

Intek Adhesives Ltd

RTV Silicones to Bond, Seal, Insulate & Weatherproof

XR 1500 High Viscosity Adhesive

XR 1500 is a higher viscosity cyanoacrylate specially formulated for the bonding of plastics, rubbers, wood, paper, cardboard, leather, metals and other common substrates. XR 1500 relies less on surface moisture for cure speed than standard cyanoacrylates and has excellent gap-filling capability. It is also slower setting allowing positioning time for smaller parts

Physical Properties of Uncured Adhesive

Chemical composition	Ethyl cyanoacrylate
Appearance	Clear
Viscosity @ 25°C	1250 - 1600 mPa.s (cP)
Density	1.08

Typical Curing Properties

Maximum gap fill	0.20 mm
Handling time	45 seconds (Steel) 60 seconds (Aluminium) 25 seconds (Buna N Rubber) 30 seconds (Phenolic) Full strength 24 hours

Temperature Resistance -50 to + 90

Typical Performance of Cured Adhesive

Shear strength* ASTM D1002	
Steel	20-23 N/mm ²
Aluminium	13-15 N/mm ²
ABS	>6 N/mm ²
Tensile Strength	21 N/2mm ²
Glass Transition	50°C (140°F)
Coefficient of thermal expansion	90 x 10 ⁻⁶ mm/mm/°C
Dielectric strength	10 mV/mm
Hardness 85 Shore A	

**Strength results will vary depending on the level of surface preparation and gap.*

Whilst all reasonable care is taken in compiling technical data on the company's products, all recommendations or suggestions regarding the use of such products are made without guarantee since the conditions of use are beyond the control of the company. It is the customer's responsibility to satisfy himself that each product is fit for

the purpose for which he intends to use it, and that the actual conditions of use are suitable.

Unit 20 Atley Business Park, Cramlington, Northumberland NE23 1WP

Tel : 01670 734400

 enquiry@intek-uk.com

www.intek-uk.com

TECHNICAL DATA