

TECHNICAL DATA SHEET Cynergy CA7015

09/13/2016

N109 W13300 ELLSWORTH DRIVE GERMANTOWN, WI 53022 262-253-5900 FAX 262-253-5919

DESCRIPTION:

Resinlab® Cynergy CA7015 is a one part gel ethyl cyanoacrylate adhesive. It is formulated for non-sag or vertical applications where run-off or dripping needs to be avoided. It is specifically formulated for bonding plastic parts, but it can be used with a variety of substrates including metal and elastomeric compounds.

At standard indoor temperature and humidity, surface moisture on the substrate(s) initiates the cure. Handle strength is developed in a short time but curing continues for at least 24 hours before a full chemical/solvent resistance is developed.

TYPICAL PROPERTIES:

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

Color Colorless Visual Viscosity Non sag gel Specific Gravity 1.05 Calculated Cure Schedule 24 hours for full cure Rate of cure dependent on substrate Set Times for handle strength: In seconds: Stainless Steel 50 – 95 Polycarbonate 20 – 60 Neoprene 15 – 25 ABS 20 – 60 Aluminum 5 – 30 PVC 50 – 95 Phenolics 30 – 60 Nitrile Rubber 15 – 25 Gap Filling 0.50 mm Tensile Strength 2175 – 3770 psi Lap Shear Strength: In psi: ASTM D1002/DIN 53283 Grit Blasted Steel 2030 – 3190 ASTM D1002/DIN 53283 Weoprene Rubbers 1450 – 2175 Polycarbonate 725 – 1450 Etched Aluminum 1450 – 2175 ASTM D149 Wood 435 – 1305 ASTM D149	Property:	Value:	Test Method or Source:
Specific Gravity 1.05 Calculated Cure Schedule 24 hours for full cure Rate of cure dependent on substrate Set Times for handle strength: In seconds: Stainless Steel 50 − 95 Polycarbonate 20 − 60 Neoprene 15 − 25 ABS 20 − 60 Aluminum 5 − 30 PVC 50 − 95 Phenolics 30 − 60 Nitrile Rubber 15 − 25 Gap Filling 0.50 mm Tensile Strength 2175 − 3770 psi Lap Shear Strength: In psi: ASTM D1002/DIN 53283 Grit Blasted Steel 2030 − 3190 ASTM D1002/DIN 53283 Neoprene Rubbers 1450 − 2175 Folycarbonate 725 − 1450 Etched Aluminum 1450 − 2175 Folycarbonate 435 − 1305 Dielectric Strength 625 v/mil ASTM D149	Color	Colorless	Visual
Cure Schedule 24 hours for full cure Rate of cure dependent on substrate Set Times for handle strength: In seconds: Stainless Steel 50 – 95 Polycarbonate 20 – 60 Neoprene 15 – 25 ABS 20 – 60 Aluminum 5 – 30 PVC 50 – 95 Phenolics 30 – 60 Nitrile Rubber 15 – 25 Gap Filling 0.50 mm Tensile Strength 2175 – 3770 psi Lap Shear Strength: In psi: ASTM D1002/DIN 53283 Grit Blasted Steel 2030 – 3190 Neoprene Rubbers 1450 – 2175 Polycarbonate 725 – 1450 Etched Aluminum 1450 – 2175 Wood 435 – 1305 ASTM D149	Viscosity	Non sag gel	
Set Times for handle strength: In seconds: Stainless Steel 50 − 95 Polycarbonate 20 − 60 Neoprene 15 − 25 ABS 20 − 60 Aluminum 5 − 30 PVC 50 − 95 Phenolics 30 − 60 Nitrile Rubber 15 − 25 Gap Filling 0.50 mm Tensile Strength 2.175 − 3770 psi Lap Shear Strength: In psi: ASTM D1002/DIN 53283 Grit Blasted Steel 2030 − 3190 Neoprene Rubbers 1450 − 2175 Polycarbonate 725 − 1450 Etched Aluminum 1450 − 2175 Wood 435 − 1305 Dielectric Strength 625 v/mil ASTM D149	Specific Gravity	1.05	Calculated
Set Times for handle strength: In seconds: Stainless Steel 50 − 95 Polycarbonate 20 − 60 Neoprene 15 − 25 ABS 20 − 60 Aluminum 5 − 30 PVC 50 − 95 Phenolics 30 − 60 Nitrile Rubber 15 − 25 Gap Filling 0.50 mm Tensile Strength 2175 − 3770 psi Lap Shear Strength: In psi: ASTM D1002/DIN 53283 Grit Blasted Steel 2030 − 3190 Neoprene Rubbers 1450 − 2175 Polycarbonate 725 − 1450 Etched Aluminum 1450 − 2175 Wood 435 − 1305 Dielectric Strength 625 v/mil ASTM D149	Cure Schedule	24 hours for full cure	
Stainless Steel 50 − 95 Polycarbonate 20 − 60 Neoprene 15 − 25 ABS 20 − 60 Aluminum 5 − 30 PVC 50 − 95 Phenolics 30 − 60 Nitrile Rubber 15 − 25 Gap Filling 0.50 mm Tensile Strength 2175 − 3770 psi Lap Shear Strength: In psi: ASTM D1002/DIN 53283 Grit Blasted Steel 2030 − 3190 Neoprene Rubbers 1450 − 2175 Polycarbonate 725 − 1450 Etched Aluminum 1450 − 2175 Wood 435 − 1305 Dielectric Strength 625 v/mil ASTM D149		Rate of cure dependent on substrate	
Polycarbonate 20 – 60 Neoprene 15 – 25 ABS 20 – 60 Aluminum 5 – 30 PVC 50 – 95 Phenolics 30 – 60 Nitrile Rubber 15 – 25 Gap Filling 0.50 mm Tensile Strength 2175 – 3770 psi Lap Shear Strength: In psi: ASTM D1002/DIN 53283 Grit Blasted Steel 2030 – 3190 Neoprene Rubbers 1450 – 2175 Polycarbonate 725 – 1450 Etched Aluminum 1450 – 2175 Wood 435 – 1305 Dielectric Strength 625 v/mil ASTM D149	Set Times for handle strength:	In seconds:	
Neoprene 15 − 25 ABS 20 − 60 Aluminum 5 − 30 PVC 50 − 95 Phenolics 30 − 60 Nitrile Rubber 15 − 25 Gap Filling 0.50 mm Tensile Strength 2175 − 3770 psi Lap Shear Strength: In psi: ASTM D1002/DIN 53283 Grit Blasted Steel 2030 − 3190 Neoprene Rubbers 1450 − 2175 Polycarbonate 725 − 1450 Etched Aluminum 1450 − 2175 Wood 435 − 1305 Dielectric Strength 625 v/mil ASTM D149	Stainless Steel	50 – 95	
ABS 20 – 60 Aluminum 5 – 30 PVC 50 – 95 Phenolics 30 – 60 Nitrile Rubber 15 – 25 Gap Filling 0.50 mm Tensile Strength 2175 – 3770 psi Lap Shear Strength: In psi: ASTM D1002/DIN 53283 Grit Blasted Steel 2030 – 3190 Neoprene Rubbers 1450 – 2175 Polycarbonate 725 – 1450 Etched Aluminum 1450 – 2175 Wood 435 – 1305 Dielectric Strength 625 v/mil ASTM D149		20 – 60	
Aluminum 5 - 30 PVC 50 - 95 Phenolics 30 - 60 Nitrile Rubber 15 - 25 Gap Filling 0.50 mm Tensile Strength 2175 - 3770 psi Lap Shear Strength: In psi: ASTM D1002/DIN 53283 Grit Blasted Steel 2030 - 3190 Neoprene Rubbers 1450 - 2175 Polycarbonate 725 - 1450 Etched Aluminum 1450 - 2175 Wood 435 - 1305 Dielectric Strength 625 v/mil ASTM D149	Neoprene	15 – 25	
PVC 50 – 95 Phenolics 30 – 60 Nitrile Rubber 15 – 25 Gap Filling 0.50 mm Tensile Strength 2175 – 3770 psi Lap Shear Strength: In psi: ASTM D1002/DIN 53283 Grit Blasted Steel 2030 – 3190 Neoprene Rubbers 1450 – 2175 Polycarbonate 725 – 1450 Etched Aluminum 1450 – 2175 Wood 435 – 1305 Dielectric Strength 625 v/mil ASTM D149	ABS	20 – 60	
Phenolics 30 − 60 Nitrile Rubber 15 − 25 Gap Filling 0.50 mm Tensile Strength 2175 − 3770 psi Lap Shear Strength: In psi: ASTM D1002/DIN 53283 Grit Blasted Steel 2030 − 3190 Neoprene Rubbers 1450 − 2175 Polycarbonate 725 − 1450 Etched Aluminum 1450 − 2175 Wood 435 − 1305 Dielectric Strength 625 v/mil ASTM D149	Aluminum	5 – 30	
Nitrile Rubber 15 – 25 Gap Filling 0.50 mm Tensile Strength 2175 – 3770 psi Lap Shear Strength: In psi: ASTM D1002/DIN 53283 Grit Blasted Steel 2030 – 3190 Neoprene Rubbers 1450 – 2175 Polycarbonate 725 – 1450 Etched Aluminum 1450 – 2175 Wood 435 – 1305 Dielectric Strength 625 v/mil ASTM D149	PVC	50 – 95	
Gap Filling 0.50 mm Tensile Strength 2175 – 3770 psi Lap Shear Strength: In psi: ASTM D1002/DIN 53283 Grit Blasted Steel 2030 – 3190 ASTM D1002/DIN 53283 Neoprene Rubbers 1450 – 2175 ASTM D1002/DIN 53283 Polycarbonate 725 – 1450 ASTM D149 Etched Aluminum 435 – 1305 ASTM D149	Phenolics	30 – 60	
Tensile Strength 2175 – 3770 psi Lap Shear Strength: In psi: ASTM D1002/DIN 53283 Grit Blasted Steel 2030 – 3190 ASTM D1002/DIN 53283 Neoprene Rubbers 1450 – 2175 ASTM D1002/DIN 53283 Polycarbonate 725 – 1450 ASTM D149 Etched Aluminum 1450 – 2175 ASTM D149 Dielectric Strength 625 v/mil ASTM D149	Nitrile Rubber	15 – 25	
Lap Shear Strength: In psi: ASTM D1002/DIN 53283 Grit Blasted Steel 2030 – 3190 Neoprene Rubbers 1450 – 2175 Polycarbonate 725 – 1450 Etched Aluminum 1450 – 2175 Wood 435 – 1305 Dielectric Strength 625 v/mil ASTM D149	Gap Filling	0.50 mm	
Grit Blasted Steel 2030 – 3190 Neoprene Rubbers 1450 – 2175 Polycarbonate 725 – 1450 Etched Aluminum 1450 – 2175 Wood 435 – 1305 Dielectric Strength 625 v/mil ASTM D149	Tensile Strength	2175 – 3770 psi	
Neoprene Rubbers 1450 – 2175 Polycarbonate 725 – 1450 Etched Aluminum 1450 – 2175 Wood 435 – 1305 Dielectric Strength 625 v/mil ASTM D149	Lap Shear Strength:	In psi:	ASTM D1002/DIN 53283
Polycarbonate 725 – 1450 Etched Aluminum 1450 – 2175 Wood 435 – 1305 Dielectric Strength 625 v/mil ASTM D149	Grit Blasted Steel	2030 – 3190	
Etched Aluminum 1450 – 2175 Wood 435 – 1305 Dielectric Strength 625 v/mil ASTM D149	Neoprene Rubbers	1450 – 2175	
Wood 435 – 1305 Dielectric Strength 625 v/mil ASTM D149	Polycarbonate	725 – 1450	
Dielectric Strength 625 v/mil ASTM D149	Etched Aluminum	1450 – 2175	
· · · · · · · · · · · · · · · · · · ·	Wood	435 – 1305	
Glass Transition Temperature 120 °C ASTM F22°	Dielectric Strength	625 v/mil	ASTM D149
Glass transition remperature 120 C ASTIVI L226	Glass Transition Temperature	120 °C	ASTM E228
Coefficient of Thermal Expansion 90 ppm/ °C ASTM D696	Coefficient of Thermal Expansion	90 ppm/ °C	ASTM D696
Thermal Conductivity 0.1 W / (m.K) ASTM C177	Thermal Conductivity	0.1 W / (m.K)	ASTM C177
Melt Point Temperature 160 – 170 °C	Melt Point Temperature	160 – 170 °C	
Service Temperature Range -60 to 80 °C	Service Temperature Range	-60 to 80 °C	

RESINLAB L.L.C. MAKES NO EXPRESS OR IMPLIED WARRANTIES OR MERCHANTABILITY, FITNESS OR OTHERWISE with respect to its products. In addition, while the information contained herein is believed to be reliable, no warranty is expressed or implied regarding the accuracy of the data or the results to be obtained from the use thereof. All recommendations or suggestions for use are made without guarantee inasmuch as conditions of use are beyond our control. The properties given are typical values and are not intended for use in preparing specifications. Users should make their own test to determine the suitability of this product for their own purposes.

Page 1 of 2



TECHNICAL DATA SHEET Cynergy CA7015

09/13/2016

N109 W13300 ELLSWORTH DRIVE GERMANTOWN, WI 53022 262-253-5900 FAX 262-253-5919

INSTRUCTIONS:

- 1.) Bring to room temperature prior to use if stored refrigerated. Surfaces should be clean and dry and free of grease and or debris. A light abrasion is recommended to achieve best results.
- 2.) If using an accelerator, apply to one surface only. Apply a thin film of adhesive to the other side and assemble immediately. Hold for several seconds and do not disturb or re-align the 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.
- 4.) Thin bondlines cure fastest. Increasing the bond gap will slow the rate of cure.

SHELF LIFE AND STORAGE:

12 months at 25 °C

Refrigerated storage is recommended to maximize shelf life. If stored refrigerated, allow the adhesive to gradually warm prior to use. Avoid heat, direct sunlight and high moisture areas when storing. Do not return unused adhesive to the original container and do not refrigerate open containers.