

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

DESCRIPTION:

Cynergy CA7904 is medium viscosity combined with fast cure speed. It is a modified cyanoacrylate adhesive giving it improved resistance to heat, humidity, and damp environments. It is specifically formulated to bond various rubbers, metals, and plastics; and can be used in challenging environments.

Common substrates

- | | | |
|---|---|---|
|  Acrylic |  Polycarbonate |  Polyimide |
|  Aluminum |  PEEK |  PETG |
|  Polysulfone |  Wood |  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)
Steel	20-30	Neoprene Rubber	8-12
Aluminum	5-10	Nitrile Rubber	5-10
Phenolic Materials	50-90	SBR Rubber	10-20
EPDM	30-80	Polyurethane Rubber	20-25

Typical Lap Shear:

Substrate	Lap Shear (psi)	Substrate	Lap Shear (psi)
Neoprene Rubber	> 1740	Aluminum	> 870
Nitrile Rubber	> 1740	Steel	> 2320
SBR Rubber	> 1450	Polycarbonate	> 1015
PVC	> 870		

PHYSICAL PROPERTIES:

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

<u>PROPERTY:</u>	<u>VALUE:</u>	<u>TEST METHOD:</u>
Color	Clear	
Viscosity	500 - 600 cps	
Nominal Gap fill	0.3 mm	

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<u>PROPERTY:</u>	<u>VALUE:</u>	<u>TEST METHOD:</u>
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	90 ppm/°C	ASTM D696
Dielectric Strength	685 v/mil	ASTM D149
Temperature Range **	-60 to 120°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.