ENGINEERING ADHESIVES TECHNICAL DATA

GENERAL PERFORMANCE CYANOACRYLATES

PART NUMBER	DESIGNATION	VISCOSITY	CURE* TIME	GAP FILL	TEMP. RANGE	TENSILE LBS./IN.	IMPACT LBS./IN.	TYPICAL APPLICATIONS
7430	General Purpose Fast Cure	40-50 cps	2-3 sec.	.004″	-100° to 180°F	4,700	7-10	For bonding metal to dissimilar substrates.
7431	Penetrating Instant Cure	2-5 cps	1-2 sec.	.002″	-100° to 180°F	4,000	3-5	For bonding parts after positioning or adjusting.
7432	Rubber and Plastic	90-110 cps	3-5 sec.	.005″	-100° to 180°F	4,000	3-5	For O-rings, rubber to metal and most plastics.
7433	Wood and Fiber Med-Long Cure	275-325 cps	7-10 sec.	.006″	-100° to 180°F	4,000	4-6	For hardwood, fiber name plates, paper.
7434	Porous Surfaces Long Cure	1,400-1,600 cps	10-25 sec.	.010″	-100° to 180°F	4,000	4-6	For ceramics, pottery, name plates, paper, open cell foam, leather.
7435	Maximum Gap Fill	2,300-2,700 cps	25-45 sec.	.020″	-100° to 180°F	4,000	4-6	Allows for part alignment, uneven surfaces, very porous parts.

SPECIAL PERFORMANCE CYANOACRYLATES

7530	Plastics/ Performance	2-5 cps	2-3 sec.	.004″	-114° to 200°F	4,400	4-8	Maximum strength for bonding plastics and elastomers, nylon, PVC, ABS.
7531	High Clarity	100-200 cps	3-5 sec.	.006″	-65° to 175°F	3,000	3-5	High clarity, low vapor, low odor, excellent moisture resistance.
7532	Critical Surfaces	90-110 cps	3-5 sec.	.006″	-114° to 180°F	4,000	3-5	For acidic and contaminated surfaces, soft wood, cork, cardboard, plastic.
7533	High Temperature	90-110 cps	3-5 sec.	.006″	-114° to 300°F	3,500	10-15	For temp. to 300°F constant, 400°F intermittent. Excellent impact resistance. For automotive, electronic, and industrial applications.
7534	High Peel	400-800 cps	8-15 sec.	.012″	-114° to 212°F	2,900	5-10	For bonding dissimilar materials. High peel strength, excellent elongation.
7535	Severe Service	4,800-5,200 cps	2-4 min.	.025″	-114° to 260°F	3,200	20-25	Good impact, peel, high temperature and gap filling properties. For porous surfaces.

*Cure time is related to bond thickness. These values are typical but are dependent on bond line.

EPOXIES

PART NUMBER	DESIGNATION	POT LIFE (per 2 oz.)	CURE TIME	HARDNESS (Shore D)	SHEAR, PSI	IMPACT, IZOD FT. LBS./IN.	TEMPERATURE RANGE	MIXED VISCOSITY @ 68°F
7515	Metal Filling and Repairs	45 mins.	48-72 hrs.	75	2,800	4	-60° to 210°F	40,000-55,000 cps
7522	High Performance	90 mins.	48-72 hrs.	75	2,800	4	-60° to 210°F	40,000-50,000 cps
7538	General Purpose	30 mins.	24 hrs.	80	3,000	0.5	-60° to 210°F	40,000-55,000 cps
7575	5-Minute Curing	5-7 mins.	1 hr.	75	2,850	2.1	-60° to 185°F	12,000-16,000 cps