

### CLEAR GENERAL PURPOSE ADHESIVE PART NO. 4005Z

#### DESCRIPTION

*Dynatex® General Purpose Adhesive* is a single component, medium to high viscosity Cyanoacrylate adhesive. Designed for general purpose bonding on all types of substrates where gap filling is required.

#### PHYSICAL PROPERTIES

##### MONOMER (Liquid)

Base Compound .....	Ethyl Cyanoacrylate
Appearance.....	Colorless Liquid
Viscosity (cps @ 68°F) .....	800 cP
Specific Gravity (g/cc).....	1.06
Flash Point (TCC) .....	185°F
Shelf Life @ 40°F.....	One year in unopened containers
Military Specifications.....	Mil-A-46050C Type II, Class 3

#### CURING PROPERTIES

Ambient surface moisture will initiate the hardening process. Handling strength is reached in a short period of time and varies depending on environmental conditions and substrates being bonded. Product will continue to cure for at least 24 hours before full strength and resistances are developed.

##### Setting Time (68 F, 65% R.H.)

Steel .....	10 to 20 seconds
Aluminum .....	10 to 17 seconds
Neoprene.....	<10 seconds
ABS.....	5 to 10 seconds
Polycarbonate .....	10 to 20 seconds
PVC .....	8 to 15 seconds

#### CURING PERFORMANCE

The gap of the bond line will affect set speed. Smaller gaps tend to increase the speed. Activators can be applied to improve set speed but may also impair overall adhesive performance.

**POLYMER (Cured)**

Appearance.....	Colorless Solid
Service Temperature Range .....	-65 <sup>0</sup> F to 200 <sup>0</sup> F
Softening Point.....	329 <sup>0</sup> F
Refractive Index (ND 20) .....	1.49
Full Cure Time.....	24 Hours
Dielectric Strength KV/mm .....	11.6
Dielectric Constant @ 1Kc .....	5.4
Coefficient of Thermal Expansion (in./in./F) .....	.000126
Tensile Strength (Steel/Steel) .....	3200 psi
Solubility.....	Nitromethane, Acetone, Dimethylformamide

**Performance of Cured Materials**

(Tensile shear strength after 48 hours @ 20-25<sup>0</sup>C (68-77<sup>0</sup>F)

<b>Substrate</b>	<b>Range in N/mm2</b>
Blasted Steel .....	17 to 23
Etched Aluminum .....	12 to 22
Neoprene.....	>10
ABS .....	>6
Polycarbonate .....	>5
PVC .....	>6

**CHEMICAL RESISTANCE**

Sheer strength on steel after 12 month soak

<b>Solvent</b>	<b>% Strength Retained</b>
Motor Oil .....	90
Gasoline .....	100
Trichloroethane.....	100
Freon TA .....	100
10% NaOH .....	0
10% Hcl .....	0
Water .....	0

**GENERAL DIRECTIONS**

1. Make sure the surfaces to be bonded are clean and dry.
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 attained in 24 hours.

4. Wipe off excess adhesive from the top of the container and recap. *Dynatex® General Purpose Adhesive*, if left uncapped, may deteriorate by contamination from moisture in the air.
5. Because *Dynatex® General Purpose Adhesive* condenses by polymerization, sometimes whitening will occur on the surface of the container or the bonded materials. Should this happen, wipe surfaces well with acetone.

### **STORAGE**

Product should be stored unopened in a cool, dry place out of direct sunlight. Products can be refrigerated for improved shelf life but should be brought back to room temperature before use.

**For safe handling information on this product, consult the Material Safety Data Sheet (MSDS).**

### **USERS PLEASE READ**

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**Dynatex®** A division of Accumetric, LLC

350 Ring Road Elizabethtown, Kentucky 42701 USA (800) 999-2937 TEL (270) 769-5557 FAX (270) 769-6418  
Outside U.S. TEL +1(270) 769-5557 FAX +1(270) 769-6418  
Email: sales@dynatexinc.com Website: www.dynatexinc.com