

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

DESCRIPTION:

The *CYNERGY 6100 SERIES* products are used to bond metal to itself or other substrates. It is available in five standard viscosities.

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.
CA6101	Methyl	Clear	2	5	2800 / 4000	-65 to 200	>5 seconds/ 8 hours	1.07
CA6102	Methyl	Clear	4	60	2800 / 4000	-65 to 200	>8 seconds/ 8 hours	1.07
CA6103	Methyl	Clear	8	100	2800 / 4000	-65 to 200	>10 seconds/ 8 hours	1.09
CA6104	Methyl	Clear	8	1000	2800 / 4000	-65 to 200	>10 seconds/ 8 hours	1.09
CA6105	Methyl	UV tracer	8	2000	2800 / 4000	-65 to 200	>10 seconds/ 8 hours	1.09

* 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.

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 24 hours.

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SHELF LIFE:

Most unmodified *CYNERGY SERIES* products have a shelf life of 18 months when stored below 40 °F, and 12 months when stored at room temperature (72°F). Customers should consult the certificate of conformance delivered with their product for the specific warranty period.

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.