

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

**DESCRIPTION:**

Resinlab CA7501 is a black, low viscosity, rubber toughened cyanoacrylate adhesive (CA). This gives the product good resistance to peel and shock loads. It is specifically formulated for bonding rubbers, metals, wood, and various plastics. It is ideal for but not limited to applications, such as, speaker assemblies, automotive parts, and electronic assemblies.

Common substrates

- |            |                 |           |
|------------|-----------------|-----------|
| ■ Acrylic  | ■ Polycarbonate | ■ Rubbers |
| ■ Aluminum | ■ PEEK          | ■ PETG    |
| ■ Wood     | ■ Latex         | ■ 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.

<b>Substrate</b>	<b>Set Time (seconds)</b>	<b>Substrate</b>	<b>Set Time (seconds)</b>
Neoprene Rubber	12-22	Steel	60-100
Nitrile Rubber	12-22	Aluminum	10-25
SBR Rubber	15-25	Phenolic Materials	10-50
Polyurethane Rubber	20-25	Polycarbonate	30 – 80

**Typical Lap Shear:**

<b>Substrate</b>	<b>Lap Shear (psi)</b>	<b>Substrate</b>	<b>Lap Shear (psi)</b>
Neoprene Rubber	> 1740	Aluminum	> 2755
Nitrile Rubber	> 1740	Steel	> 4000
SBR Rubber	> 1450	Polycarbonate	> 1015
PVC	> 870	ABS	> 1015

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**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	Black	Visual
Viscosity	300 cps	Brookfield RVT @ 25°C
Nominal Gap fill	0.3 mm	
Specific Gravity	1.10	
Melting Point Temperature	160 to 170°C	
Glass Transition Temperature	150°C	ASTM E228
Tensile Strength	1885 – 4060 psi	
Thermal Conductivity	0.1 W/m <sup>2</sup> K	ASTM C177
Coefficient of Thermal Expansion	80 ppm/°C	ASTM D696
Dielectric Strength	635 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 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:**

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.