



SUPERGLUE

CYANOACRYLATE ADHESIVE

TECHNICAL DATA

PHYSICAL PROPERTIES

LIQUID STATE		CURED STATE	
Base	Ethyl Cyanoacrylate	Colour	Clear
Colour	Clear	Specific Gravity (20°C)	1.1~1.3
Specific Gravity (20°C)	1.053~1.060	Working Temp (°C)	-55 °C - 80°C
Refraction Index (n 20D)	1.439	Refractive Index (n 20D)	1.490
Flash Point (°C)	>80°C	Dielectric Constant (at 10MHz)	3.5
Shelf Life	12 months	Dielectric Loss (at 10MHz)	0.067
Boiling Point (°C)	65/6mm Hg	Soluble in Acetone, Dimethyl formamide, Nitromethane, Dimethyl sulfoxide	
Viscosity (cP)	80-120		

DIRECTIONS FOR USE

1. Make sure the surfaces to be bonded are clean and dry (preferable to solvent-wipe plastics glass, and rubber, and to acid-treat metals).
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 achieved in 24 to 48 hours).
4. Wipe off excess adhesive from the top of the container and recap OB1 Superglue if left uncapped, may deteriorate by contamination from moisture in the air.
5. Because OB1 Superglue polymerises on contact with moisture surfaces, sometimes whitening will occur on the surface of the container or the bonded materials. Should this happen, wipe surfaces well with debonder.

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BOND STRENGTH (TENSILE SHEAR STRENGTH, CURED FOR 24 HOURS AT 20-25°C)

MATERIALS	KG/CM ²	MATERIALS	KG/CM ²
Rigid PVC to Rigid PVC	50-70	SBR to SBR	5-10
ABS to ABS	50-70	Steel to Steel	200-220
Polycarbonate to Polycarbonate	70-120	Stainless steel to Stainless steel	200-220
Polystyrene to Polystyrene	35-45	Aluminum to Aluminum	170-190
Natural rubber to Natural rubber	5-10	Copper to Copper	150-170
*Neoprene to Neoprene	5-10	Steel to Rigid PVC	40-60
NBR to NBR	5-10	Stainless steel to Neoprene	5-10
ABS to SBR	5-10		

CURE SPEED

MATERIALS	SECONDS	MATERIALS	SECONDS
ABS to ABS	8-10	NBR to NBR	3-5
Wood to Wood	>60	Stainless steel to Stainless steel	15-20
ABS to Stainless steel	9-10	ABS to NBR	3-5
NBR to Stainless steel	7-10	Wood to ABS	25-30

PRECAUTION

1. Use with proper ventilation. Avoid contact with skin and eyes.
2. If contact with skin occurs, rinse with warm water or dissolve gradually with appropriate debonder. Do not try to remove forcibly.
3. If adhesive gets into eye, keep eye open and rinse thoroughly. Seek medical attention immediately.
4. Keep well out of reach of children.
5. Keep adhesive in a cool, dry place 20-25°C. For long term storage, refrigeration (5°C) is recommended.

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