



AN ELLSWORTH ADHESIVES COMPANY 

TECHNICAL DATA SHEET Cynergy 6400 Series

09/14/2020

N109 W13300 ELLSWORTH DRIVE GERMANTOWN, WI 53022

262-253-5900 FAX 262-253-5919

DESCRIPTION:

The *CYNERGY 6400 SERIES* are clear, highly toughened, high peel strength products ideal for bonding dissimilar materials with excellent performance on a wide range of surfaces. These products impart superior hot strength, impact and thermal resistance making them ideal for demanding applications.

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.
CA6401	Ethyl	Clear	6	300	3750	-65 to 250	>10 seconds/ 8 hours	1.10
CA6402	Ethyl	Clear	8	800	3750	-65 to 250	>15 seconds/ 8 hours	1.10
CA6403	Ethyl	Clear	10	2400	3750	-65 to 250	>15 seconds/ 8 hours	1.10
CA6404	Ethyl	Clear	10	4000	3750	-65 to 250	>18 seconds/ 8 hours	1.10
CA6405	Ethyl	Clear	12	5000	3750	-65 to 250	>18 seconds/ 8 hours	1.10

PERFORMANCE PROPERTIES:

Lap Shear Strength: Substrate	Value in psi:	Method:
Etched Aluminum	>1750	ASTM D1002
ABS	>900	
PVC	>900	
Polycarbonate	>900	
Phenolic	>850	
Neoprene Rubber	>750	
Tensile Strength	>1800 psi	ISO 6922
Dielectric Constant	1KHz 2 to 3.5/<0.02	ASTM D150 Dissipation Factor
Volume Resistivity	2x10 ¹⁵ to 10x10 ¹⁵	ASTM D257
Temperature Range	-65 to 250 °F	

PREPARATION:

For best results and optimum adhesive performance, surface should be clean and free from contaminant. 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.

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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.

SHELF LIFE:

CYNERGY 6400 SERIES products have a typical shelf life of 12 months from date of package when stored at 25 °C. When stored at 5 °C the typical shelf life from date of package is 18 months. Where shelf life is impacted by specialty packaging, refer to the product label for shelf life details.

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.