

## Product features

- 2K adhesive based on methoxyethyl cyanoacrylate
- Mixing ratio 1:4
- Gap filling
- Elastic bonding
- Impact resistant

## Applications

For bonding numerous materials: stainless steel (A316), steel, aluminum (A5754), neoprene, rubber, nitrile, EPDM, PVC, wood, leather, PC / ABS, paper

## Technical Data

### Individual components:

#### Component A

|   |   |
|---|---|
| Colour  | transparent   |
| Viscosity at 25 °C  | 100.000-190.000 cP @ 1.5 rpm<br>6.000-9.000 cP @ 50 rpm |
| Density at 23 °C according to ISO 1183-1 [g/cm <sup>3</sup> ] | ~ 1,12  |
| VOC according to ISO 11890-2                                  | ~ 61 g/L  |
| Storage stability at 2-8 °C [months]                          | 12  |
| Processing temperature  | 10-30 °C  |

#### Component B

|   |  |
|---|--|
| Colour  | whitish  |
| Viscosity at 25 °C  | 70.000-130.000 cP @ 1.5 rpm<br>3.000-7.000 cP @ 50 rpm |
| Density at 23 °C according to ISO 1183-1 [g/cm <sup>3</sup> ] | ~ 1,10   |
| VOC according to ISO 11890-2                                  | ~ 19 g/L   |
| Mixing ratio by weight (A : B)                                | 80,0 g : 20,0 g  |
| Mixing ratio by volume (A : B)                                | 4 : 1  |
| Storage stability at 2-8 °C [months]                          | 12   |
| Processing temperature  | 10-30 °C   |

### Unvulcanized mass:

|   |             |
|---|-------------|
| Colour  | whitish     |
| Density at 23 °C according to 1183-1 [g/cm <sup>3</sup> ] | ~ 1,1       |
| Processing temperature from/to [°C]                       | + 10 / + 30 |
| Pot life for 23 °C/50 % rLf [min]                         | ~ 60-10     |
| Functional strength [min]                                 | ~ 6-10      |
| Glass transition temperature according to ISO 6721        | ~ 35 °C     |

### Vulcanizate:

|  |             |
|--|-------------|
| Shore A hardness ISO 868-2003                            | ~ 76        |
| Temperature resistance from/to [°C]                      | ~ 40 / + 60 |
| Tensile strength according to ISO 527 [MPa]              | ~ 2         |
| Elongation at break after ISO 527 [%]                    | ~ 259       |
| Water absorption in 24 h [%]                             | ~ 11,3      |
| Impact resistance according to 24 h [kJ/m <sup>2</sup> ] | ~ 21,0      |

These values are not intended for the creation of specifications.  
Please contact i.GLUESYSTEMS prior to creating specifications.

|   |                        |                   |
|---|------------------------|-------------------|
| Fixture time*<br>(0,1 N / mm <sup>2</sup> ) | stainless steel (A316) | 60 - 90 Seconds   |
|   | Steel (mild steel)     | 30 - 50 Seconds   |
|   | Aluminium (A5754)      | 60 - 120 Seconds  |
|   | Neoprene               | 60 - 90 Seconds   |
|   | EPDM                   | 45 - 75 Seconds   |
|   | Rubber, nitrile        | 30 - 60 Seconds   |
|   | ABS                    | 45 - 75 Seconds   |
|   | PVC                    | 15 - 80 Seconds   |
|   | Polycarbonate          | 60 - 90 Seconds   |
|   | Phenol                 | 115 - 140 Seconds |
|   | Wood (oak)             | 150 - 210 Seconds |
|   | Wood (pine)            | 130 - 180 Seconds |
|   | Chipboard              | 45 - 60 Seconds   |
|   | Leather                | 50 - 70 Seconds   |
|   | PC / ABS               | 60 - 90 Seconds   |
| Paper                                       | 60 - 90 Seconds        |                   |

\* if properly stored

|   |                              |       |          |
|---|------------------------------|-------|----------|
| Overlapping<br>shear strength (ISO 4587)<br>at 23 ° C (MPa) | after curing for 24 hours RT |       |          |
|   | Sandblasting steel (GBMS)10  | +/- 1 |          |
|   | Aluminium (A5754)            | 5     | +/- 1    |
|   | ABS                          | 6     | +/- 1 SF |
|   | PVC                          | 2     | +/- 1 SF |
|   | Phenol                       | 4     | +/- 1    |
|   | Polycarbonate                | 5     | +/- 1 SF |

## Special instructions

Before using the product, the user has to ensure the materials in the contact area are compatible with it and with each other and do not damage or change (e.g. discolour). In case of materials that are subsequently processed in the area of the product, the user has to clarify in advance that their ingredients or vapors cannot impair or change (e.g. discolour) the product. If necessary, the user has to consult with the respective manufacturer of the materials. Paints, varnishes, plastics and other coating materials must be compatible with the adhesive / sealant.

## Pretreatment

The adhesive surfaces must be cleaned and any contamination such as release agents, preservatives, grease, oil, dust, water, old adhesives / sealants and other substances that impair adhesion must be removed. Cleaning of non-porous surfaces: cleaning with isopropanol (airing time approx. 1 minute) and a clean, lint-free cloth. Cleaning of porous substrates: surfaces mechanically, e.g. with a steel brush or a grinding wheel, remove loose particles.

The requirements for elastic seals and bonds depend on the respective external influences. Extreme temperature fluctuations, stretching and shearing forces, repeated contact with water, etc. place high demands on an adhesive bond. In such cases, when making recommendations, it is advisable to use a suitable primer to achieve the most resilient connection possible. We would be happy to advise you on the choice of primer for your application, the processor must always carry out a test application and application.

**Instructions for use**      Processing of 2K adhesives:  
Component A is sensitive to humidity and must therefore be protected from moisture. Component B does not react with air humidity and is stable under normal conditions (23 ° C, 50% RH). As the storage progresses, the B component may phase separate slightly.

In order to achieve optimal adhesion and good mechanical properties, the inclusion of air must be avoided. Processing: The adhesive must be joined within its pot life to ensure intimate contact with the adhesive surface and the flanks. We recommend storing our products in the unopened original containers in a dry place (<60% RH) in a temperature range of + 2 ° C to + 8 ° C. If the products are stored and / or transported for longer periods of time (several weeks) at higher temperatures / humidity, a reduction in the shelf life or a change in the material properties cannot be ruled out. Because of the large number of possible influences during processing and use, the processor must always carry out a test processing and application.

**Delivery form**              Container:                      2k syringe 10g  
   Colour:                            whitish  
   Packaging Unit:                12 pcs.  
   Item number:                 Art.no. 1000-51

**Safety instructions**      Please note the safety data sheet.

**Disposal**                      For information on disposal, see safety data sheet.

**Liability for defects**      All information in this publication is based on current technical knowledge and experience.

Due to the large number of possible influences during processing and use, they do not exempt the processor from carrying out their own tests and trials. The information in this publication and statements by i.GLUESYSTEMS in connection with this publication do not constitute an acceptance of a guarantee. Guarantee statements require a separate express written declaration by i.GLUESYSTEMS to be effective.

The properties specified in this data sheet determine the properties of the delivery item comprehensively and conclusively. Suggestions for use do not constitute an assurance of suitability for the recommended purpose. We reserve the right to adapt the product to technical progress and new developments. We are happy to answer any inquiries, also with regard to any special application problems. If the application for which our products are used is subject to official approval, the user is responsible for obtaining these approvals.

Our recommendations do not release the user from the obligation to consider and, if necessary, clarify the possibility of infringing third party rights. In addition, we refer to our general terms and conditions, especially with regard to any liability for defects.

You can find our terms and conditions: <https://www.i-gluesystems.com>

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