



INSTANT ADHESIVE BLACK SEMI-GEL • RUBBER TOUGHENED

PART NO. **CA500RT**

DESCRIPTION

CA500RT is a black, medium viscosity, rubber-toughened ethyl instant adhesive. It provides superior shock and thermal resistance when bonding rubbers, metals, and plastics in harsh environments, and displays excellent strength and flexibility on a variety of substrates.

PHYSICAL PROPERTIES

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

TECHNICAL DATA

Property	Value	Method/Condition
Rheology		
Viscosity	500 +/- 100 cPs	Brookfield SC4-21, @ 25°C
Density		
Specific Gravity	1.06	N/A
Uncured Materials Characteristics		
Flash Point	80°C (176°F)	N/A
Set Time		
Steel (sec)	<60	N/A
ABS (sec)	<50	N/A
EPDM (sec)	<40	N/A
Shelf Life	12mo	N/A
Cured Materials Characteristics		
Full Cure Time	24 hours	N/A
Cure Appearance	Black	N/A
Service Temperature	-55 to 140°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.

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.

SPECIFICATIONS AND APPROVALS

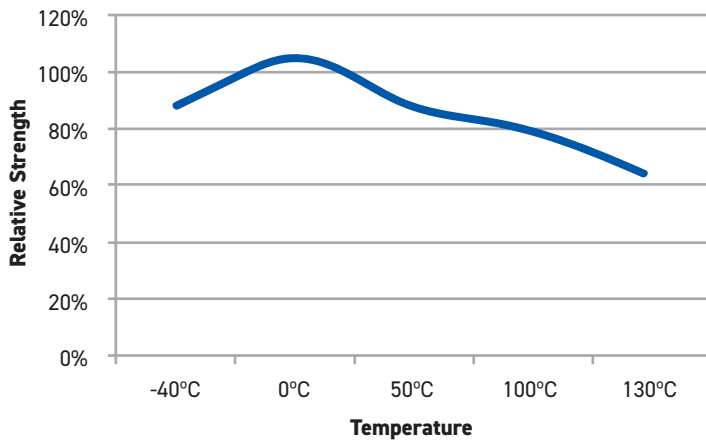
Mil-A-46050C, Type II Class 3,
CID A-A-3097, Type II Class 3

SAFETY & DISPOSAL

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



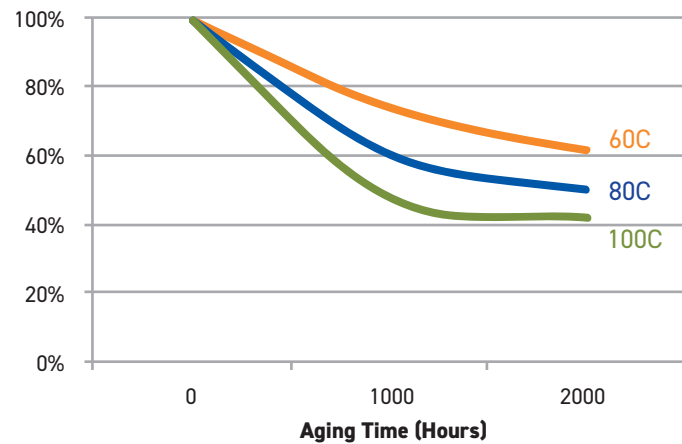
HOT STRENGTH %RT Strength, Tested at Temperature



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

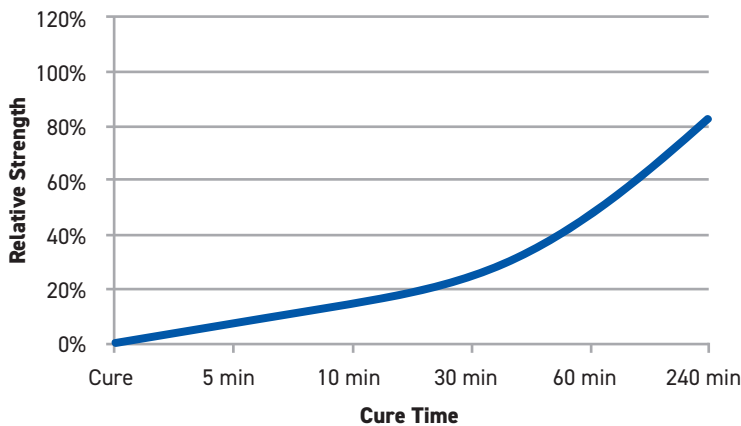


PERFORMANCE OF CURED ADHESIVE

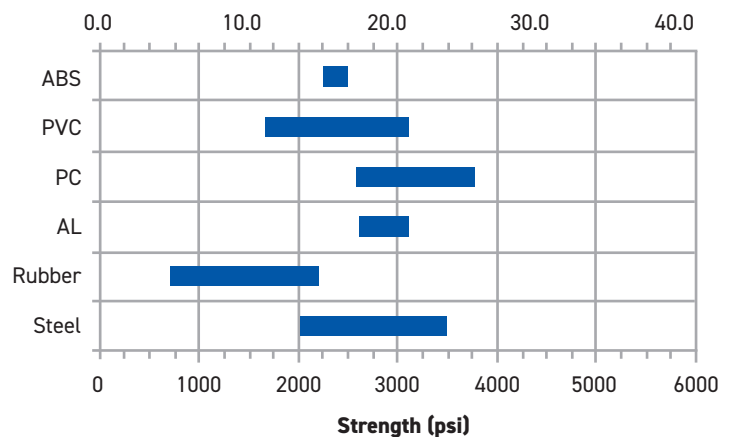
Substrate	N/mm ²	PSI
Steel	13.8 to 24.1	2000 to 3500
Rubber*	4.9 to 15.2	710 to 2200
AL	18.0 to 21.5	2610 to 3115
PC**	17.8 to 26.0	2585 to 3770
PVC**	11.4 to 21.4	1655 to 3110
ABS**	15.5 to 17.2	2250 to 2500

*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

IMPORTANT: The information, specifications, procedures and recommendations herein (together "information") are based on our experience and we believe these to be accurate. No representation, guarantee or warranty is made as to the accuracy or completeness of the information or that the information will avoid losses or damages or give desired results. It is user's sole responsibility to test and determine the suitability of any product for the intended use. Tests should be repeated if materials or conditions change in any way. The user is advised to review the specific context of the intended use to determine whether the user's intended use violates any law or infringes upon any patent(s). No employee, distributor or agent has any right to change these facts and offer a guarantee of performance.

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