Technical Data Sheet

H.B. Fuller | Engineering Adhesives

2611

2611 is a fast setting, low to medium viscosity cyanoacrylate adhesive for use on all types of substrates. It is particularly suitable for setting and adhering rapidly to inactive surfaces such as wood, leather and fiberglass matting. 2611 offers viscosity and flow characteristics ideal for filling small gaps. 2611 is certified to ISO 10993-5 for biocompatibility, making it suitable for use in medical applications.

Technology / Base	Ethyl
Type of Product	Cyanoacrylate
Components	One Component
Curing	Humidity
Appearance / Color	Clear
Consistency	Wicking Liquid

Technical Data

Rheology	**Value**	**Condition/Method**
Viscosity	105 +/- 15 cPs	Brookfield SC4-27, 20°C to 25°C (68°F to 77°F)
Density		
Specific Gravity	1.06	
Uncured Material Characteristics		
Flash Point	85°C (185°F)	
Set Time Steel	7 sec	
ABS	10 sec	
EPDM	2 sec	
Shelf Life	12 mo	
Cured Material Characteristics		
Full Cure Time	24 hours	
Cure Appearance	Clear	
Service Temperature	-55 to 95°C	
RoHS Compliant	yes	
Cured Mechanical Properties	See Graphs and Table Below	

General Instructions

Surfaces to be bonded should be clean and dry. Dispense a drop or drops to one surface only. Apply only enough to leave a thin film layer after compression. Press parts together and hold firmly for a few seconds. Good contact is essential. An adequate bond develops in less that one minute and maximum strength is attained in 24 hours. Wipe off excess adhesive from the top of the container and recap. products if left uncapped may deteriorate by contamination from moisture in the air. Because products cure by polymerization, whitening may appear on the surface of the container or the bonded materials. This will not affect adhesive performance.

Curing Performance

Ambient surface moisture initiates the curing process. Handling strength is reached in a short time, and will vary based on environmental conditions, bond line gap, and other factors. Product will continue to cure for at least 24 hours before full strength and solvent resistance is developed.

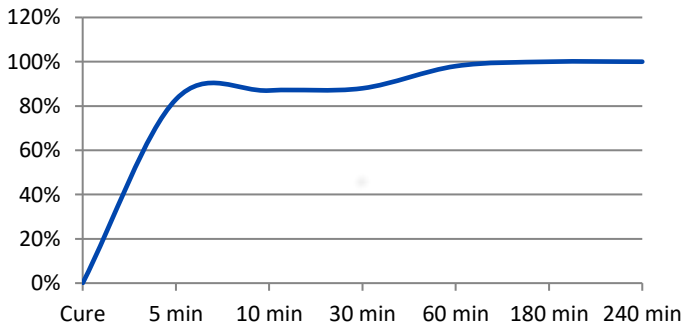
Storage

Containers should be stored in a cool, dry, dark area. Storage temperature 15.5°C - 25°C (60°F - 77°F), without exposure to direct light or heat. Do not refrigerate.

Specifications and Approvals

10993-5

Time Until Full Cure (% of RT strength)



Safety & Disposal

For safe handling information and disposal instructions on this product, consult the Safety Data Sheet (SDS)

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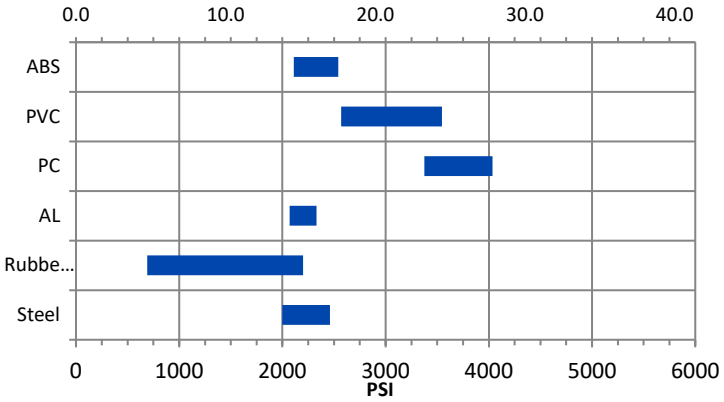
Performance Range by Substrate (N/mm²)



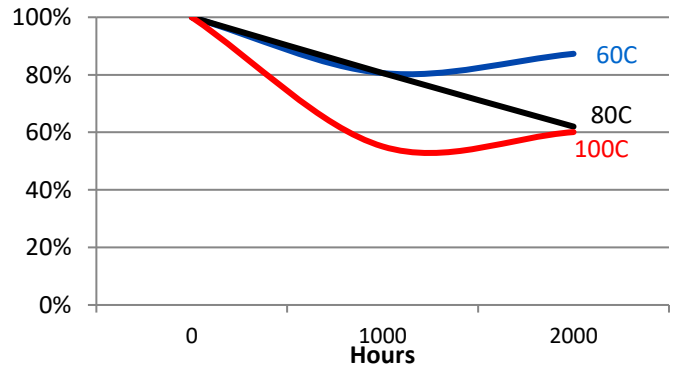
Performance of Cured Adhesive

Substrate	N/mm²			PSI		
Steel	13.8	to	17.0	2000	to	2460
Rubber*	4.8	to	15.2	690	to	2200
AL	14.3	to	16.1	2070	to	2330
PC**	23.3	to	27.8	3375	to	4035
PVC**	17.7	to	24.4	2570	to	3545
ABS**	14.5	to	17.5	2110	to	2540

***Rubber figures given are typical**. Your results may vary by specific rubber type.

**Tested to ASTM 4501 ***n/r = not recommended

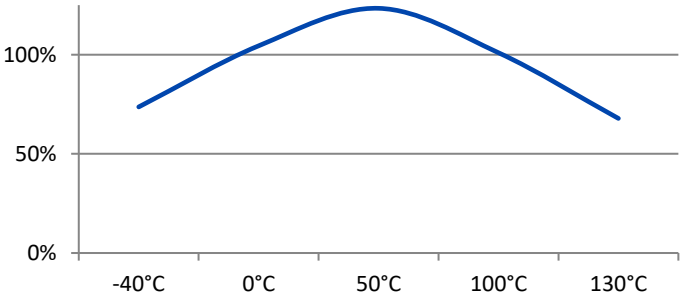
Heat Aging (aged at temp indicated and tested @ 22°C)



Solvent Resistance

Solvent	Example	Resistance
Alcohol	Ethanol, Methanol	+ + +
Ester (aromatic)	Ethylacetate	+ + +
Ketone (aromat	Acetone, Benzophenone	– – –
Aliphatic hydrocarbon (alkanes)	Petrol, Heptanes, Hexane	+ + –
Aromatic hydrocarbons	Benzyl, Toluol, Xylol	+ + –
Halogenated hydrocarbons	Methylenchloride, Chloroform, Chlorobenzol	– – –
Weak aqueous	Nitrite, muriatic acid, sulphuric acid, phosphoric acid	+ + + (– – – if concentrated)
Weak aqueous base	sodium hydroxide solution, caustic potash	+ + + (– – – if concentrated)

Hot Strength (%RT strength, tested at temperature)



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