



## PRODUCT CHARACTERISTICS

Appearance (uncured)	White
Uncured Viscosity* (ASTM D1084: 130°C)	Approx 5500 mPa.s
Open time**	75 sec.
Operation Temperature	100°C - 130°C
Density - cured (ASTM D792)	1.1

\*based on Brookfield viscometer

\*\*Open time is an application parameter that depends on the environment temperature, substrates and application process.

## TYPICAL PERFORMANCE OF CURED MATERIAL

Cure rate is dependent upon substrate type, moisture permeability and ambient conditions. HHD 6002 will develop adhesive properties within 24 hours. However, optimum properties are achieved after three to seven days at room temperature.

For all the performance data provided in this TDS, the samples were prepared as follows : A 1.5mm\*2mm width adhesive bead was applied on PC to PC with a 0.12mm spacer. A 1kg weight was applied for 20 seconds on the sample, which was then cured for 3 days @ 23°C/50%RH before testing. The tests were performed at 2mm/min

## CURED PHYSICAL PROPERTIES

Tensile Elongation at Break	1125.6%
Tensile Strength	12.1 MPa
Elastic Modulus (DIN 53504/ ISO37)	56 MPa
Curing Shrinkage (ISO 3521)	0.9%

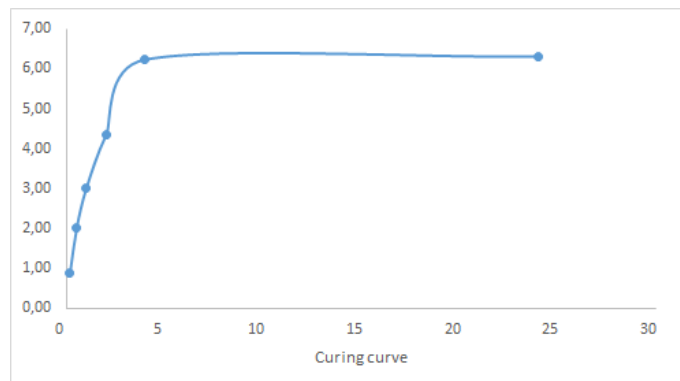
## HAND HOLD SPECIFIC DATA

Sebum and sweat resistance*	Good
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\*Internal Test Methods

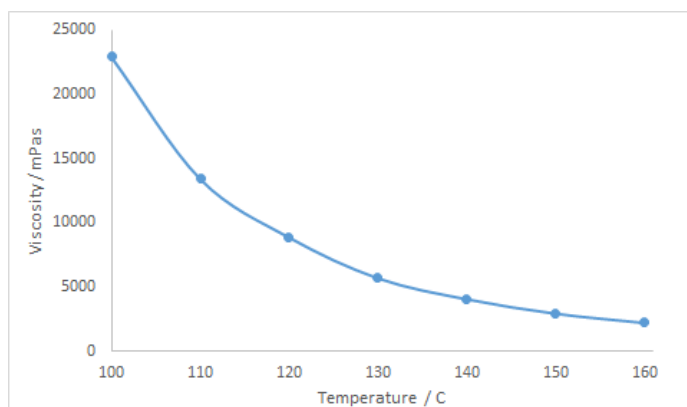
## CURING SPEED

Test condition: PC-PC with supporting, 23°C/50% H, 0.12mm spacer, 1.5mm\*2 width adhesive bead, 1Kg weight@20 second, test method @ 2mm/min.



## APPLICATION PROCESS - VISCOSITY

9DRS 2 DSGNC#' QNNOEHDK" ' ROHMCKD' fiz' @fi COL " ' fiz' '@ Ži % - "

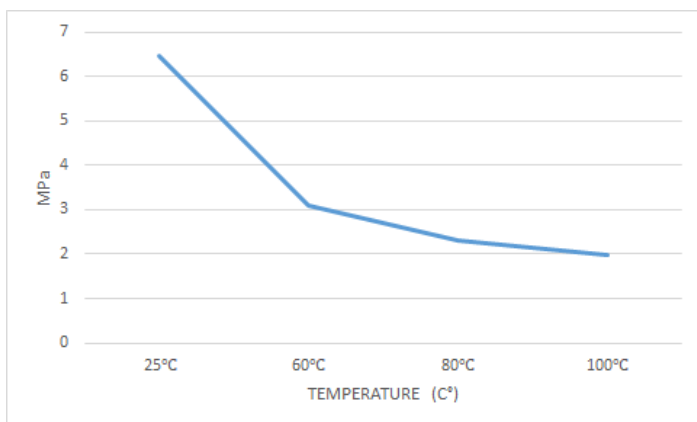


## BONDING PERFORMANCE

Glass - Glass (Bare)	5.17
PC - PC	6.45
ABS - ABS	3.64
304 Steel - 304 Steel	3.79
Rilsan® PA 820 - PA 820 with Supporting	3.20
Rilsan® PA 820 - Steel	3.36

## HOT STRENGTH

Test condition : PC-PC with supporting, 23°C/50% H 7days, 0.12mm spacer, 1.5mm\*2 width adhesive bead, 1Kg weight @ 20 second, test @ 2mm/min, test after heat for 5min in the chamber.



## CONVERSIONS

$$(^{\circ}\text{C} \times 1.8) + 32 = ^{\circ}\text{F}$$

$$\text{kV/mm} \times 25.4 = \text{V/mil}$$

$$\text{mm} / 25.4 = \text{in}$$

$$\mu\text{m} / 25.4 = \text{mil}$$

$$\text{N} \times 0.225 = \text{lb}$$

$$\text{N/mm} \times 5.71 = \text{lb/in}$$

$$\text{N/mm}^2 \times 145 = \text{psi}$$

$$\text{MPa} \times 145 = \text{psi}$$

$$\text{N}\cdot\text{m} \times 8.851 = \text{lb}\cdot\text{in}$$

$$\text{N}\cdot\text{mm} \times 0.142 = \text{oz}\cdot\text{in}$$

$$\text{mPa}\cdot\text{s} = \text{cP}$$

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