

## Cynergy Zero Technical Data Sheet CA5215

01/18/2018

N109 W13300 ELLSWORTH DRIVE GERMANTOWN, WI 53022  
 262-253-5900 FAX 262-253-5919

### DESCRIPTION:

*ResinLab® CA5215* is a one part, high viscosity, odorless UV cure cyanoacrylate. It was designed for bonding applications that require rapid fixturing, fillet cure or surface cure. This on demand type curing makes it a unique product that that allows for unlimited time for component positioning during assembly process and at the same time offering a rapid fixture time.

UV and visible light will initiate the rapid cure of exposed surfaces which will minimize blooming. The rate of cure is dependent on the substrate used. The UV tracer present allows the user to observe fluorescence when the cured product is irradiated with UV light.

### TYPICAL PROPERTIES:

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

<b>Property:</b>	<b>Value:</b>	<b>Test Method or Source:</b>
Color	Transparent, yellow	Visual
Viscosity	600-1500 cps	Brookfield Viscosity #21 spindle@1.5 rpm @25 °C
Specific Gravity	1.15	Calculated
<b><u>Cure Speed:</u></b>	<b><u>Fixture time:</u></b>	Fixture time measurements relate to non UV/Visible cure.
ABS	20-60 seconds	
Polycarbonate	50-100 seconds	
PVC	100-200 seconds	
Glass	20-60 seconds	
Beech Wood	60-120 seconds	
Steel	40-100 seconds	
<b><u>Tack Free Time:</u></b>		Time in seconds needed to achieve a tack free surface.
<b><u>UV Visible Light Sources:</u></b>		
Electrodeless, V bulb	70 mW/cm <sup>2</sup> measured @ 365nm: <5s	
Electrodeless, H bulb	30 mW/cm <sup>2</sup> measured @ 365nm: <5s 100 mW/cm <sup>2</sup> measured @ 365nm: <5s	
<b><u>Visible Light Source:</u></b>		
Blue light laser	70 mW/cm <sup>2</sup> measured @ 445nm: <5s	
<b><u>Lap Shear Strength in psi:</u></b>	<b><u>24h RT Non-UV/Vis cure:</u></b>	<b><u>10s curing w/UV light:</u></b>
ABS	1700-2000*	opaque
Beech Wood	1885-2300	opaque
Polycarbonate	1450-1700*	435-725
Steel	2100-2700	opaque

\*substrate failure

## *Cynergy Zero Technical Data Sheet CA5215*

01/18/2018

---

N109 W13300 ELLSWORTH DRIVE GERMANTOWN, WI 53022  
262-253-5900 FAX 262-253-5919

### **PREPARATION:**

For best results and optimum adhesive performance, surface should be clean and free from contaminant. Contaminants can be removed by using suitable solvents. When using a cleaning solvent, first check for material compatibility particularly in case of plastics. An easy method for removing contaminants is by using a clean soft cloth and wiping the surface with acetone or alcohol. Exposure to daylight, UV light and artificial light should be kept to a minimum during storage and handling.

### **APPLICATION:**

Apply in small amounts to one surface only. The parts should then be mated together under slight pressure. This causes the adhesive to spread out into a thin film and assures optimum adhesive performance. CA5215 cures rapidly allowing for bonded parts to be handled within 20 to 60 seconds for most applications.

### **SHELF LIFE:**

CA5215 has a shelf life of one year when stored at 5 °C. Optimal storage conditions are 2-8 °C. Storage below 2 °C or greater than 8 °C can adversely affect product properties. 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.