

Description

Instant adhesive based on methyl cyanoacrylate, high viscosity and high strength. Especially recommended for bonding metals, rigid materials, ceramics and rubber and plastic on a metal support. High viscosity allows to fill large gaps and its slow fixture time enables the eventual repositioning of parts.

Physical properties

Composition :	methyl cyanoarylate
Colour :	clear/colourless
Viscosity (+25°C - mPa s) :	1.200 - 1.800
Specific weight (g/ml) :	1,19
Gap to fill :	10 - 200 microns
Flash point :	+87°C
Shelf life :	1 year in original unopened packaging
Temperature range :	-50°C/+80°C

Curing properties

Curing rate depends on the substrate used, on the gap, on the temperature and on the environmental humidity.

Substrate Fixture Time (seconds)

Plastics	
* PVC :	30 - 90
* Phenolic Resin :	10 - 40
* ABS :	20 - 50
Metals	
* Steel :	30 - 60
* Aluminium :	40 - 80
* Zinc :	30 - 90

Various substrates

* Neoprene/NBR :	< 10
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In case of too long setting time we recommend to use Activator 9. In case of usage with PE, PP, Silicone rubbers or PTFE Primer 7 is always recommended.

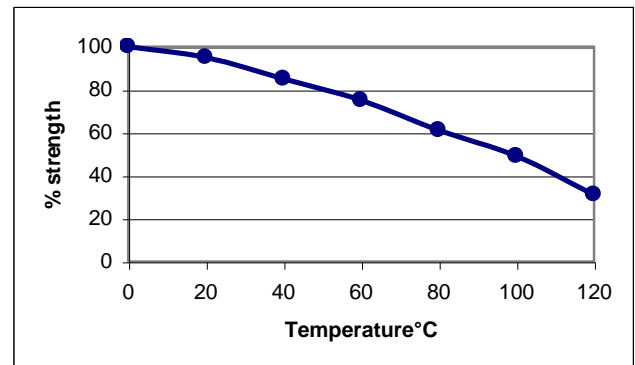
Proprieties of cured material (typical)

Tensile strength ISO 6922 (N/mm ²) :	25 - 30
Shear strength ISO 4587 (N/mm ²) :	20 - 25
Softening range :	+160°C/+170°C
Refraction index n ²⁰ _D :	similar to glass
Electrical resistivity DIN 53482 (Ω mm) :	>10 ¹⁵
Dielectric strength ASTM D 149 (kV/mm) :	25
Dielectric constant DIN 53483 (1MHz) :	5,2

Environmental resistance

The graph below shows the mechanical strength of the product (%) vs. temperature.

Specimen steel - ISO 4587



Chemical resistance

Aged at indicated temperature under conditions below after 24 hours from polymerisation.

Substance	°C	Resistance after 100 h	Resistance after 500 h	Resistance after 1000 h
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Motor oil	40	excellent	excellent	excellent
Alcohol	25	excellent	excellent	excellent
Gasoline	25	excellent	excellent	excellent
Relative humidity 90%	40	discrete	low	low
Refrigerating gases	25	excellent	excellent	excellent

* For information on resistance with other chemicals, contact Loxeal Technical Service

Directions for use

Clean and degrease parts to bond with Cleaner 10. Excess of product either cured or not can be removed with CA Remover.

Storage

We recommend to store product in a cool and dry place at temperature non exceeding +20°C. For better and enhanced shelf life, keep product in a refrigerator at +2°C/+7°C. To avoid contaminations do not refill containers with used product. For more information on applications, storage and handling contact Technical Service

Safety and handling

Consult the Safety Data Sheet before use.

Note

The information contained in this document has been provided in good faith and Mascherpa regards it as being accurate.

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