

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

DESCRIPTION:

Resinlab CA7405 is a high viscosity rubber toughened cyanoacrylate adhesive (CA). This gives the product good resistance to peel, shock, and high temperature resistance. It is specifically formulated for bonding rubbers, metals, wood, and various plastics.

Common substrates

- | | | |
|------------|-----------------|-----------|
| ■ Acrylic | ■ Polycarbonate | ■ Rubbers |
| ■ Aluminum | ■ PEEK | ■ PETG |
| ■ Wood | ■ Latex | ■ Steel |

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)
Neoprene Rubber	< 5	ABS	15 – 40
Nitrile Rubber	< 5	Steel	15 – 50
SRS Rubber	15 – 25	Aluminum	10 - 25
Phenolic Materials	10 - 50	Polycarbonate	30 - 80

Typical Lap Shear:

Substrate	Lap Shear (psi)	Substrate	Lap Shear (psi)
Neoprene Rubber	>1740	Aluminum	>2465
Nitrile Rubber	>1740	Steel	>3480
SRS Rubber	>1450	Polycarbonate	>1015
PVC	>870		

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

PHYSICAL PROPERTIES:

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

<u>PROPERTY:</u>	<u>VALUE:</u>	<u>TEST METHOD:</u>
Color	Clear	Visual
Viscosity	5,000 – 6,000 cps	Brookfield LVT
Nominal Gap fill	0.6 mm	
Specific Gravity	1.06	
Glass Transition Temperature	125°C	ASTM E228
Tensile Strength	1885 – 3625 psi	
Thermal Conductivity	0.1 W/m ² K	ASTM C177
Coefficient of Thermal Expansion	80 ppm/°C	ASTM D696
Dielectric Strength	635 v/mil	ASTM D149
Temperature Range	-60 to 100°C	

INSTRUCTIONS:

1. Bring to room temperature prior to use if stored refrigerated. Surfaces should be clean and dry and free of 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. When bonding "O" rings, cut a fresh surface onto each end of the rubber to gain the best possible strength.

STORAGE & SHELF LIFE:

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.