

Cynergy Zero Technical Data Sheet CA5015

08/03/2018

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

DESCRIPTION:

ResinLab[®] CA5015 is a one part, high viscosity, odorless moisture cure cyanoacrylate. It has been formulated to have low blooming, non irritating and non staining characteristics. CA5015 bonds well to various substrates such as metals, plastics and elastomers as well as porous or absorbent materials like wood, paper, leather and textiles. CA5015 is well suited for applications where vapor control is difficult.

Surface moisture will initiate the hardening process. Handling strength is reached quickly and can vary depending on environmental conditions and type of substrate used. This product will continue to cure for at least 24 hours before full strength and chemical resistance is achieved. Allow product to develop full strength before use with full loads.

CA5015 is suitable for use in medical device assembly. It has been tested and is proven non-toxic per ISO 10993-5. Manufacturers should test their own finished product for biocompatibility. Certificates of compliance are available upon request.

TYPICAL PROPERTIES:

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

<u>Property:</u>	<u>Value:</u>	<u>Test Method or Source:</u>
Color	Transparent	Visual
Viscosity	735-775 cps	Brookfield Viscosity #21 spindle@50 rpm
Specific Gravity	1.10	Calculated
<u>Cure Speed:</u>		
ABS	15-30 seconds/24 hours	
Polycarbonate	20-30 seconds/24 hours	
Aluminum	10-20 seconds/24 hours	
Steel	5-15 seconds/24 hours	
Beech Wood	5-15 seconds/24 hours	
<u>Fixture time/Full cure:</u>		
<u>Lap Shear Strength:</u>		
ABS	1450 – 1885*	ISO 4587
Polycarbonate	1015 – 1300*	Cured for 24h @ 22 °C
Aluminum	435 – 725	
Steel	1450 – 2030	
Beech Wood	1885 – 2100*	

*substrate failure

Cynergy Zero Technical Data Sheet CA5015

08/03/2018

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 contaminants. Contaminants can be removed using suitable solvents. When using a cleaning solvent, first check for material compatibility particularly with plastics. An easy method for removing contaminants is by using a clean soft cloth and wiping the surface with acetone or alcohol.

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. The pressure need only be applied for several seconds. CA5015 cures rapidly allowing for bonded parts to be handled within 5 to 30 seconds for most applications. Full cure is normally within 24 hours.

SHELF LIFE:

CA5015 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.