

## IsoBond HBN 5233

IsoBond HBN 5233 is fast setting, two-component polyurethane adhesive. This product is designed for bonding many plastics as well as aluminum parts.

### PRODUCT ADVANTAGES

- Bonds to many substrates
- High strength and sandable
- Non-sag formulation is gap filling

\*Values given are not intended to be used in specific preparation

### Component Properties

Color - ISO	yellow
Color - POL	black
Specific Gravity - 74°F, ISO	1 - 1.25
Specific Gravity - 74°F, POL	1 - 1.1
Viscosity - ASTM D-2196 - 74°F, ISO	700 - 1100 cps
Viscosity - ASTM D-2196 - 74°F, POL	500 - 1060 cps

### Reactivity Profile

Bead Open Time - 1/4 inch	50 Seconds
Set Time - Wooden Block - Normal	2.2 Minutes
Clamp Time	15 Minutes
Ratio by Weight - ISO:POL	1.12 - 1
Ratio by Volume - ISO:POL	1 - 1

### Typical Physical Properties

Lap Shear ABS - ASTM D1002	160 psi
Lap Shear Acrylic - ASTM D1002	45 psi
Lap Shear Aluminum - ASTM D1002	2100 psi
Lap Shear Maple - ASTM D1002	650 psi
Lap Shear PVC - ASTM D1002	121 psi
Lap Shear SMC - ASTM D1002	600 psi
Hardness - ASTM D2240 - Shore D	70 Shore D
Tensile Strength - ASTM D412	8600 psi

### RECOMMENDED HANDLING INSTRUCTIONS

Isotec® International's Recommended Application and Handling Instructions

- Surfaces should be clean and dry before applying adhesive
- Clean plastic surfaces with isopropyl alcohol before gluing to remove any mold release, oil, or plasticizer contamination.
- Clean rubber, and aluminum, with MEK before gluing.
- Mechanical sanding of surfaces can improve adhesion beyond the typical values indicated in this document.
- Place parts together within the open time of the adhesive, then hold or clamp the parts until the set time passes.
- Cured adhesive is removable by cutting, scraping, or sanding, but not by burning.

-Use only in well-ventilated areas.

-Wear chemically resistant rubber gloves, safety glasses, and an apron.

-Avoid prolonged or repeated contact with skin.

-In case of skin contact, wipe affected area with isopropyl alcohol, followed by soap and water.

-In case of eye contact, flush eyes with water for 15 minutes and consult a physician.

-If swallowed or comes into contact with eyes, seek medical attention immediately.

## STORAGE

Protect ISO and POL side from moisture. If the ISO side material is exposed to moisture, including moisture from the air, it will release CO<sup>2</sup> gas. If placed in a sealed container, this gas can cause a dangerous build up of pressure potentially resulting in injury or death. If the POL side is exposed to excess moisture and then applied it may cause weak or foamed material to be applied.

## SAFETY

-Refer to the product SDS for all relevant safety information.

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- Reported laboratory test results of the color stability in no way relates to the actual performance upon exposure to light sources. Since all aromatic urethanes experience color degradation upon ultraviolet light exposure, Seller shall not be liable for any damages resulting from ultraviolet light color degradation of any aromatic urethane systems manufactured or sold by Seller.
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