



# TECHNICAL DATA SHEET

## CA60

**Description** ULTRABOND CA60 is a low whitening, low viscosity, medium setting velocity Ethyl and medium odor Cyanoacrylate adhesive.

**Application** Ideal for bonding plastics, rubber, metal

**Full Cure Speed**

Plastic	:	13 - 18 seconds
Rubber	:	6 - 8 seconds
Metal	:	22 - 27 seconds
Wood	:	9 - 12 seconds

(22°C, 50% relative humidity ASTM D1002, 0.1 N/mm<sup>2</sup> tensile shear strength)

### General Properties

#### Uncured monomer

Main Component	Ethyl Cyanoacrylate
Appearance	Clear Liquid
Specific gravity, 25°C	1.05
Viscosity 25°C (CPS)	2-3 CPS
Brookfield LV	
Spindle 2 @ 30 rpm	
Flash point	>82°C
Shelf life (20°C) months	6
Storage	Under 10°C

(Stored in cool & dry place, unopened bottle & out of direct sunlight)

#### Cured Adhesive

Gap Filling	0.04 mm
Tensile Strength	25 ~ 30 N/mm <sup>2</sup>
steel - steel ASTM D-2095	
Tensile shear Strength	15 ~ 26 N/mm <sup>2</sup>
steel/steel ASTM D-1002	
Service Temperature Range	- 55 ~ 82°C
Full cure time	24 hours

### Safety Direction

Danger, irritant

Avoid contact with eyes and skin, bonds skin in seconds. In case of eye contact,



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flush with plenty water for over 15 minutes and call a physician immediately. Use in well-ventilated place. Avoid contact clothing; it can cause very strong heat.

### Application Direction

- ◆ The surfaces to be bonded should be clean and free of grease completely.
- ◆ ULTRABOND CD-1 debonder or acetone can treat excess Adhesive.
- ◆ If setting time is too long due to large gaps or low relative humidity. ULTRABOND CS-1 Setter can be used.
- ◆ If the porosity of surface is higher, higher viscosity type should be better.
- ◆ Difficult to bond plastics, like PE, PP, Silicone Rubber, ABS, TPR, EPDM's Adhesion, ULTRABOND CP-1 Primer should be applied firstly, then applied ULTRABOND super glue.