TECHNICAL DATA SHEET
Cynergy CA7210

03/17/2010

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

DESCRIPTION:

Cynergy CA7210 is gel adhesive for use in non-drip or non-run applications. It is classified as a surface insensitive cyanoacrylate adhesive. It is specifically formulated to bond difficult surfaces with high industrial strength. This includes rough, porous and acidic surfaces including Wood, Cardboard, Balsa Wood, Rubbers, Plastics, Metals, Leather, etc.

Common substrates

- Acrylic
- Cardboard
- Polysulfone
- Steel
- Polycarbonate
- Zinc Dichromate
- Wood
- Aluminum
- Paper
- Fabric
- 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)*
Aluminum	2-10	Stainless Steel	5-20
PVC	2-10	Polycarbonate	10-40
Wood	2-10	Neoprene	> 5
Nitrile Rubber	> 5	ABS	2-10

Typical Lap Shear:

Substrate	*Lap Shear (psi)*	*Substrate*	*Lap Shear (psi)*
Grit Blasted Steel	2610 – 4060	Etched Aluminum	1595 – 2755
Neoprene Rubber	1450 – 2610	Wood	3625 – 3915
PVC	435 - 1305	Polycarbonate	725 – 2900

PHYSICAL PROPERTIES:

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

PROPERTY:	VALUE:	TEST METHOD:
Color	Clear	
Viscosity	Gel	
Nominal Gap fill	0.75 mm	

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PROPERTY:	VALUE:	TEST METHOD:
Specific Gravity	1.05	
Glass Transition Temp (by DSC)	120 °C	ASTM E228
Melting Point	160-170 °C	
Tensile Strength	2175 - 3770 psi	
Coefficient of Thermal Expansion	80 ppm/°C	ASTM D696
Thermal Conductivity	0.1 W/mK	ASTM C177
Dielectric Strength	625 v/mil	ASTM D149
Temperature Range **	-60 to 85°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. Thinner bond lines will produce fast cure times. Increasing bond gaps will slow down the rate of cure.

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.