

Cynergy Zero Technical Data Sheet CA5013

09/26/2017

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

DESCRIPTION:

ResinLab[®] CA5013 is a one part, medium viscosity, odorless moisture cure cyanoacrylate. It has been formulated to have low blooming, non irritating and non staining characteristics. CA5013 bonds well to various substrates such as leather, plastic and rubber products and provides flexibility and high bond strength to areas that are prone to flexing and bending.

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.

CA5013 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.

Property:	Value:	Test Method or Source:
Color	Transparent	Visual
Viscosity	120-170 cps	Brookfield Viscosity Spindle #21 @ 100rpm@ 25 °C
Specific Gravity	1.10	Calculated
Cure Speed:	Fixture time/Full cure:	
ABS	10-20 seconds/24 hours	
Polycarbonate	20-30 seconds/24 hours	
Aluminum	5-10 seconds/24 hours	
Steel	5-10 seconds/24 hours	
Beech Wood	5-10 seconds/24 hours	
Lap Shear Strength:	In psi:	ISO 4587
ABS	1600 – 1740*	Cured for 24 hours @ 22 °C
Polycarbonate	1000 – 1300*	
Aluminum	580 – 725	
Steel	1160 – 1800	
Beech Wood	1700 – 2000*	
Biocompatibility Biological Evaluation of Medical Devices	Passes	MEM Elution Test

*substrate failure

PREPARATION:

RESINLAB L.L.C. MAKES NO EXPRESS OR IMPLIED WARRANTIES OR MERCHANTABILITY, FITNESS OR OTHERWISE with respect to its products. In addition, while the information contained herein is believed to be reliable, no warranty is expressed or implied regarding the accuracy of the data or the results to be obtained from the use thereof. All recommendations or suggestions for use are made without guarantee inasmuch as conditions of use are beyond our control. The properties given are typical values and are not intended for use in preparing specifications. Users should make their own test to determine the suitability of this product for their own purposes.

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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. CA5013 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:

CA5013 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.