



## TECHNICAL DATA SHEET

### CA915

**Description** ULTRABOND CA915 is a high viscosity medium setting velocity methyl cyanoacrylate adhesive. It is especially for metal bonding.

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

**Full Cure Speed**

Plastic	:	15 - 25 seconds
Rubber	:	15 - 25 seconds
Metal	:	15 - 25 seconds
Wood	:	20 - 30 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 Chanoacrylate
Appearance	Clear Liquid
Specific gravity, 25°C	1.10
Viscosity 25°C (CPS)	1,500 CPS
Brookfield LV	
Spindle 2@ 30rpm	>82°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	0.2 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 to 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; call a physician immediately. Use in well-ventilated place. Avoid contact clothing; it can cause very strong heat.



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### 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.