

## Adhesive Products

| Part Number      | Adhesive Type                              | Features   | Working Time | Handling Strength |  | Full Cure                                | Strength               |                       | Service Temp Range  |
|------------------|--|--|--------------|-------------------|--|--|------------------------|-----------------------|---|
|                  |  |  |              |                   |  |  | Shear (ASTM D1002)     | Peel (ASTM D1876)     |   |
| CB200            | Acrylic Structural Adhesive                | <ul style="list-style-type: none"> <li>Bonds a wide variety of metals, engineering plastics, and composites</li> <li>Cures quickly at room temperature.</li> <li>Bonds irregular shapes and inaccessible surfaces</li> <li>Excellent environmental and chemical resistance</li> <li>Water resistant</li> </ul>   | 5 min        | 30 min            |  | 24 hrs                                   | 4400 psi<br>(30.3 MPa) | 21 pli<br>(3.7 kN/m)  | -67°F - 250°F<br>(-55°C - 121°C)  |
| CB250            | Acrylic Structural Adhesive                | <ul style="list-style-type: none"> <li>Bonds ABS, PVC, acrylic, styrene, metals, wood, and ceramics</li> <li>High shear, peel, and impact strength</li> <li>Cures quickly at room temperature</li> <li>Bonds gaps from 0.003 - 0.125 inches</li> <li>Excellent environmental resistance</li> </ul>   | 5 min        | 30 min            |  | 24 hrs                                   | 3500 psi<br>(24.1 MPa) | 37 pli<br>(6.5 kN/m)  | -67°F - 250°F<br>(-55°C - 121°C)  |
| CB300            | Epoxy Structural Adhesive                  | <ul style="list-style-type: none"> <li>Bonds to most substrates including metal, wood, concrete, ceramics and many plastics</li> <li>Recommended for fast patching, fixturing, and other repairs requiring quick handling strength</li> <li>Excellent fast-setting general purpose adhesive</li> </ul>   | 3 min        | 15 - 30 min       |  | 60 min                                   | 3000 psi<br>(20.7 MPa) | 1.8 pli<br>(0.3 kN/m) | -40°F - 180°F<br>(-40°C - 82°C)   |
| CB301            | Epoxy Structural Adhesive                  | <ul style="list-style-type: none"> <li>Bonds a wide variety of metals</li> <li>Good peel and shear strength</li> </ul>   | 5 min        | 24 hrs            |  | 7 days                                   | 4500 psi<br>(31.0 MPa) | 50 pli<br>(8.8 kN/m)  | -67°F - 250°F<br>(-55°C - 121°C)  |
| CB309            | Epoxy Structural Adhesive                  | <ul style="list-style-type: none"> <li>Bonds metals, FRP, wood, rubber, and other materials</li> <li>Excellent environmental and chemical resistance</li> <li>Ideal for gap filling and use on vertical surfaces</li> </ul>  | 90 - 120min  | 8 - 16 hrs        |  | 24 - 48 hrs                              | 1550 psi<br>(10.7 MPa) | 2.2 pli<br>(0.4 kN/m) | -30°F - 250°F<br>(-34°C - 121°C)  |
| CB359            | Epoxy Structural Adhesive                  | <ul style="list-style-type: none"> <li>Bonds a wide variety of metals, thermoplastics, wood, concrete and composites</li> <li>High peel, tensile, and lap shear strength</li> <li>Low outgassing</li> <li>Excellent resistance to water, salt spray, and organic fluids</li> </ul>   | 60 min       | 24 hrs            |  | 5 - 7 days<br>or 1 hr at<br>180°F (82°C) | 4500 psi<br>(31.0 MPa) | 60 pli<br>(10.5 kN/m) | -67°F - 200°F<br>(-55°C to 93°C)  |
| CB394            | High Temperature Epoxy Structural Adhesive | <ul style="list-style-type: none"> <li>Bonds metals, many thermoplastics, and thermoset composites</li> <li>Excellent strength to 350°F / 177°C and higher</li> <li>Low outgassing</li> <li>Ideal for potting, filling, and liquid shim applications</li> </ul>  | 90 min       | 24 hrs            |  | 3 - 5 days<br>or 1 hr at<br>150°F (65°C) | 4200 psi<br>(30.0 MPa) | 5 pli<br>(0.9 kN/m)   | -67°F - 350°F   |
| CB420<br>CB420E* | Acrylic Structural Adhesive                | <ul style="list-style-type: none"> <li>Bonds ABS, acrylics, aluminum, FRP, PVC, carbon steel, and stainless steel</li> <li>Cures quickly at room temperature</li> <li>High strength, excellent fatigue endurance, outstanding impact resistance, and superior toughness</li> <li>Excellent environmental and chemical resistance</li> </ul>  | 4 - 6 min    | 15 - 18 min       |  | 24 hrs                                   | 3050 psi<br>(21.0 MPa) | 28 pli<br>(4.9 kN/m)  | -40°F - 250°F<br>(-40°C - 121°C)  |
| CB440            | Polysulfide Sealant                        | <ul style="list-style-type: none"> <li>Designed for fillet sealing of fuel tanks and other sealing applications</li> <li>Maintains excellent elastomeric properties after prolonged exposure to both jet fuel and aviation gas</li> <li>Excellent flexibility for high-shock environments</li> <li>Cures at room temperature</li> <li>Excellent resistance to water, salt water, alcohols, petroleum-base and synthetic lubricating oils, and petroleum-base hydraulic fluids</li> </ul> | 30 min       | 10 hrs            |  | 30 hrs                                   | N/A                    | 25 pli<br>(4.4 kN/m)  | -65°F - 250°F<br>(-54°C - 121°C),<br>with intermittent<br>excursions up to<br>275°F (135°C) |

\* REACH compliant version developed for European market.

**Note:** All times measured at 75°F (24°C) and are significantly affected by temperature. Refer to adhesive data sheet for more details.