



ACA GEL CYANOACRYLATE ADHESIVE

PRODUCT DESCRIPTION

ACA GEL is a non slump, thixotropic Cyanoacrylate adhesive. It is designed for use on vertical surfaces and for bonding of porous materials or inaccurately fitting components where gap filling is required.

APPLICATIONS

A general purpose high viscosity grade. Bonding of wood, cork, paper and porous materials. Where bonding of vertical surfaces is required or where adhesive flow is minimal.

CHARACTERISTICS:

- > Single component adhesive 100% solvent free
- > High viscosity gel type adhesive
- > Large gaps up to 1mm

PERFORMANCE DATA, TYPICAL VALUES

Tensile shear strength

Material	Fixture Time	Strength (N/mm ²)
ABS/ABS	35 Seconds	15
Nylon	35 Seconds	15
PVC	60 Seconds	10
Phenolic	25 Seconds	13
Mild Steel (degreased)	65 Seconds	20
Aluminium (degreased)	20 Seconds	18



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PHYSICAL PROPERTIES OF LIQUID ADHESIVE

Monomer	Modified ethyl cyanoacrylate
Appearance	Colourless
Specific Gravity	1.10
Viscosity @ 25°C (Brookfield)	40,000 + cPs
Flash Point (Cleveland open cup)	> 85°C
Shelf Life(Stored below 25°C)	6 months minimum
Toxicity	Non-toxic

PHYSICAL PROPERTIES OF CURED ADHESIVE

Refractive index (ND20)	1.46
Hardness (Rockwell)	85
Specific resistance OHM/cm	8×10^{12}
Dielectric constant @ 1MHZ	3.44
Softening Point	150°C
Working temperature range	-60°C to + 80°C

DIRECTIONS FOR USE

Ensure surfaces are clean and dry, apply adhesive to one surface. Press surfaces together and hold for 10 seconds or as indicated below. Cure speed is rapid so exercise care when aligning. Cure performance can be enhanced if necessary, by using selected activators.

TYPICAL BONDING TIMES

Plastics	10 - 60 seconds depending on substrate
Rubbers	5 - 20 seconds depending on substrate
Metals (degreased)	15 - 60 seconds depending on substrate

LIMITATIONS

Ensure surfaces are degreased prior to bonding
This product is not suitable for permanent glass bonding, or applications where the bonded joint maybe immersed in water



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RELATIVE HUMIDTY CONDITIONS

Where possible the working environment should have a relative humidity of 50%+

CAUTION

Prior to use consult relevant Material Safety Data Sheet. When continuously used local fume extraction is recommended. Contains cyanoacrylate ester. Use in a well ventilated environment. In the event of inadvertent skin bonding separate bonded skin issue carefully by peeling apart gently with a blunt instrument. Preferably after soaking in warm soapy water. Keep out of reach of children.

STORAGE

Store in original sealed upright container between +3°C and 20°C in a dry area out of direct sunlight. The lower the temperature the longer the ultimate shelf life, but bring to room temperature before use.

PACKAGING

Available in 20g tubes.
Other packs available upon request.

FURTHER INFORMATION

Please contact Amber Composites for additional information.

This is not a specification. The information given in this data sheet in relation to the performance, storage and other characteristics of the product is based on results gained from experience and tests and is believed to be accurate. Given, however, that conditions of use and storage will vary, Amber Composites will not be liable for any loss or damage resulting from reliance upon such information. The purchaser is recommended to carry out his own tests to establish the suitability of the product for its particular purpose. The use of the product in certain processes may require third party consent.