

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

DESCRIPTION:

Cynergy CA7204 is medium viscosity combined with fast cure speed. It is classified as a surface insensitive cyanoacrylate adhesive. It is specifically formulated to bond difficult surfaces with high industrial strength. Ideal for bonding rough, porous and acidic surfaces including Wood, Cardboard, Balsa Wood, Rubbers, Plastics, Metals, and Leather. It meets Military specification MLLA 46050 Type II Class II.

Common substrates

- | | | |
|---------------|-----------------|-------------|
| ■ Acrylic | ■ Polycarbonate | ■ Polyimide |
| ■ Cardboard | ■ PEEK | ■ PETG |
| ■ Polysulfone | ■ Wood | ■ Latex |
| ■ Steel | ■ Aluminum | ■ 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.

<i>Substrate</i>	<i>Set Time (seconds)</i>	<i>Substrate</i>	<i>Set Time (seconds)</i>
Plastics	3-6	Rubbers	< 3
Wood	1-6	Leather	7-17
Metals	9-12	Ceramics	14-20

Typical Lap Shear:

<i>Substrate</i>	<i>Lap Shear (psi)</i>	<i>Substrate</i>	<i>Lap Shear (psi)</i>
Grit Blasted Steel	> 3190	Etch Aluminum	> 2610
Rubbers	> 2900	Polycarbonate	> 2030
Wood	> 3625	ABS	> 1740

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	600 - 800 cps	
Nominal Gap fill	0.30 mm	

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<u>PROPERTY:</u>	<u>VALUE:</u>	<u>TEST METHOD:</u>
Specific Gravity	1.05	
Glass Transition Temp (by DSC)	122 °C	ASTM E228
Melting Point	160-170 °C	
Tensile Strength	2900 - 4000 psi	
Coefficient of Thermal Expansion	90 ppm/°C	ASTM D696
Thermal Conductivity	0.1 W/mK	ASTM C177
Dielectric Strength	625 v/mil	ASTM D149
Temperature Range **	-60 to 80°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.