

N109 W13300 ELLSWORTH DRIVE GERMANTOWN, WI 53022
262-253-5900 FAX 262-253-5919

DESCRIPTION:

The *CYNERGY 6000 SERIES* are for use in demanding applications where very fast cure speeds are required. These are single component solvent free materials manufactured in a wide variety of viscosities and setting times to satisfy specific bonding applications. Substrates such as wood, plastics, metal, rubber, or other materials are bonded quickly and effectively with the *Cynergy 6000* series. These products are less dependent on surface moisture for achieving cure speed than most standard grades of cyanoacrylates.

TYPICAL PROPERTIES:

All properties given are at 25°C unless otherwise noted.

Product	Base	Color	Gap fill (mil)	Viscosity (cps)	Shear strength (psi)*	Temp range °F	Cure Speed (fixture / full cure)	S.G.
CA6001	Ethyl	Clear	2	5	2700 / 4300	-65 to 200	>5 seconds / 8 hours	1.05
CA6002	Ethyl	Clear	2	5	2700 / 4300	-65 to 200	>10 seconds / 8 hours	1.05
CA6003	Ethyl	Clear	3	30	2700 / 4300	-65 to 200	>10 seconds / 8 hours	1.05
CA6004	Ethyl	Clear	4	45	2700 / 4300	-65 to 200	>8 seconds / 8 hours	1.05
CA6005	Ethyl	Clear	6	100	2700 / 4300	-65 to 200	>10 seconds / 8 hours	1.05
CA6006	Ethyl	Clear	6	200	2700 / 4300	-65 to 200	>10 seconds / 8 hours	1.05
CA6007	Ethyl	Clear	7	500	2700 / 4300	-65 to 200	>10 seconds / 8 hours	1.05
CA6008	Ethyl	Clear	7	750	2700 / 4300	-65 to 200	>12 seconds / 8 hours	1.05
CA6009	Ethyl	Clear	8	1000	2700 / 4300	-65 to 200	>15 seconds / 8 hours	1.09
CA6010	Ethyl	Clear	8	1500	2700 / 4300	-65 to 200	>15 seconds / 8 hours	1.09
CA6011	Ethyl	Clear	8	2000	2700 / 4300	-65 to 200	>15 seconds / 8 hours	1.09
CA6012	Ethyl	Clear	8	2400	2700 / 4300	-65 to 200	>15 seconds / 8 hours	1.09
CA6013	Ethyl	Clear	8	3200	2700 / 4300	-65 to 200	>15 seconds / 8 hours	1.09
CA6014	Ethyl	Clear	8	4000	2700 / 4300	-65 to 200	>15 seconds / 8 hours	1.09
CA6015	Ethyl	Clear	10	GEL	2700 / 4300	-65 to 200	>25 seconds / 8 hours	1.05
CA6016	Ethyl	Clear	2-3	20	2700 / 4300	-65 to 200	>5 - <10 seconds / 8 hours	1.05

* Strength values given are: (tensile / steel lap shear)

PREPARATION:

For best results and optimum adhesive performance, surface should be clean and free from contaminants. Contaminants can be removed by using suitable solvents. When using a cleaning solvent, first check for material compatibility particularly in case of plastics. An easy method for removing contaminants is by using a clean soft cloth and wiping the surface with acetone or alcohol.

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APPLICATION:

The *CYNERGY SERIES* of the cyanoacrylates should be applied in small amounts to one surface only. The parts should then be mated together under slight pressure. This causes the adhesive to spread out into a thin film and assures optimum adhesive performance. The pressure need only be applied for several seconds. The *CYNERGY SERIES* cures rapidly allowing for bonded parts to be handled within 10 to 60 seconds for most applications. Full cure is normally within 8 - 24 hours.

SHELF LIFE:

All of the *CYNERGY SERIES* products have a shelf life of one year when stored at 40 °F. Shelf life at room temperature (72°F) is a minimum of six (6) months. When stored in a refrigerator, allow the adhesive to gradually warm to room temperature prior to use. Avoid heat, direct sunlight and high moisture areas when storing. Avoid contaminating open containers. Do not return unused adhesive to original container. DO NOT refrigerate open containers.

HANDLING PRECAUTIONS:

All of the *CYNERGY SERIES* adhesive products are non-toxic and do not constitute a health hazard. Normal precautions should be observed. Use in area where there is adequate ventilation. KEEP AWAY FROM CHILDREN.

Accidental skin bonding may occur. Use warm, soapy water to separate skin or use *CYNERGY DEBONDER*. Gradually work skin free. DO NOT use excessive force to pull the bonded area apart: this will only result in tearing of skin and or cause irritation, which is not necessary.

Should eye contact occur flush with water and see physician. DO NOT force bonded area apart. When the corneal surface and eyelid are bonded together treat with a suitable anti-irritant ointment and allow the eye to remain closed. Bond separation will occur naturally within 48 hours with no damage.