



TECHNICAL DATA SHEET

CA GEL

Description ULTRABOND CA GEL is thixotropic gel ethyl cyanoacrylate adhesive. Equivalent to Loctite's 409.

Application Ideal for non-running, non-dripping, vertical, porous, big gap application.

Full Cure Speed

Plastic	:	20 - 50 seconds
Rubber	:	10 - 25 seconds
Metal	:	40 - 100 seconds

(can improved by ULTRABOND CS-1 Setter)

General Properties

Uncured monomer

Main Component	Ethyl Cyanoacrylate
Appearance	Clear Liquid
Specific gravity, 25°C	1.1
Viscosity 25°C (CPS)	Thixo Gel (35,000 CPS)
Brookfield LV	
Spindle 2 @ 30 rpm	>92°C
Flash point	
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	1 mm
Tensile Strength	25 ~ 30 N/mm ²
steel - steel ASTM D-2095	
Tensile shear Strength	15 ~ 26 N/mm ²
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, 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

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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.