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TECHNICAL DATA SHEET

CA PLUS Methyl Cyanoacrylates: M5, M60, M100 and M1000

Product Description: The advanced performance series of CA PLUS Methyl Cyanoacrylates are a family of products that have been designed and manufactured to meet the demands of today's product assembly requirements. These single component, room temperature and rapid curing adhesives have been formulated to bond metal to metal and metal to other substrates such as: plastics, elastomers, wood and both porous and non porous surfaces. This new generation of cyanoacrylates create exceptional bond strengths with excellent aging, weathering and moisture resistance characteristics.

Physical Properties:	M5	M60	M100	M1000
(Uncured Properties)				
Base Compound	----------Methyl 2 Cyanoacrylate----------			
Appearance	----------Colorless, transparent liquid----------			
Viscosity @ 20ºC	5	60	100	1000
Flash Point (TCC)	----------182ºF----------			
Density	1.07	1.07	1.09	1.09
Shelf Life	------- ----------One year----------			
Soluble in	----------Nitromethane----------			
Military Spec	----------Type I----------			
Class	1	2	2	3
(Cured Properties)				
Softening Range	----------284ºF to 293ºF----------			
Melting Point	----------355ºF to 375ºF----------			
Density	1.07	1.07	1.09	1.09
Hardness (Shore A)	----------85----------			
Weatherability	----------No change observed after 200 hours--------			
Solubility	----------Nitromethane----------			
Fixture Time (Sec)	<5	<8	<10	<10
Full Cure	----------8 Hours ----------			
Tensile/Shear	----------2800-4000 psi ----------			
Gap fill (Inches	.002	.004	.006	.008
Temp. Range	----------65ºF to +200ºF ----------			

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 series of CA PLUS Methyl Cyanoacrylates 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. The advanced performance series cures rapidly allowing for bonded parts to be handled within 5 to 10 seconds for most applications. Full cure is normally within 8 hours. In cases where CA PLUS Accelerator is used, fixturing will normally occur in less than 3 seconds with full cure in 2-4 hours.

Shelf Life:

All of the advanced performance series products have a shelf life of one year when stored at 40ºF. Shelf life at room temperature (72ºF) is a minimum of six 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:

All of the advanced series products are non-toxic and so do not constitute a health hazard. Normal precautions should be observed. Use in areas where there is adequate ventilation. 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.