

### RUBBER ADHESIVE PART NO. 42077

#### PHYSICAL PROPERTIES

##### MONOMER (Liquid)

Base Compound .....	Ethyl Cyanoacrylate
Appearance .....	Clear
Viscosity (cps @ 68°F) .....	800 cP
Specific Gravity (g/cc) .....	1.06
Flash Point (TCC) .....	185°F
Shelf Life @ 60°F.....	9mths in unopened containers
Military Specifications .....	Mil-A-46050C Type II, Class 3
Setting Time: (68°F, 65%R.H.)	
Steel .....	35 seconds
ABS.....	6 seconds
EPDM .....	4 seconds

##### POLYMER (Cured)

Appearance .....	Clear Solid
Service Temperature Range.....	-65°F to 205°F
Softening Point .....	329°F
Full Cure Time .....	24 Hours
Tensile Strength (Steel/Steel) .....	3700 psi
Solubility... Nitromethane, Acetone, Dimethylformamide	



#### DESCRIPTION

**Dynatex® Rubber Adhesive** is a clear medium-viscosity, rubber ethyl cyanoacrylate adhesive. Provides excellent strength and speed when bonding rubbers.

#### FEATURES

- Ready to use
- No mixing
- Permanent bond
- Fills gaps to .004"
- Holding strength to 5000 psi

#### TYPICAL APPLICATIONS

- Automotive trim
- Minor interior repairs
- Knobs
- Logos
- Household repairs and more...

#### CURING PROPERTIES

Ambient surface moisture will initiate the hardening process. Handling strength is reached in a short period of time and varies depending on environmental conditions and substrates being bonded. Product will continue to cure for at least 24 hours before full strength and resistances are developed.

#### 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.

## PERFORMANCE OF CURED MATERIALS

(Tensile shear strength, cured for 48 hours  
@ 20-25°C (68-77°F)

Substrate	Range in N/mm <sup>2</sup>
Blasted Steel	13 to 19
Etched Aluminum	>3
ABS	>12
Polycarbonate	>22
PVC	>18

## CHEMICAL RESISTANCE

Sheer strength on steel after 12 month soak

### % Strength Retained

Motor Oil.....	100
Gasoline.....	100
Trichloroethane .....	100
Freon TA.....	100
10% NaOH.....	0
10% HCl .....	0
Water .....	0

## 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® Rubber Adhesive**, if left uncapped, may deteriorate by contamination from moisture in the air.
5. Because **Dynatex® Rubber Adhesive** 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.

## STORAGE AND SHELF LIFE

When stored in the original unopened containers at or below 90°F (32°C), **Dynatex® Rubber Adhesive** 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.

## USERS PLEASE READ

The information and data contained herein is believed to be accurate and reliable; however, it is the user's responsibility to determine suitability of use. Since the supplier cannot know all the uses, or the conditions of use to which these products may be exposed, no warranties concerning the fitness or suitability for a particular use or purpose are made.

It is the user's responsibility to thoroughly test any proposed use of our products and independently conclude satisfactory performance in the application. Likewise, if the application, product specifications or manner in which our products are used requires government approval or clearance, it is the sole responsibility of the user to obtain sure authorization.

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