



TECHNICAL DATA SHEET



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DESCRIPTION:

Loctite® Plastics Bonding System is a two-part cyanoacrylate adhesive that sets in seconds and develops tremendous strength with just one drop. The activator primes hard-to-bond surfaces such as polypropylene and polyethylene. Loctite® Super Glue Plastics Bonding System dries clear and sets without clamping. It is resistant to water, most chemicals and freezing temperatures.

RECOMMENDED FOR:

Use for repairing figurines, costume jewelry, cameras, toys, metal car parts, wiper blades, rubber seals and O-rings. Bonds leather, cork, paper, cardboard, wood, chipboard, fabric, metal, ceramic, rubber and plastics such as Plexiglass™, polycarbonate, polystyrene, PVC, polyethylene and polypropylene

NOT RECOMMENDED FOR:

- Styrofoam, foam rubber, pure bone china, glass and silicone rubber
- Glazed surfaces
- Use on repairs needing high flexibility or for gap filling applications
- Use in dishwasher, oven or microwave
- Exterior applications

FEATURES & BENEFITS:

Feature	Benefits
Dries transparent.....	Invisible repairs
Sets in seconds.....	No clamping required
No mixing.....	Ease of application
Activator.....	Bonds difficult-to-bond plastics such as polyethylene, polypropylene and Teflon™

Item #	Package	Size
681925	Carded	Activator = 4g Adhesive = 2g

DIRECTIONS:

Tools Typically Required:

Tissue paper, sharp and thin tool to puncture seal.

Safety Precautions:

Well-ventilated area, gloves.

Preparation:

Surfaces must be clean, dry and free from oil, wax and paint. Protect work area. For better adhesion, lightly roughen smooth surfaces. Pre-fit parts to be joined.

Application:

Apply the surface activator to both surfaces. Wait 20 seconds for the activator to completely dry. Remove the cap and disconnect from the adhesive tube. Pierce seal of tube carefully and replace nozzle. Apply sparingly to one side only using approximately one drop per square inch of surface. Press parts together immediately. Hold in place for 30 seconds or until bond sets. Do not reposition parts. Clean tip with tissue and replace the cap.

Clean-up

Cured adhesive may be cut away with caution using a sharp blade, removed with Duro® Super Glue Remover, acetone or with boiling water. Note: Acetone may damage some plastics. Test before use.

STORAGE AND DISPOSAL

Not damaged by freezing. Store in a cool, dry location. Humidity and high temperatures may decrease effectiveness. Use an approved hazardous waste facility for disposal.

LABEL PRECAUTIONS

FUMES MAY CATCH FIRE. **Adhesive:** Do not get in eyes or mouth or on skin. **FIRST AID TREATMENT:** Contains cyanoacrylate. Eyelid bonding: see a doctor. Skin bonding: soak skin in water and call a poison control centre. Do not force apart. **Activator:** Avoid breathing vapours and skin contact. Do not smoke. Use only in a well-ventilated area. Keep away from flames, such as a pilot light, and any object that sparks, such as an electric motor. **KEEP OUT OF REACH OF CHILDREN.**

Refer to the Material Safety Data Sheet (MSDS) for further information

DISCLAIMER

The information and recommendations contained herein are based on our research and are believed to be accurate, but no warranty, express or implied, is made or should be inferred. Purchasers should test the products to determine acceptable quality and suitability for their own intended use. Nothing contained herein shall be construed to imply the nonexistence of any relevant patents or to constitute a permission, inducement or recommendation to practice any invention covered by any patent, without authority from the owner of the patent.

TECHNICAL DATA

Typical Uncured Physical Properties		Typical Application Properties	
<u>Color:</u>	Clear	<u>Application Temperature:</u>	Apply at temperatures above 10°C (50°F)
<u>Appearance:</u>	Liquid	<u>Odor:</u>	Solvent (use in a well-ventilated area)
<u>Adhesive Base:</u>	Ethyl cyanoacrylate	<u>Set Time:</u>	30 seconds
<u>Activator Solvent:</u>	Heptane	<u>Handling Time:</u>	Leave undisturbed for at least 5 minutes. For best results, leave undisturbed overnight to allow full bond strength to develop.
<u>Specific Gravity:</u>		<u>Full Cure Time:</u>	24 hours Note: Full cure time is dependent upon the temperature, humidity and amount of adhesive used.
Adhesive	1.05		
Activator	0.684		
<u>VOC Content:</u> (Adhesive)	< 20 g/L (2% by weight)		
<u>Shelf Life:</u>	18 months from date of manufacture (unopened)		
<u>Lot Code Explanation:</u>	YYDDD YY = Year DDD = Day of manufacture based on 365 days in a year For example: 09061 = 61 st day of 2009 = March 2, 2009		
(Adhesive: Lot Code imprinted on crimped end of tube)			

Typical Cured Performance Properties

<u>Color:</u>	Clear and colorless	<u>Cured form:</u>	Non-flammable, hard, brittle solid.
<u>Bond Strength:</u>	290 to 2900 psi (2 to 20 N/mm ²)	<u>Moisture Resistance:</u>	Yes
<u>Chemical Resistance:</u>	Motor oil, leaded petrol, ethanol, isopropanol and freon TA.	<u>Service Temperature:</u>	Up to 180°F (82°C)