Instant Adhesives

Cyanacrylate adhesives are for the instant and structural bonding of rubber, metals, ceramic, leather and a variety of plastics. Best results can be obtained with joint gaps of less than 0.1mm up to 0.2mm for special grades. The service temperature range is between -50°C and +80°C, although new high-temperature resistant formulations are available for use up to 200°C. For porous surfaces or for vertical application a gel grade is available.

	GRADE	CHEMICAL COMPOSITION	SPECIFIC GRAVITY	VISCOSITY (25°C mPa.s)	GAP FILLING (microns)	SPEED OF CURE (*)	TENSILE STRENGTH (ASTM D 2095) N/mm²	SHEAR STRENGTH N/mm²	PROPERTIES
STANDARD GRADES	14	METHYL	1,15	80 - 150	10 - 100	2	25 - 30	20 - 25 (1)	For rigid materials, like rubber-metal. Slow setting. High strength.
	23	ETHYL	1,06	40 - 80	10 - 60	3	12 - 25	13 - 18 (2)	General purpose for rubbers and plastics. Medium setting.
	25	ETHYL	1,07	350 - 450	10 - 150	3	15 - 23	13 - 20 (1)	Fills large gaps, for rubbers, plastics, metals and ceramics.
	32	ETHYL	1,05	5 - 10	10 - 40	5	12 - 25	13 - 18 (2)	Very fast curing. Very good results on EPDM and foam rubbers, difficult rubbers and plastics.
	34	ETHYL	1,06	20 - 40	10 - 100	5	12 - 25	13 - 18 (2)	Very fast curing. Very good results on EPDM and foam rubbers, difficult rubbers and plastics.
	43	ETHYL	1,06	80 - 150	10 - 150	4	22 - 25	15 - 20 (1)	General purpose, for bonding plastics, metals, leather, wood and rubbers.
	435	ETHYL	1,06	80 - 150	10 - 150	5	15 - 25	15 - 20 (1)	General purpose, faster setting on acidic surfaces, for leather, wood and metals.
	63	ALCOXI	1,07	80 - 150	10 - 150	1	10 - 25	12 - 22 (1)	General purpose, odour free, no blooming.
SPECIAL GRADES	17	METHYL	1,19	1200 - 1800	10 - 200	1	25 - 30	20 - 25 (1)	High viscosity, for rigid materials, fills large gaps, slow setting, high resistance.
	27	ETHYL	1,08	1400 - 2000	10 - 200	2	18 - 25	13 - 18 (1)	High viscosity, for rubbers, plastics, fills large gaps.
	29	ETHYL / BLACK	1,06	500 - 1500	10 - 200	1	18 - 25	13 - 18 (1)	General purpose, elastomeric, flexible.
	41	ETHYL	1,05	5 - 10	10 - 40	5	18 - 25	13 - 18 (1)	Low viscosity, fast setting on acidic surfaces.
	45	ETHYL	1,06	600 - 1200	10 - 200	4	12 - 25	12 - 20 (1)	Medium viscosity, general purpose, fast setting on acidic surfaces.
	47	ETHYL	1,08	GEL	10 - 300	2	18 - 25	13 - 18 (1)	Gel, fills large gaps, for vertical bonding and porous surfaces.
	54	ETHYL	1,05 - 1,07	< 15	10 - 40	3	18 - 25	13 - 18 (1)	General purpose, for joints exposed to high temperatures up to 120°C.
	61	ALCOXI	1,06	10 - 20	10 - 40	2	10 - 20	12 - 22 (1)	Low viscosity, odour free, no blooming.
	67	ALCOXI	1,1	1000 - 1500	10 - 200	1	10 - 25	12 - 22 (1)	High viscosity, fills large gaps, odour free, no blooming.
	73	ETHYL	1,06	100 - 200	10 - 150	2	12 - 25	15 - 25 (1)	General purpose, flexible, transparent, high temperature resistance up to 100°C.
	74	ETHYL / BLACK	1,06	100 - 200	10 - 150	2	12 - 25	15 - 25 (1)	General purpose, flexible, high temperature resistance up to 100°C.

(1) ISO 4587 Norm (2) ISO 10123 Norm (*) Relative setting time (5= max, 1 = min.)

PHYSICAL PROPERTIES

FLASH POINT (ISO 2592)	OPERATING TEMPERATURE	SOFTENING RANGE	REFRACTIVE INDEX n_D^{20}	ELECTRICAL RESISTIVITY ASTM D 257 (Ω.mm)	DIELECTRIC STRENGTH ASTM D 149 (Kv/mm)	DIELECTRIC CONSTANT ASTM D 150 (1 Mhz)
87°C	-50°C +80°C (120°C)	160 / 170°C	SIMILAR TO GLASS	> 10^{15}	25	> 2,65