

W186 N11687 MORSE DRIVE GERMANTOWN, WI 53022
262-502-6610 FAX 262-502-4743

DESCRIPTION:

Resinlab CA7004 is low viscosity combined with fast cure speed, ethyl cyanoacrylate adhesive (CA). It is specifically formulated for bonding rubbers and plastic parts, but it can be used with a variety of substrates including wood and metal.

Common substrates

- | | | |
|-----------------------------------|--|----------------------------------|
| <input type="checkbox"/> Acrylic | <input type="checkbox"/> Polycarbonate | <input type="checkbox"/> Rubbers |
| <input type="checkbox"/> PVC | <input type="checkbox"/> PEEK | <input type="checkbox"/> PETG |
| <input type="checkbox"/> Wood | <input type="checkbox"/> Latex | <input type="checkbox"/> Steel |
| <input type="checkbox"/> Aluminum | | |

Set Times:

At standard indoor temperature and humidity, surface moisture on the substrates initiates the curing process. Handle strength is developed in a short time but curing continues for at least 24 hours before full chemical/solvent resistance is developed. The rate of cure will depend on substrate used.

Substrate	Set Time (seconds)	Substrate	Set Time (seconds)
Plastics	2-5	Rubbers	<3
Wood	1-5	Leather	5-15
Metals	8-10	Ceramics	12-18

Typical Lap Shear:

Substrate	Lap Shear (psi)	Substrate	Lap Shear (psi)
Grit Blasted Steel	>2900	Etch Aluminum	>2600
Rubbers	>3150	ABS	>1450
Wood	>3600	Polycarbonate	>1700

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PHYSICAL PROPERTIES:

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

<u>PROPERTY:</u>	<u>VALUE:</u>	<u>TEST METHOD:</u>
Color	Clear	Visual
Viscosity	45 cps	Brookfield LVT
Nominal Gap fill	1.25 mil	
Specific Gravity	1.05	
Melting Point	160-170 °C	
Glass Transition Temperature	122°C	ASTM E228
Thermal Conductivity	0.1 W/m ² K	ASTM C177
Coefficient of Thermal Expansion	75 ppm/°C	ASTM D696
Dielectric Constant	2.7	
Dielectric Strength	685 v/mil	ASTM D149
Temperature Range **	-60 to 80°C	

INSTRUCTIONS:

1. Bring to room temperature prior to use if stored refrigerated. Surfaces should be clean and dry and free of grease or debris. A light abrasion is recommended if possible.
2. If using an accelerator, apply to one surface only. Apply a thin film of adhesive to the other side and assemble immediately. Do not disturb or re-align joint until parts are set.

STORAGE & SHELF LIFE:

Shelf life is one year at room temperature (77°F / 25°C). Refrigerated storage at 40°F is recommended to maximize shelf life. 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.