



# TECHNICAL DATA SHEET



## CA GEL ADHESIVE PART NO. 20254

### DESCRIPTION:

**DynaGrip CA GEL ADHESIVE** is a gel consistency surface insensitive cyanoacrylate adhesive. It is specifically formulated for non-drip and non-run applications. It is specially formulated for difficult to bond surfaces.

### APPLICATIONS:

- Ideal for bonding porous and absorbent materials such as wood, paper, leather and fabric
- Excellent adhesion to metal, plastic and elastomeric compounds.

### BONDING TIMES:

Stainless steel	5-20 seconds	Aluminium	2-10 seconds
Polycarbonate	10-40 seconds	PVC	2-10 seconds
Neoprene	>5 seconds	Wood	2-10 seconds
ABS	2-10 seconds	Nitrile Rubber	>5 seconds



### PHYSICAL PROPERTIES:

#### Liquid

Composition	Surface Insensitive Ethyl Cyanoacrylate
Appearance	Colourless liquid
Viscosity	Gel

#### Cured Adhesive

Gap Filling	0.75 mm
Tensile Shear Strength	15-26 n/mm <sup>2</sup>
Service Temperature Range	-60 to +80 °C
Full Cure	24 hours
Melting Point Temperature	160 to 170 °C

#### Mechanical Properties

Glass Transition Temperature, ASTM E228, °C	120
Dielectric Strength, ASTM D149, v/mil	625
Coefficient of thermal expansion, ASTM D696, K <sup>-1</sup>	80 x 10 <sup>-6</sup>
Coefficient of thermal conductivity, ASTM C177, W.m <sup>-1</sup> K <sup>-1</sup>	0.1

### **Shear Strength ASTM D 1002/DIN 53283**

Grit Blasted Steel	18-28 N/mm <sup>2</sup>
Etched Aluminium	11-19 N/mm <sup>2</sup>
Neoprene	10-18 N/mm <sup>2</sup>
Wood	25-27 N/mm <sup>2</sup>
Polycarbonate	5-20 N/mm <sup>2</sup>
PVC	3-9 N/mm <sup>2</sup>

### **APPLICATION INSTRUCTIONS**

- All surfaces must be clean, dry, dust and grease free. Best result will be achieved with surfaces that have been lightly abraded immediately prior to bonding.
- If using accelerator apply to one component surface only. Apply thin film of adhesive to the other surface and bring the pieces together immediately. Hold for few seconds without disturbing the joints.

### **DIRECTIONS:**

1. Ensure parts are clean and dry.
2. Best results will be achieved with surfaces that have been lightly abraded prior to bonding.
3. Protect clothing and work surfaces. Use in a well-ventilated area.
4. Carefully open bottle while keeping bottle pointed away from face.
5. Apply glue to one surface. Assemble parts and hold together with pressure for 10-30 seconds or until set.
6. If using with DynaGrip® CA745 ACTIVATOR (P/N 20155) apply to one surface only and apply a thin film of adhesive to the other surface. Bring pieces together immediately. Hold for a few seconds without disturbing joints.
7. After use wipe top of nozzle to remove any excess glue before recapping bottle securely.
8. STORE UPRIGHT IN A COOL AREA AWAY FROM SUNLIGHT/HEAT SOURCES.

**NOTE:** Not for use with Teflon, polyethylene, polypropylene, certain silicone rubber types, glass, rear view mirrors or parts that are subjected to great shock or continuous immersion in water.

**CAUTION: EYE IRRITANT. BONDS SKIN & EYES IN SECONDS.** Contains ethyl cyanoacrylate. Use with adequate ventilation. Avoid contact with clothing as can cause burn. In case of eye contact, flush with water for 15 minutes; get medical attention for eye or internal contact. To remove from skin, soak in acetone nail polish remover & gently peel adhesive off with fingernail; water exposure will wear off residual adhesive in a few days (do not use polish remover around eye area). **KEEP OUT OF REACH OF CHILDREN.**

**QUALITY PRODUCTS**

### **GENERAL INFORMATION**

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 their 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 require government approval or clearance, it is the sole responsibility of the user to obtain sure authorization.

The supplier warrants only that its products will meet its specifications. There is no use, nor any other express or implied warranty. The user's exclusive remedy and the supplier's sole liability is limited to refund of the purchase price or replacement of any product when to be otherwise than as warranted. The supplier will not be liable for incidental or consequential damages of any kind.

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