TECHNICAL DATA SHEET
Cynergy CA7201

03/19/2010

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

DESCRIPTION:

- Cynergy CA7201 is low viscosity combined with fast cure speed. It is classified as a surface insensitive cyanoacrylate adhesive. It is specifically formulated to bond difficult surfaces with high industrial strength. The low viscosity of this adhesive makes it ideal for penetrating into pre-assembled components. It is also suitable for a wide variety of plastic surfaces.

Common substrates

- Acrylic
- Cardboard
- Polysulfone
- Steel
- Polycarbonate
- PEEK
- Wood
- Aluminum
- Polyimide
- PETG
- Latex
- Leathers

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	10-20	ABS	10-20
Polycabonate	20-40	PVC	20-50
Neoprene	< 5	Phenolics	10-20
Nitrile Rubber	5-7		

Typical Lap Shear:

Substrate	*Lap Shear (psi)*	*Substrate*	*Lap Shear (psi)*
Grit Blasted Steel	2030 – 3190	Etch Aluminum	1450 – 2175
Rubbers	1450 – 2175	Polycarbonate	725 – 1450
PVC	450 - 1305		

PHYSICAL PROPERTIES:

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

PROPERTY:	VALUE:	TEST METHOD:
Color	Clear	
Viscosity	2 - 5 cps	
Nominal Gap fill	0.05 mm	

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PROPERTY:	VALUE:	TEST METHOD:
Specific Gravity	1.05	
Glass Transition Temp (by DSC)	120 °C	
Melting Point	160-170 °C	
Tensile Strength	2175 - 3770 psi	
Coefficient of Thermal Expansion	90 ppm/°C	
Dielectric Strength	625 v/mil	
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 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.

3. When bonding “O” rings, cut a fresh surface onto each end of the rubber to gain the best possible strength.

STORAGE:

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.