

IsoBond HBN 5234

IsoBond HBN 5234 is a two-component polyurethane adhesive with a 3 minute working time. It was designed for adhering to many plastics and aluminum.

PRODUCT ADVANTAGES

- High strength and sandable
- Non-sag

*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	3 Minutes
Set Time - Wooden Block - Normal	8 Minutes
Clamp Time	30 Minutes
Ratio by Weight - ISO:POL	1.12 - 1
Ratio by Volume - ISO:POL	1 - 1

Typical Physical Properties

Lap Shear Aluminum - ASTM D1002	2100 psi
Lap Shear SMC - ASTM D1002	600 psi
Hardness - ASTM D2240 - Shore D	70 Shore D
Tensile Strength - ASTM D412	7300 psi

RECOMMENDED 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.

STORAGE

Protect Iso and Poly side from moisture. If the Iso side material is exposed to moisture, including moisture from the air, it will release CO₂ 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 Poly side is exposed to excess moisture and then applied it may cause weak or foamed material to be applied.

Always mix/roll Poly side prior to use to ensure a homogenous product.

SAFETY

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

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- THERE ARE NO WARRANTIES, EXPRESS OR IMPLIED, INCLUDING ANY WARRANTIES OR MERCHANTABILITY OR FOR ANY PARTICULAR PURPOSE. While all data presented in Seller's technical data sheet is based on the best information available to Seller and believed correct, such data is not to be construed as a warranty that the product will conform to such specifications. Such technical data sheets are subject to change without notice. Reported laboratory test results of fire redundancy in no way relates to the actual performance under fire conditions. Since all urethane systems are organic, they will burn.
- 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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