



CryoBond™ 920

CryoBond™920 is a solvent free adhesive that is supplied in two parts. This adhesive has demonstrated excellent adhesive characteristics at cryogenic and elevated temperatures.

- Low density adhesive system (~30 pcf, SG=0.48)
- Extremely flexible, even at cryogenic temperatures
- Room temperature cure
- Excellent adhesive properties on metals and composites

Primed Aluminum Substrate

| Temperature [°F] | Bond Thickness [inches] | Lap Shear Strength [psi] |
|------------------|-------------------------|--------------------------|
| -320 | 0.017 | 731 |
| 70 | 0.017 | 1081 |
| 350 | 0.017 | 162 |

Carbon Epoxy Substrate

| Temperature [°F] | Bond Thickness [inches] | Lap Shear Strength [psi] |
|------------------|-------------------------|--------------------------|
| -320 | 0.017 | 1485 |
| 70 | 0.017 | 712 |
| 350 | 0.017 | 107 |

| <u>Materials</u> | <u>Color</u> | <u>Parts by Weight</u> | <u>Parts by Volume</u> |
|----------------------|--------------|------------------------|------------------------|
| <i>CryoBond™ 920</i> | | | |
| Part A | Purple | 100 | 100 |
| Part B | White | 46 | 50 |

MIXING TEMPERATURE: 4°C - 30°C (Room Temperature)

MIXING PROCEDURE: Measure out the recommended quantities of Parts A & B by weight or volume. It is essential that good mixing is achieved. **STRONGLY RECOMMEND MECHANICAL MIXING OF EACH COMPONENT PRIOR TO COMBINING.**

POT LIFE: approximately 20 minutes in batch sizes around 100g

CURE SCHEDULE: Hardens in approximately 2 hour in a 10 mil coating at 25°C
7 days at 25°C for complete cure
Elevating temperature using heat lamps or ambient heating will accelerate cure, recommend 2 hours at 140°F

STORAGE : Store at room temperature, 20 - 30°C (65-75°F).

RECOMMENDED SHELF LIFE: 6 months from DATE OF MANUFACTURE