

TECHNICAL DATA SHEET Cynergy CA7103

01/22/2010

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

DESCRIPTION:

Cynergy CA7103 is a medium viscosity methyl cyanoacrylate adhesive. It sets extremely quickly, typically in several seconds on most substrates. It was formulated to bond a variety of metals and rubbers with high strength. The product meets Military specification MLLA 46050 Type II Class II.

Common substrates

Acrylic	Polycarbonate	Polyimide
PVĆ	PEÉK	PETG
Polysulfone	Wood	Latex
Steel	Aluminum	Zinc Dichromate

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)
Stainless Steel	20-40	PEEK	20-30
Aluminum	30-60	PES	20-30
Zinc Dichromate	30-60	Neoprene	< 10
PVC	< 10	Nitrile Rubber	5 – 10
ABS	10 -25	Viton	5 – 10

Typical Lap Shear:

Substrate	Lap Shear (psi)	Substrate	Lap Shear (psi)
Grit Blasted Steel	>3600	Etch Aluminum	>2900
Zinc Dichromate	>1450	ABS	>2000
Polycarbonate	>1800	Phenolic	725-2125
PVC	>2000	Nitrile	725-2175

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PHYSICAL PROPERTIES:

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

PROPERTY:	VALUE:	TEST METHOD:
Color	Clear	Visual
Viscosity	100-150 cps	Brookfield LVT
Nominal Gap fill	5 mil	
Specific Gravity	1.05	
Glass Transition Temp (by DSC)	165 °C	ASTM E228
Melting Point	160-170°C	
Tensile Strength	2600 psi *	ASTM
Tensile Elongation	1.5% *	
Thermal Conductivity	0.1 W/m°K	ASTM C177
Coefficient of Thermal Expansion	80 ppm/°C	ASTM D696
Dielectric Constant	2.5	
Dielectric Strength	625 v/mil	ASTM D149
Temperature Range **	-60 to 80°C	

INSTRUCTIONS:

- 1. Bring to room temperature prior to use if stored refridgerated. Surfaces should be clean and dry and free of and 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:

Store in a cool dry place away from sunlight, heat or flames for best shelf life. Shelf life is one year unopened from date of manufacture.

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