

Product Data Sheet - Adhesive Recommendations

CMT offers the following adhesive recommendations for use with HYTAC materials:

Bonding HYTAC materials to themselves or other materials, e.g. aluminum			
Category	HYTAC Material	Preferred	Alternate
Thermoset	W	Araldite 2014 (available from CMT or www.huntsman.com)	Devcon HP250 (www.devcon.com) Loctite Hysol E-120HP (www.henkel.com)
	WF		
	WFT		
	FLX		
	FLXT		
	C1R		
	LPX		

Thermoplastic	B1X	Devcon Plastic Welder II	Devcon HP250 (www.devcon.com) Loctite Hysol E-120HP (www.henkel.com)
	XTL		

Insert installation			
Category	HYTAC Material	Preferred	Alternate
Thermoset	W	Loctite 495 General Purpose Adhesive Plexus MA425*	Loctite 411 Prism Instant Adhesive Loctite 4471 Instant Adhesive
	WF		
	WFT		
	FLX		
	FLXT		
	C1R		
	LPX		

*Plexus MA 425 is a 2-part epoxy used to bond large plugs to base plates.