TECHNICAL DATA SHEET

INSTANT ADHESIVE GEL • MULTI-PURPOSE BONDING

PART NO. **CA-GEL**

DESCRIPTION

CAGEL is a high-viscosity, rapid-curing, gel instant adhesive. It is designed to bond a wide range of similar and dissimilar materials. Handling strength in most applications is in 25 seconds with maximum gap filling properties.

PHYSICAL PROPERTIES

Technology / Base	Modified Ethyl
Type of Product	Cyanoacrylate
Components	One Component
Curing	Humidity
Appearance / Color	Colorless
Consistency	Gel

TECHNICAL DATA

Property		Value	Method/Condition
Rheology			
Viscosity		75000 +/- 5000 cPs	Brookfield SP4 @ 25°C
Density			
Specific Gravity		1.05	N/A
Uncured Materials Characteristics			
Flash Piont		80°C (176°F)	N/A
Set Time	Steel (sec)	<30	N/A
	ABS (sec)	<20	N/A
	EPDM (sec)	<20	N/A
Shelf Life		12mo	N/A
Cured Materials Characteristics			
Full Cure Time		24 hours	N/A
Cure Appearance		Clear	N/A
Service Temperature		-55 to 95°C	N/A
Cured Mechanical Properties			
See Graphs and Table			

INSTRUCTIONS

Surfaces to be bonded should be clean and dry. Dispense a drop or drops to one surface only. Apply only enough to leave a thin film layer after compression. Press parts together and hold firmly for a few seconds. Good contact is essential. An adequate bond develops in less than one minute and maximum strength is attained in 24 hours. Wipe off excess adhesive from the top of the container and recap. Products, if left uncapped, may deteriorate by contamination from moisture in the air. Because products cure by polymerization, whitening may appear on the surface of the container or the bonded materials. This will not affect adhesive performance. Factors affecting cure speed include gap size and humidity. Thin bond line results in faster cure speed. Larger gaps will lengthen cure speed. Cure and fixture times can be influenced by the humidity conditions at the time of assembly. The higher the RH the faster cure and fixture times will be. Fixture time data based on our testing is conducted at 50% relative humidity.

CURING PERFORMANCE

Ambient surface moisture initiates the curing process. Handling strength is reached in a short time, and will vary based on environmental conditions, bond line gap, and other factors. Product will continue to cure for at least 24 hours before full strength and solvent resistance is developed.

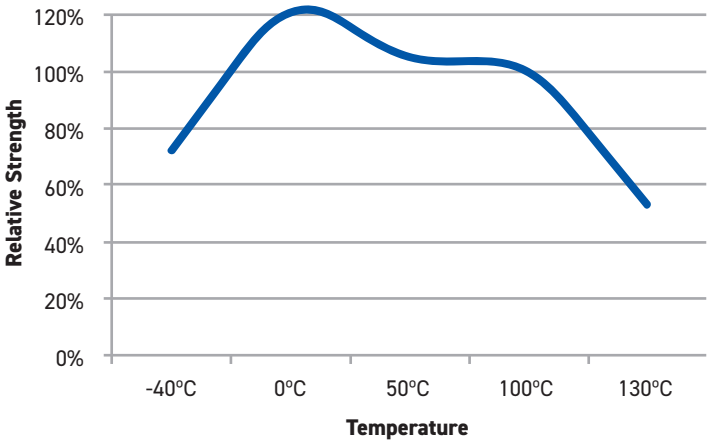
STORAGE

Containers should be stored in a cool, dry, dark area. Storage temperature 15.5°C - 25°C (60°F - 77°F), without exposure to direct light or heat. Do not refrigerate.

SAFETY & DISPOSAL

For safe handling information and disposal instructions on this product, consult the Safety Data Sheet (SDS).

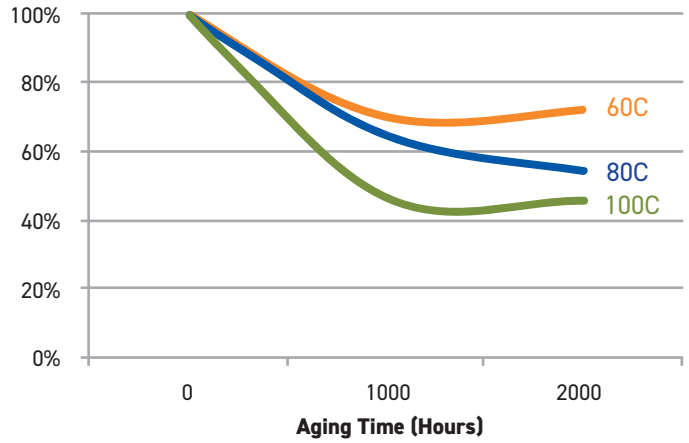
HOT STRENGTH %RT Strength, Tested at Temperature



SOLVENT RESISTANCE

Solvent	Resistance
Alcohol	Excellent
Ester (aromatic)	Excellent
Ketone (aromatic)	Poor
Aliphatic hydrocarbon (alkanes)	Good
Aromatic hydrocarbons	Good
Halogenated hydrocarbons	Poor
Weak aqueous acid	Excellent (Poor if concentrated)
Weak aqueous base	Excellent (Poor if concentrated)

HEATING AGING Aged at Temperature Indicated & Tested at 22°C



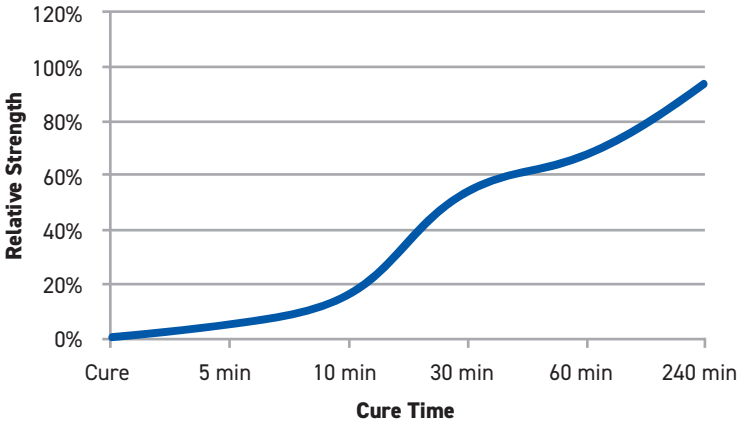
PERFORMANCE OF CURED ADHESIVE

Substrate	N/mm²			PSI		
Steel	13.8	to	18.8	2000	to	2730
Rubber*	4.3	to	15.2	630	to	2200
AL	10.4	to	13.2	1510	to	1920
PC**	22.3	to	24.9	3240	to	3605
PVC**	18.3	to	26.7	2660	to	3875
ABS**	12.0	to	18.3	1740	to	2660

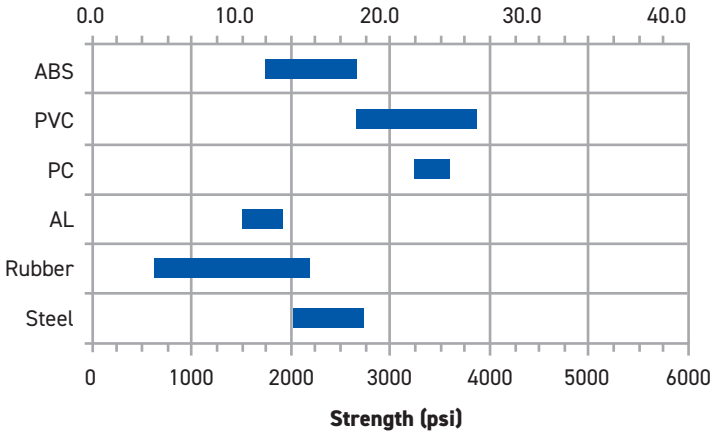
***Rubber figures given are typical.** Your results may vary by specific rubber type.

**Tested to ASTM 4501 ***n/r = not recommended

TIME UNTIL FULL CURE %RT Strength



PERFORMANCE RANGE BY SUBSTRATE (N/mm²)



DISCLAIMER

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