

DHT-350(A,B)

Second Generation Acryl Adhesive

**DAEHEUNG CHEMICAL**

DHT-350(A,B) is two component modified acrylic monomer base adhesive, which is the quickly curing type, good workability and bonding strength for the various materials.

1. Uses

- Parts of an electronic, parts of a motors, etc. (Metal, ABS, FRP, various soft and hard type plastics.)
- The use of common industry. (Glass, rubber, ceramic, stone, wood, etc.)

2. Characteristics

- Quickly curing type.(Curing time 5~10 min)
- Adhesion is good to various materials. (Metal, acrylic, ABS, FRP, etc.)
- Superb resistance to impact, heat, water, chemical and weather.
- Good workability.

3. Physical properties

Properties	DHT-350A (Resin)	DHT-350B (Hardener)	Reference
Main component	Modified acrylate		
Color	Blue viscous liquid	Pink viscous liquid	
Solid contents	98±1 %		at 105±5 °C × 3hr
Viscosity	8,000±1,000 cps		at 25 °C, BF#5, 10rpm
Specific gravity	1.0±0.1 g/cm ³		at 20 °C
Mixing ratio	1:1		By weight
Pot life	Within 15 min		at 20 °C
Temperature resistance	-40 °C ~150 °C		at 20 °C
Shelf life	3 months in unbroken package under dry and cool condition		

4. How to use

- Two component mixing and non mixing method.

- Mixing method

After two components mixing (mixing ratio 1:1) immediately coat it with each surface, and then press them.

- Non mixing method

Coat component A with one material surface and coat component B with another material surface, and then

press them. (Unlimited curing time.)

- Auto applicator method

You can continual coat mixed material or non mixed material by auto applicator.

- Application amount: 200 ~ 500g/m²

5. Adhesion property

- Adhesion strength

Adhesion property	Test value	Reference
Shear strength (kg/cm ²)	255	
Peel strength (kg/25mm)	10	
Impact strength (kgf cm/cm ²)	32	
Heat resistance strength(kg/cm ²)	60	at 130℃

- Adhesion strength(As curing time)

time Item	10min	24hour	96hour	Reference
Shear strength (kg/cm ²)	155	240	255	
Impact strength (kgf cm/cm ²)	12	29	32	

- Adhesion strength(As heat resistance)

Item condition	Shear strength (kg/cm ²)	Impact strength (kg,cm/cm ²)	Reference
Heat aging	205	25	
Cold resistance	241	-	
Heat resistance	58	31	

- Adhesion strength(As chemical resistance)

condition Item	H ₂ O	10% HCl	10% NaOH	Toluene	Acetone	Reference
Shear strength (kg/cm ²)	190	120	115	195	160	
Impact strength (kg cm/cm ²)	18	13	13	23	18	

6. Caution

- Avoid direct rays of the sun and keep in cool and dry place.
- Keep it away from the fire.
- Close the cap tightly after using it.
- Ventilation the room well because of containing solvent.
- Don't use except for the original purpose.

7. Packaging

- DHT-350(A): 2.5kg PE C/N
- DHT-350(B): 2.5kg PE C/N

Please contact us for further information or see Material Safety Data Sheet (MSDS) for this product.

DAEHEUNG CHEMICAL CO., LTD.

68, Sandan-ro 64beon-gil, Pyeongtaek-si, Gyeonggi-do, Korea

Telephone +82-2-554-8211, +82-31-668-1424

Facsimile +82-2-554-8215, +82-31-668-1425

Website www.dhcbond.co.kr



DAEHEUNG CHEMICAL