

Hapweld™ 36

Thermoplastic

Hapco Inc.

Message:

A two part, non-shrinking, 100% solids, amber clear, polymer adhesive which cures at room temperature. It is a flowable polymer adhesive which forms permanent structural bonds between similar and dissimilar materials.

Once hardened, HAPWELD 36 resists moisture, water, solvents, chemicals, and retains good bond strength up to 160°F.

May be used from 2:1 to 1:1 by volume or by weight, making it ideal for both field and production applications.

The "workhorse" of our polymer adhesive line and will bond most metals, plastics, ceramics, wood, fabrics, canvas, etc. As you increase the mix from 2:1 to 1:1, the cured product becomes semi-rigid and has lower heat resistance

General Information			
Features	Bondability		
	Good Chemical Resistance		
	Low Shrinkage		
	Moisture Resistant		
	Solvent Resistant		
Uses	Adhesives		
Appearance	Clear Amber		
Forms	Liquid		
Physical	Nominal Value	Unit	
Weight - Per gallon	4000	g	
Service Temperature	-73 to 71	°C	
Work Time ¹	0.7 to 2.0	hr	
Cure Time (21°C)	1.0 to 2.0	day	
Hardness	Nominal Value	Unit	
Durometer Hardness (Shore D)	80		
Mechanical	Nominal Value	Unit	Test Method
Tensile Strength	56.9	MPa	ASTM D732
Shear Strength	29.0	MPa	
Electrical	Nominal Value	Unit	
Volume Resistivity (25°C)	1.0E+16	ohms · cm	
Dielectric Constant (25°C)	3.50		
Thermoset	Nominal Value	Unit	
Thermoset Components			
Part A ²	Mix Ratio by Weight: 1.0, Mix Ratio by Volume: 1.0		
Part A ³	Mix Ratio by Weight: 2.0, Mix Ratio by Volume: 2.0		
Part B ⁴	Mix Ratio by Weight: 1.0, Mix Ratio by Volume: 1.0		
Part B ⁵	Mix Ratio by Weight: 1.0, Mix Ratio by Volume: 1.0		
Thermoset Mix Viscosity	30000	cP	

NOTE

1.	Depending on mix ratio. Longest working life is at 2 parts A to 1 part B, and the shortest is at 1:1 mixing ratio.
2.	Semi-rigid
3.	Hard
4.	Semi-rigid
5.	Hard

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