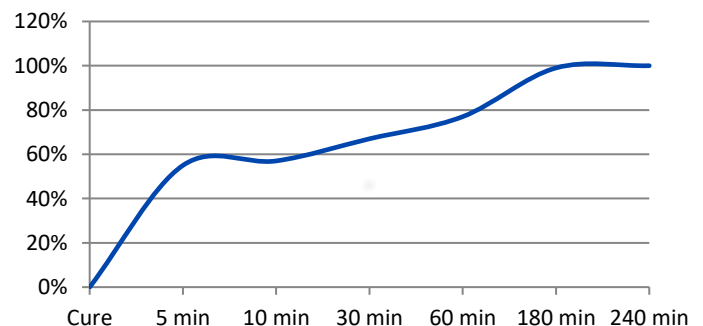
Containers should be stored in a cool, dry, dark area. Storage temperature 15.5°C - 25°C (60°F - 77°F), without exposure to direct light or heat. Do not refrigerate.

Specifications and Approvals

10993-5, 10993-10, 10993-11

Mil-A-46050C, Type II Class III, A-A-3097, Type II Class 3

Time Until Full Cure (% of RT strength)

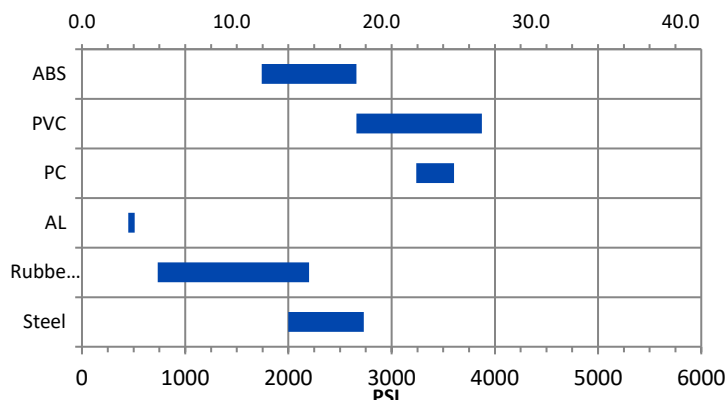


Safety & Disposal

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



Performance Range by Substrate (N/mm²)



Performance of Cured Adhesive

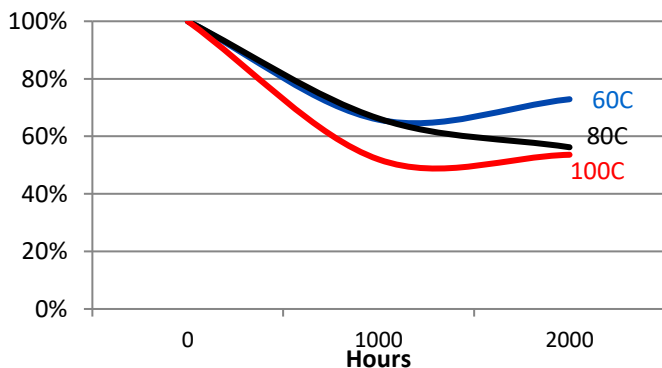
Substrate	N/mm ²			PSI		
Steel	13.8	to	18.8	2000	to	2730
Rubber*	5.1	to	15.2	735	to	2200
AL	3.1	to	3.5	450	to	510
PC**	22.3	to	24.9	3240	to	3605
PVC**	18.3	to	26.7	2660	to	3875
ABS**	12.0	to	18.3	1740	to	2660

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

**Tested to ASTM 4501

***n/r = not recommended

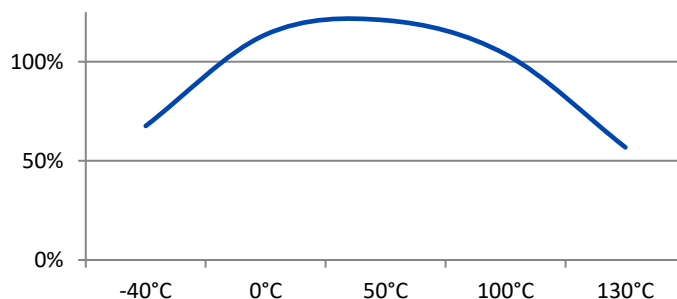
Heat Aging (aged at temp indicated and tested @ 22°C)



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)



Date Modified: 13 March 2017

H.B. Fuller Company
9001 W. Fey Drive
Frankfort, IL 60423
+1.800.552.0299
www.hbfuller.com

Connecting what matters.™

IMPORTANT: Information, specifications, procedures and recommendations provided ("information") are based on our experience, and we believe this information to be accurate. No representation, guarantee or warranty is made as to the accuracy or completeness of the information or that use of the product will avoid losses or damages or give desired results. It is purchaser's sole responsibility to test and determine the suitability of any product for the intended use. Tests should be repeated if materials or conditions change in any way. No employee, distributor or agent has any right to change these facts and offer a guarantee of performance.

® and ™ are trademarks of H.B. Fuller Company or one of its affiliated entities.

NOTE TO USER: by ordering/receiving product you accept the **H.B. Fuller General Terms and Conditions of Sale** applicable in the region. Please request a copy if you have not received these. These Terms and Conditions contain disclaimers of implied warranties (including but not limited to disclaiming warranties of fitness for a particular purpose) and limits of liability. All other terms are rejected. In any event, the total aggregate liability of H.B. Fuller for any claim or series of related claims however arising, in contract, tort (including negligence), breach of statutory duty, misrepresentation, strict liability or otherwise, is limited to replacement of affected products or refund of the purchase price for affected products. H.B. Fuller shall not be liable for loss of profit, loss of margin, loss of contract, loss of business, loss of goodwill or any indirect or consequential losses arising out of or in connection with product supply.



H.B. Fuller
www.hbfuller.com