

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

**DESCRIPTION:**

Cynergy CA7704 is a medium viscosity cyanoacrylate adhesive. It is specially formulated with low odor and low-blooming characteristics. This offers excellent product performance coupled with easy of processing. This can eliminate the need for ventilation and reduces frosted residues in critical cosmetic bonding applications.

Common substrates

- |               |                 |                   |
|---------------|-----------------|-------------------|
| ■ Acrylic     | ■ Polycarbonate | ■ Polyimide       |
| ■ PVC         | ■ PEEK          | ■ PETG            |
| ■ Polysulfone | ■ Wood          | ■ Latex           |
| ■ Steel       | ■ Aluminum      | ■ Zinc Dichromate |

**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>
Stainless Steel	30-70	Neoprene	< 5
Aluminum	5-20	Phenolics	30-60
Polycarbonate	20-60	PVC	20-50
ABS	20-60	Nitrile Rubbers	5-7

**Typical Lap Shear:**

<i>Substrate</i>	<i>Lap Shear (psi)</i>	<i>Substrate</i>	<i>Lap Shear (psi)</i>
Grit Blasted Steel	2030-3190	Etch Aluminum	1450-2175
Neoprene Rubber	1450-2175	Polycarbonate	750-1450
PVC	435-1305		

**PHYSICAL PROPERTIES:**

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

<b><u>PROPERTY:</u></b>	<b><u>VALUE:</u></b>	<b><u>TEST METHOD:</u></b>
Color	Clear	Visual
Viscosity	1,000 – 1,100cps	Brookfield LVF
Nominal Gap fill	0.30 mm	

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<u>PROPERTY:</u>	<u>VALUE:</u>	<u>TEST METHOD:</u>
Glass Transition Temp (by DSC)	135°C	ASTM E228
Melting Point	160-170 °C	
Tensile Strength	2175 - 3770 psi *	
Thermal Conductivity	0.1 W/m <sup>2</sup> K	ASTM C177
Coefficient of Thermal Expansion	90 ppm/°C	ASTM D696
Dielectric Strength	625 v/mil	ASTM D149
Dielectric Constant 25 °C	2.75	ASTM D150
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.

**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.