Technical Data Sheet

Heat-Resist™ 320

incure™
ADHESIVES, EPOXIES AND COATINGS

Ultra-High Temp, Superior Strength Medical CA Bonder

PRODUCT DESCRIPTION

Incure Heat-Resist™ 320 high-temp grade, is a single component ethyl cyanoacrylate designed for difficult applications subjected to thermal shock testing and high temperature. Medium in viscosity, it provides extra-ordinary bonding strengths of up to 5,200PSI is achievable on some plastics, such as PC and PVC. Incure 320 is resistant to some solvent, such as alcohol, petrol and aromatic hydrocarbons and diluted aqueous acids and bases.

UNCURED PROPERTIES

Chemical Type	Ethyl			
Appearance	Black			
Density, g/ml	1.06	Flash Point	85ºC (185ºF)	
Viscosity, cP (rpm)	20	260 - 370	Spindle	2
Other viscosities are available upon request. If the viscosity range requested is not our standard offering, this product may be produced with a small lab fee. Email us at: support@uv-incure.com or your nearest local distributor for more information.			ASTM D2556	

Viscosity (cP) taken at 25ºC (77ºF) - Call to enquiry for other viscosities.

SETTING TIME FOR MATERIALS (s)

Steel	45	EPDM	30		-
ABS	35	Wood	-		-

FULL CURE (hr)

@25ºC, 85% RH	4
@25ºC, 60% RH	6

CURED PROPERTIES

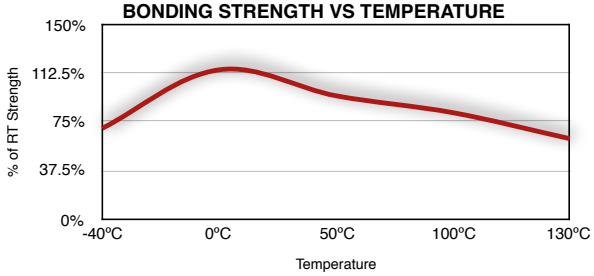
Service Temperature	-55ºC to 135ºC (-67ºF to 275ºF)

Incure Inc.
1 Hartford Square, Box 16 West,
Suite C-3 West Gate, Door 18, New Britain,
CT 06052, USA

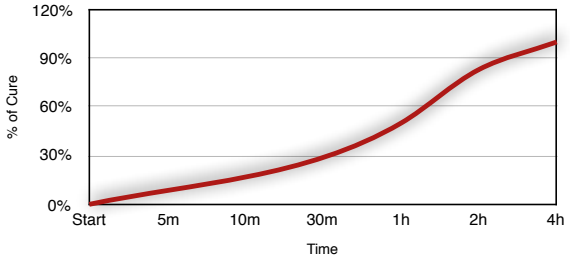
Incure Adhesives Manufacturing Pte Ltd
33 Ubi Avenue 3 #04-23, Vertex Tower B
Singapore 408868
support@uv-incure.com www.uv-incure.com

RoHS COMPLIANT | Pb LEAD FREE | HF HALOGEN FREE

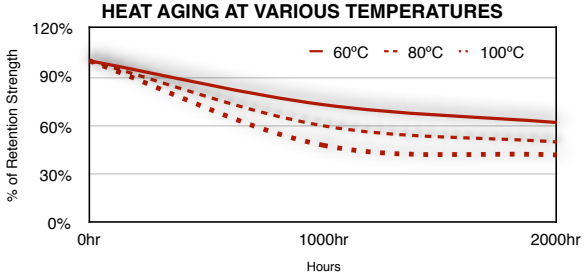
BONDING STRENGTH VS TEMPERATURE



FULL CURE vs TIME



HEAT AGING AT VARIOUS TEMPERATURES



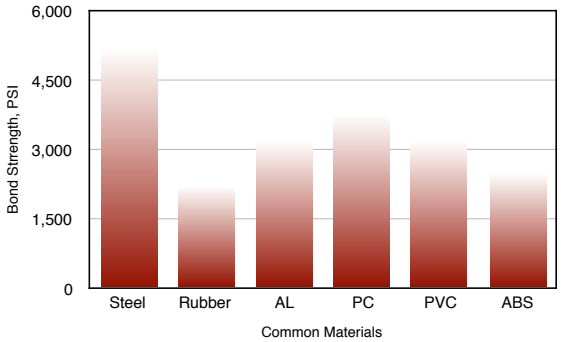
SHELF-LIFE, STORAGE, USE AND HANDLING

Shelf–Life of this unopened product is a minimum of 9 mths from date of manufacture. Avoid direct exposure of bottle to visible light at all times. Containers should remained covered when not in use. Product should be stored 15ºC to 25ºC (59ºF to 77ºF). Transfer of product into other packages void all warranties. Users should ensure all bonding surfaces are free of grease, mold release, or any contaminants, as bonding performance will be compromised. Dispense onluy to one surface only. Bonding parts should be firmed held together for a few seconds before releasing. All tests for cured bonds should be carried out at ambient temperature. For safe handling of this product, please read Material Safety Data–sheet (MSDS) prior to use. Organic solvents, such as IPA, may be used to wipe away uncured material from surfaces.

EtO and GAMMA STERILIZATION (Not Applicable)

All Incure Medical products are formulated to subject to standard sterilization methods, such as EtO and Gamma Radiation of 25 to 50 kGrays (cumulative). Enhanced moisture and thermal resistance of this product show excellent adhesion and bonding strength after one cycle of steam auto-clave test. Depending on bond design and structure of the application, users should test specific assemblies after subjecting them to the test requirements. Please consult Incure Support Team for assistance, if your devices are subjected to more than one sterilization cycles.

BOND STRENGTH TO MATERIALS



Figures are tested to ASTM 4501. Results may differ with varying application bonding areas, contact surface areas, coatings and material grades, etc.

NOTE