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2P-10 Cyanoacrylate Adhesive (Jel, Thick, Medium, Thin)

2P-10 is an ethyl cyanoacrylate adhesive. It is specially formulated for difficult to bond surfaces.

■ APPLICATIONS:

- Suitable for bonding porous or absorbent materials such as wood, paper, leather and fabric.
- Excellent adhesion to metal, plastic and elastomeric compounds.

BONDS:

- | | | |
|---------------|-----------------|-------------------|
| ■ Acrylic | ■ Polycarbonate | ■ Paper |
| ■ PVC | ■ Leather | ■ Fabric |
| ■ Polysulfone | ■ Wood | ■ Latex |
| ■ Steel | ■ Aluminum | ■ Zinc Dichromate |

BONDING TIMES:

Under normal conditions, the surface moisture initiates the curing process. Functional strength developed in a short time but curing continues for at least 24 hours before full chemical/solvent resistance is developed. The rate of cure will depend on substrate used.

| | | | |
|-----------------|---------------|----------------|--------------|
| Stainless Steel | 5-20 seconds | Aluminum | 2-10 seconds |
| Polycarbonate | 10-40 seconds | PVC | 2-10 seconds |
| Neoprene | > 5 seconds | Wood | 2-10 seconds |
| ABS | 2-10 seconds | Nitrile Rubber | >5 seconds |

■ PHYSICAL PROPERTIES

Liquid

| | |
|----------------------------------|--|
| Composition | Surface Insensitive Ethyl Cyanoacrylate Adhesive |
| Appearance | Colorless liquid |
| Viscosity@ 25 °C, cps | Gel |
| Brookfield LVF, Spindle 1-60 rpm | |

Cured Adhesive

| | |
|---------------------------|-------------------------|
| Gap Filling | 0.75 mm |
| Tensile Shear Strength | 15-26 n/mm ² |
| Service Temperature Range | -40 to + 185 °F |
| Full Cure | 24 hours |
| Melting Point Temperature | 160 to 170 ° C |

Mechanical Properties

| | |
|---|-----------------------|
| Glass Transition Temperature, ASTM E228, °C | 120 |
| Dielectric Strength, ASTM D149, v/mil | 625 |
| Coefficient of thermal expansion, ASTM D696, K ⁻¹ | 80 x 10 ⁻⁶ |
| Coefficient of thermal conductivity, ASTM C177, W.m ⁻¹ K ⁻¹ | 0.1 |

Shear Strength, ASTM D1002/DIN 53283

| | |
|--------------------|---------------------------|
| Woods | 25 – 27 N/mm ² |
| Grit Blasted Steel | 18 – 28 N/mm ² |
| Neoprene Rubber | 10 – 18 N/mm ² |
| PVC | 3 – 9 N/mm ² |
| Etched Aluminum | 11 – 19 N/mm ² |
| Polycarbonate | 5 – 20 N/mm ² |

APPLICATION INSTRUCTIONS

- All surfaces must be clean, dry, dust and grease free. Best result will be achieved with surfaces that have been lightly abraded immediately prior to bonding.
- If using accelerator apply to one component surface only. Apply thin film of adhesive to the other surface and bring the pieces together immediately. Hold for few seconds without disturbing the joints.
- Thin bond lines favor high cure speed. Increasing the bond gap will slow down the rate of cure.

PRECAUTIONS: This product and the auxiliary materials normally combined with it are capable of producing adverse health effects ranging from minor skin irritation to serious systemic effects. None of these materials should be used, stored, or transported until the handling precautions and recommendations as stated in the Material Safety Data Sheets (MSDS) for this and all other products being used are understood by all persons who will work with the product.