



TECHNICAL LEAFLET

SUNSTAR ENGINEERING INC.

PENGUIN CEMENT # 379

Penguin Cement # 379 is a one-component, synthetic rubber based adhesive designed to bond various kind of substrate (except PVC) onto non-pretreated polypropylene base material without priming.

1). Characteristics

1. Good adhesion to non-pretreated polypropylene.
2. Suitable to vacuum formed materials.
3. Excellent heat & humidity resistance.

2). Properties

Appearance	Blue
Viscosity (cps/20oC)	200
Non-volatile (%)	21.5
Specific gravity	0.86

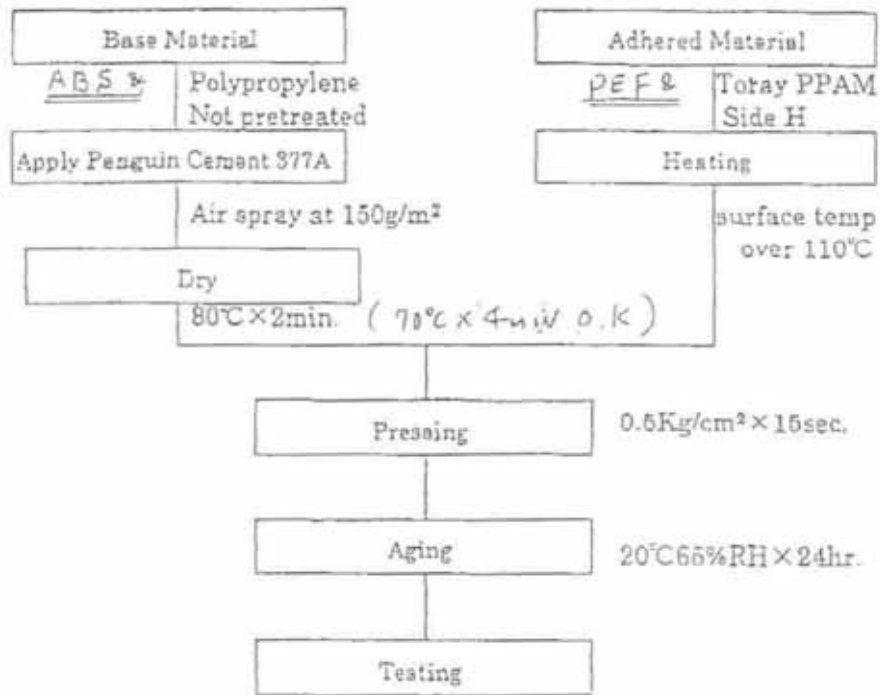
3). Bonding Properties

Peel strength (Kg/25mm)	
Initial	2.0 MB
Ordinary state	2.0 MB
Heat aging	0.7 MB/CF
Humidity resistance	1.9 MB
Creep resistance (mm)	4.0 CF

*MB: Material Break

CF: Cohesive Failure

4). Application Procedures



{Test Condition}

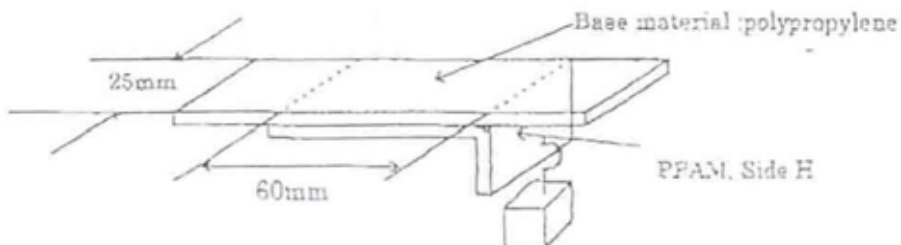
Peel strength;

- 1) Initial : 10 min, after bonding
- 2) Ordinary state : After aging
- 3) Heat aging : Aging + 110°C X 400hr. (measured at 90°C)
- 4) Humidity : Aging + 50°C 95%RH X 400hr

resistance

*Peel strength is measured at tensile speed 200mm/min at 180° angle

Creep resistance : After aging, measure peel length with 100g load
At 100°C



5). Safety precaution

1. Use Penguin Cement 379 in a well-ventilated place.
2. Use protective clothing to avoid skin contact.
3. For skin contact, immediately flush with water and get medical attention.
4. In case of eye contact, immediately flush with water and get medical attention.
5. If swallowed, drink plenty of water and throw it up.
6. Flammable. Keep away from sources of ignition.
7. Store at cool and dark place. (0 ~ 35°C)
8. Moisture sensitive. Close cap tightly for shipping and storage. Inject dry air to the drum. The part that touches adhesives is recommended to be made of Teflon or stainless.

6). Packaging

14 Kg per can