

**TECHNICAL DATA SHEET****CA PLUS LOW ODOR / LOW BLOOM GEL CYANOACRYLATE**

**Product Description:** This advanced performance product of Gel Cyanoacrylate has been designed and manufactured to meet the demands of today's product assembly requirements while at the same time reducing odor and blooming. Standard Cyanoacrylates are generally eye and nose irritants. CA PLUS Low Odor / Low Bloom Gel cyanoacrylate virtually eliminates the odors and fumes that cause irritation and the whitening effect around the bond. (Sometimes called blooming.)

**Physical Properties:****(Uncured Properties)****Base Compound****Appearance****Viscosity @ 68°F****Flash Point (TCC)****Density****Shelf Life****Soluble in****Alkoxy-ethyl Cyanoacrylate****Clear, Colorless****Thixotropic Gel****>175°F****1.10****Six Months, unopened****Nitromethane****(Cured Properties)****Refractive Index****Solubility****Fixture Time:****Wood to Wood****Nitrile to Nitrile****Neoprene to Neoprene****EPDM to EPDM****Steel to Steel****PVC to PVC****Polycarbonate to Polycarbonate****1.45****Nitromethane****15 – 20 seconds****< 7 seconds****< 7 seconds****< 7 seconds****20 to 40 seconds****20 to 40 seconds****20 to 50 seconds****24 Hours****Full Cure****Shear Strength:****Grit Blasted Steel****Etched Aluminum****Nitrile Rubber****Polycarbonate****Tensile Strength:****Grit Blasted Steel****Nitrile Rubber****Neoprene Rubber****> 2000psi****> 1500psi****> 500psi (Substrate failure)****> 1800psi****> 2200psi****> 700psi (Substrate failure)****> 700psi (Substrate failure)****Gap fill (Inches)****.010" to .012"****Temp. Range****-65°F to +180°F**

**Preparation:**

For best results and optimum adhesive performance, surfaces should be clean and free from contaminants. Contaminants can be removed by using suitable solvents. When using a cleaning solvent, first check for material compatibility particularly in the case of plastics. An easy method for removing contaminants is by using a clean cloth and wiping the surface with acetone or alcohol.

**Application:**

The advanced performance product of CA PLUS Low Odor / Low Bloom Gel Cyanoacrylate should be applied in small amounts to one surface only. The parts should then be mated together under slight pressure. This causes the adhesive to spread out into a thin film and assures optimum adhesive performance. The pressure need only be applied for several seconds. This advanced performance product cures rapidly allowing for bonded parts to be handled within 7 to 50 seconds for most applications. Full cure is normally within 24 hours. In cases where CA PLUS Accelerator is used, fixturing will normally occur in less than 5 seconds with full cure in 8 hours.

**Shelf Life:**

The Low Odor / Low Bloom Gel Cyanoacrylate has a shelf life of six months when stored at 40°F. Shelf life at room temperature (72°F) is a minimum of 4 months. When stored in a refrigerator, allow the adhesive to gradually warm to room temperature prior to use. Avoid heat, direct sunlight and high moisture areas when storing. Avoid contaminating open containers

**Handling Precautions:**

Low Odor / Low Bloom Gel Cyanoacrylate is non-toxic and does not constitute a health hazard. Normal precautions should be observed. **KEEP AWAY FROM CHILDREN.**

Accidental skin bonding may occur. Use warm, soapy water to separate skin or use CA PLUS Debonder. Gradually work skin free. Do not use excessive force to pull bonded area apart: this will only result in the tearing of skin and/or cause irritation which is unnecessary.

Should eye contact occur, flush with water and see a physician. Do not force the bonded area apart. When the corneal surface and eyelid are bonded together treat with a suitable anti-irritant ointment and allow the eye to remain closed. Bond separation will occur naturally within 48 hours with no damage.

While the information set forth herein is believed to be accurate as of the date hereof, the Company makes no warranty or guarantee, express or implied and disclaims all liability arising out of the use of this information. As of October 2, 2003.