TECHNICAL DATA SHEET
Cynergy CA7215

03/17/2010

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

DESCRIPTION:

Cynergy CA7215 is a gel adhesive for use in non-drip or non-run applications. It is both a surface insensitive and rubber toughened cyanoacrylate adhesive. It is specifically formulated to improve heat resistance and aging in humid environments. This product is ideal for bonding various metals, rubbers, and plastics in challenging industrial environments.

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	5-10	Polyurethane Rubber	20-25
Neoprene Rubber	8-12	Steel	20-30
SBR Rubber	10-20	Phenolic Materials	50-90
Nitrile Rubber	5-10	EPDM	30-80

Typical Lap Shear:

Substrate	*Lap Shear (psi)*	*Substrate*	*Lap Shear (psi)*
Steel	>2300	Etched Aluminum	>870
Neoprene Rubber	>1740	PVC	>870
Nitrile Rubber	>1740	Polycarbonate	>1015
SBR Rubber	>1450		

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	1.10	
Glass Transition Temp (by DSC)	130 °C	ASTM E228
Melting Point	160-170 °C	
Tensile Strength	1885 - 3625 psi	
Coefficient of Thermal Expansion	310 ppm/°C	ASTM D696
Thermal Conductivity	0.1 W/mK	ASTM C177
Dielectric Strength	825 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.