

TECHNICAL DATA SHEET Cynergy CA7701

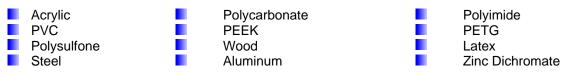
03/26/2010

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

DESCRIPTION:

Cynergy CA7701 is a very low viscosity, wicking grade cyanoacrylate adhesive. It is specially formulated with low odor and low-blooming characteristics. This offers excellent product performance coupled with easy of processing. This can eliminate the need for ventilation and reduces frosted residues in critical cosmetic bonding applications.

Common substrates



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 | 30-70 | Neoprene | < 5 |
| Aluminum | 5-20 | Phenolics | 30-60 |
| Polycarbonate | 20-60 | PVC | 20-50 |
| ABS | 20-60 | Nitrile Rubbers | 5-7 |

Typical Lap Shear:

| Substrate | Lap Shear (psi) | Substrate | Lap Shear (psi) |
|--------------------|-----------------|---------------|-----------------|
| Grit Blasted Steel | 2030-3190 | Etch Aluminum | 1450-2175 |
| Neoprene Rubber | 1450-2175 | Polycarbonate | 750-1450 |
| PVC | 435-1305 | | |

PHYSICAL PROPERTIES:

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

| PROPERTY: | VALUE: | TEST METHOD: |
|------------------|-----------|----------------|
| Color | Clear | Visual |
| Viscosity | 3 - 5 cps | Brookfield LVT |
| Nominal Gap fill | 0.05 mm | |

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| PROPERTY: | VALUE: | TEST METHOD: |
|-----------------------------------|-------------------|--------------|
| Glass Transition Temp (by DSC) | 150 °C | ASTM E228 |
| Melting Point | 160-170°C | |
| Tensile Strength | 1275 - 5945 psi * | |
| Thermal Conductivity | 0.1 W/m°K | ASTM C177 |
| Coefficient of Thermal Expansion | 90 ppm/°C | ASTM D696 |
| Dielectric Strength | 625 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 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:

Shelf life is one year at room temperature $(77^{\circ}F / 25^{\circ}C)$. 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.

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