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Product Description Sheet

Hysol® Product

Aerobond 2034

Industrial Products, August 2001

Description

Loctite® Hysol® Aerobond 2034 is a two part, modified, low viscosity adhesive.

Features

Good Tensile Sheer Strength

Self Leveling

1 : 1 Ratio by volume

Packaging

One Gallon Systems, Two per carton

GENERAL INFORMATION

This product is not recommended for use in pure oxygen and/or oxygen rich systems and should not be selected as a sealant for chlorine or other strong oxidizing materials.

For safe handling information on this product, consult the Material Safety Data Sheet, (MSDS).

Storage

Store product in unopened container in a cool dry location. Ideal conditions are within the range 8 to 21 degrees C (46 to 70 degrees F) and are recommended for long term storage. Exposure to higher temperatures (greater than 28 degrees C) for prolonged periods should be avoided as extended exposure to warm conditions can adversely affect product properties. For further specific shelf life information, contact your local Technical Service Center.

Note

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Typical Uncured Properties	Part A	Part B	Mixed
Pot Life @ 77°F, 150 grams hours			3 to 3.5
Color	Straw	Amber	Amber
Viscosity, cP	11,000 to 15,000	6,000 to 10,000	N/A
Specific Gravity	1.17	0.97	1.10
Mix Ratio			
By weight	100	84	
By volume	1	1	
Density per Gallon, lbs	9.75	8.08	8.95

Shear Strength, psi, ASTM D 1002 Etched Aluminum		
Cure Schedule	Test Temp °F	Typical Value
3 Days @ 77°F	77	3000

Handling

Mixing: Hysol Aerobond 2034 requires mixing Part A and Part B together just prior to the application. Complete mixing of the two components is necessary.

Application

Mixing: Combine Part A (resin) and Part B (hardener) in the correct ratio and mix thoroughly. This is important! Heat build-up during or after mixing is normal. Do not mix quantities greater than one pound as excessive exotherm or heat build-up will develop. Mixing smaller quantities will minimize the heat build-up.

Application: Bonding surfaces should be clean and dry. The bonded parts should be held in contact until the adhesive is set. It not necessary to maintain fixturing for the entire cure schedule but only until handling strength is achieved.

Cure: Hysol Aerobond 2034 can be cured by a variety of cure schedules to meet processing requirements. Full cure time at 77°F is 24 hours. Heat cures can be used to shorten this time. For instance, one hour at 160°F is sufficient to fully cure the adhesive.

Clean up: It is important to remove excess adhesive from the work area and application equipment before it hardens. Many common solvents and citrus cleaners are suitable for removing uncured adhesive. Consult with your solvent supplier for information pertaining to the safe and proper use of solvents.

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PLEASE CONTACT LOCTITE CORPORATION QUALITY DEPARTMENT FOR ASSISTANCE AND RECOMMENDATIONS ON SPECIFICATIONS FOR THIS PRODUCT.
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