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# **TECHNICAL DATA SHEET**

## CA916

**Description** ULTRABOND CA916 is a high viscosity medium setting velocity

ethyl cyanoacrylate adhesive. Equivalent to Loctite's 416.

Application Ideal for bonding plastics, rubber, metal can be cured

better with ULTRABOND CS-1 SETTER.

Full Cure Speed Plastic : 20 - 25 seconds

Rubber : 4 - 5 seconds
Metal : 20 - 40 seconds
Wood : 12 - 15 seconds

(22℃, 50% relative humidity ASTM D1002, 0.1 N/mm2 tensile

shear strength)

#### General Properties

Uncured monomer

Main Component Ethyl Cyanoacrylate

Appearance Clear Liquid

Specific gravity, 25°C 1.1

Viscosity 25°C (CPS)

Brookfield LV 1,500 CPS

Spindle 2@ 30rpm

Flash point >82°C

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Shelf life  $(20^{\circ}C)$  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  $82^{\circ}\text{C}$  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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<sup>\*\*</sup> All the information is provided on the basic in good faith, and is believed to be trustworthy but is for reference only. Adhesion is very complicated and the result of it is much dependent on the surface material, additives, releasing agents of the substrates and user's methods. UEA and its agents, dealers, distributors, directors and employees cannot accept any liability for the results whatsoever arising from the use of UEA's products due that the utilization of these products is simply out of UEA's control. The users are responsible for selecting the suitability of the products and methods of use.

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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.