TECHNICAL DATA SHEET
Cynergy CA7006

03/08/2010

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

DESCRIPTION:

Cynergy CA7006 is a medium viscosity ethyl cyanoacrylate adhesive. It sets extremely quickly, typically in several seconds on most substrates. It is specifically formulated for bonding plastic parts, but it can be used with a variety of substrates including rubber, wood, and metal.

Common substrates

- Acrylic
- PVC
- Polysulfone
- ABS
- Polycarbonate
- PEEK
- PET
- Rubber
- Polyimide
- PETG
- Latex
- Metals

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)*
Steel	15-30	ABS	2-10
Polycarbonate	15-30	Aluminum	2-10
Neoprene	< 5	Phenolic	5-15
PVC	2-10	Nitrile Rubber	5-7

Typical Lap Shear:

Substrate	*Lap Shear (psi)*	*Substrate*	*Lap Shear (psi)*
ABS	1100 – 2000	Acrylic	1450 – 2175
Neoprene Rubber	1450 – 2175		
Polycarbonate	725 – 1450		
PVC	870 – 1300		

PHYSICAL PROPERTIES:

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

PROPERTY:	VALUE:	TEST METHOD:
Color	Clear	
Viscosity	70 - 100 cps	
Nominal Gap fill	0.20 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	2100 - 2600 psi	
Thermal Conductivity	0.1 W/m°K	ASTM C177
Coefficient of Thermal Expansion	90 ppm/°C	ASTM D696
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. When bonding “O” rings, cut a fresh surface onto each end of the rubber to gain the best possible strength.

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.

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Rev.	Date	Sections Affected/Description
0	03/08/09	Document Established