

CLEAR RUBBER ADHESIVE PART NO. 143334

PHYSICAL PROPERTIES

MONOMER (Liquid)

Base Compound..... Ethyl Cyanoacrylate
Appearance Colorless Liquid
Viscosity (cps @ 68°F) 800 cP
Specific Gravity (g/cc) 1.06
Flash Point (TCC) 185°F
Shelf Life @ 40°F 1 year unopened
Military Specifications Mil-A-46050C
Type II, Class 3

POLYMER (Cured)

Appearance Colorless Solid
Service Temperature Range -65°F to 200°F
Softening Point 329°F
Refractive Index (ND 20) 1.49
Full Cure Time 24 Hours
Dielectric Strength KV/mm 11.6
Dielectric Constant @ 1Kc 5.4
COE (in./in./F) 0.000126
Tensile Strength (Steel/Steel) 3400psi
Solubility Nitromethane, Acetone,
Dimethylformamide



DESCRIPTION

Dynatex® Clear Rubber Bonder is a single component medium viscosity cyanoacrylate adhesive. It is suitable for general-purpose bonding but provides excellent strength and speed on all rubber compounds.

FEATURES

- General purpose bonding
- No mixing
- Provides excellent strength and speed
- Medium viscosity
- For use on all rubber compounds
- Super strong; holds up to 3,400 psi

CURING PERFORMANCE

The gap of the bond line will affect set speed. Smaller gaps tend to increase the speed. Activators can be applied to improve set speed but may also impair overall adhesive performance.

TYPICAL APPLICATIONS

- Reattaching trim
- Knobs
- Logo plates
- Broken plastic pieces
- Especially designed for rubber to rubber applications

Packaging

Colors: Clear

Size: 20g Bottle Carded

DIRECTIONS FOR USE

1. Make sure the surfaces to be bonded are clean and dry.
2. Dispense a drop or drops to one surface only. Apply only enough to leave a thin film after compression.
3. Press parts together and hold firmly for a few seconds. Good contact is essential. An adequate bond develops in less than one minute. (Maximum strength is achieved in 24 to 48 hours.
4. Wipe off excess adhesive from the top of the container and recap. *Dynatex® Clear Rubber Bonder*, if left uncapped, may deteriorate by contamination from moisture in the air.
5. Because *Dynatex® Clear Rubber Bonder* condenses by polymerization, sometimes whitening will occur on the surface of the container or the bonded materials. Should this happen, wipe surfaces well with acetone.

PERFORMANCE OF CURED MATERIALS

Tensile shear strength, cured for 48 hours @ 20-25°C (68-77°F)	
Substrate	Range in N/mm ²
Blasted Steel	19 to 25
Etched Aluminum	12 to 20
Neoprene	>10
ABS	>6
Polycarbonate	>5
PVC	>6

CHEMICAL RESISTANCE

Sheer strength on steel after 500 hours.

Solvent	% Strength Retained
Motor Oil	90
Gasoline	100
Trichloroethane	100
Freon TA	100
10% NaOH	0
10% HCl	0
Water	0

SETTING TIME (68°F, 65% R.H.)

Steel	10 to 20 seconds
Aluminum.....	7 to 15 seconds
Neoprene	<7 seconds
ABS	5 to 10 seconds
Polycarbonate.....	10 to 15 seconds
PVC	5 to 10 seconds

STORAGE AND SHELF LIFE

When stored in the original unopened containers at or below 77°F (25°C), *Dynatex® Clear Rubber Bonder* has a shelf life of 12 months from date of shipment.

In Countries where high heat and humidity are a factor, special precautions must be taken. Store product in a covered, well-ventilated warehouse and avoid excessive heat conditions. Storage in high heat, high humidity conditions may reduce shelf life by up to 30%. Rotation of stock is an absolute necessity. Cartons should always be stacked upright. DO NOT stack cartons on their side. **NEVER** stack cartons more than 8 high. DO NOT store within 1 meter (4 feet) of roofline of the warehouse or storage building.

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