

CLEAR RUBBER BONDER PART NO. 45500

DESCRIPTION

Dynatex® Clear Rubber Bonder is a single component, medium viscosity cyanoacrylate adhesive. Suitable for general-purpose bonding but provides excellent strength and speed on all rubber compounds

PHYSICAL PROPERTIES

MONOMER (Liquid)

Base Compound	Ethyl Cyanoacrylate
Appearance.....	Colorless Liquid
Viscosity (cps @ 68°F)	800 cP
Specific Gravity (g/cc).....	1.06
Flash Point (TCC)	185°F
Shelf Life @ 40°F.....	One year in unopened containers
Military Specifications.....	Mil-A-46050C Type II, Class 3

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.

Setting Time (68 F, 65% R.H.)

Steel	10 to 20 seconds
Aluminum	7 to 15 seconds
Neoprene.....	<7 seconds
ABS	5 to 10 seconds
Polycarbonate	10 to 15 seconds
PVC	5 to 10 seconds

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.

POLYMER (Cured)

Appearance.....	Colorless Solid
Service Temperature Range	-65 ⁰ F to 200 ⁰ F
Softening Point.....	329 ⁰ F
Refractive Index (ND 20)	1.49
Full Cure Time.....	24 Hours
Dielectric Strength KV/mm	11.6
Dielectric Constant @ 1Kc	5.4
Coefficient of Thermal Expansion (in./in./F)000126
Tensile Strength (Steel/Steel)	3400 psi
Solubility.....	Nitromethane, Acetone, Dimethylformamide

Performance of Cured Materials

(Tensile shear strength, cured for 48 hours @ 20-25⁰C (68-77⁰F)

Substrate	Range in N/mm2
Blasted Steel	19 to 25
Etched Aluminum	12 to 20
Neoprene.....	>10
ABS	>6
Polycarbonate	>5
PVC	>6

CHEMICAL RESISTANCE

Sheer strength on steel after 12 month soak

Solvent	% Strength Retained
Motor Oil	100
Gasoline	100
Trichloroethane.....	100
Freon TA	100
10% NaOH	0
10% Hcl	0
Water	0

GENERAL DIRECTIONS

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 attained in 24 hours.

4. Wipe off excess adhesive from the top of the container and recap. *Dynatex® Clear Rubber Bonder*, if left uncapped, may deteriorate by contamination from moisture in the air.
5. Because *Dynatex® Clear Rubber Bonder* 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

Product should be stored unopened in a cool, dry place out of direct sunlight. Products can be refrigerated for improved shelf life but should be brought back to room temperature before use.

For safe handling information on this product, consult the Material Safety Data Sheet (MSDS).

USERS PLEASE READ

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