



# 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. No mixing required; simply prime and glue. 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 Plexiglas®, polycarbonate, polystyrene, PVC, polyethylene, polypropylene and polytetrafluoroethylene (PTFE)/Teflon®.

## NOT RECOMMENDED FOR:

- Polystyrene foams, foam rubber, pure bone china, glass and silicone rubber
- Glazed surfaces
- Use on repairs needing high flexibility or for gap filling applications
- Use in 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 PTFE/Teflon®

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

## DIRECTIONS:

**Tools Typically Required:**  
 Tissue paper

**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:**  
 To open the adhesive tube: Screw the cap and nozzle clockwise all the way down to tube shoulder, puncturing the tube. Unscrew the cap counter clockwise from the nozzle.

To open the activator: Pull top off black base, exposing felt tip applicator.

Note: The activator is only recommended for difficult to bond substrates such as polyethylene, polypropylene, polytetrafluoroethylene (PTFE) and thermoplastic rubber materials. Other substrates do not require activator.

Apply the surface activator to both surfaces (see note above). Wait 60 seconds for the activator to completely dry. Apply the adhesive 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

After cleaning, wet any tissue used for wiping off glue with water and dispose of. When cleaning up larger quantities of uncured adhesive, apply water and allow to cure and then scrape up. Note this may result in damage to the surfaces. Cured adhesive may be cut away with caution using a sharp blade, removed with acetone or with boiling water. Note: Acetone may damage some plastics and is also highly flammable. Test before use and follow manufacturer's instructions.

### STORAGE AND DISPOSAL

Not damaged by freezing in the unopened container. Optimal shelf life is achieved when unopened container is stored from 36°F to 46°F (2°C to 8°C). After opening, it is not recommended that the product be stored cold or frozen. Once opened, the product is best stored tightly sealed in a dry location away from heat sources or sun exposure. Humidity and high temperatures may decrease shelf life. Use an approved hazardous waste facility for disposal.

### LABEL PRECAUTIONS

**WARNING!** This kit contains the chemicals ethyl cyanoacrylate and heptane which may be harmful if misused.

Bonder: **WARNING!** EYE, SKIN AND RESPIRATORY IRRITANT. BONDS SKIN IN SECONDS. Contains Cyanoacrylate. May cause allergic skin reaction. Skin contact may cause burns. Avoid contact with skin and eyes. **FIRST AID:** In case of eye contact, flush with water for 15 minutes, call a physician. For skin contact, flush with water. For ingestion do not induce vomiting, call a physician. Activator: **WARNING!** May be flammable. Keep away from heat and open flame. This activator contains a heptane soaked wad and marking tip but no free liquid. Vapor may be harmful. May irritate eyes and skin on contact. **FIRST AID:** In case of eye contact, flush with water for 15 minutes, call a physician. For skin contact, flush thoroughly with soap and water. If irritation persists, call a physician. **KEEP OUT OF THE REACH OF CHILDREN.**

**WARNING:** This product contains chemicals known to the State of California to cause cancer and birth defects or other reproductive harm.

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 50°F (10°C)
<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 10 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
Adhesive	1.05		
Activator	0.684		
<u>Flashpoint:</u>			Note: Full cure time is dependent upon the temperature, humidity and amount of adhesive used
Adhesive:	176°F to 200°F (80°C to 93.4°C)		
Activator:	30.2°F (-1.00°C)		
<u>VOC Content:</u> (Adhesive)	2% by weight (< 20 g/L)		

Shelf Life: From date of manufacture (unopened)  
Stored at 36-46°F: 30 months  
Stored at 68°F: 18 months

Lot Code Explanation: #YDDDX  
# = Disregard  
(Adhesive: Lot Code Y = Last Digit of Year of Manufacture  
imprinted on crimped end of tube) DDD = Day of manufacture based on  
365 days in a year  
X= Disregard (may not appear on all)

For example: #3061  
= 61<sup>st</sup> day of 2013  
= March 2, 2013

### Typical Cured Performance Properties

<u>Colour:</u>	Clear and colorless
<u>Cured form:</u>	Non-flammable, hard, brittle solid
<u>Service Temperature:</u>	Up to 180°F (82°C )
<u>Moisture Resistance:</u>	Yes
<u>Bond Strength (Tensile Shear, ISO 4587):</u>	Varies from 290 to 2900 psi (2 to 20 N/mm <sup>2</sup> ) in 12-24 hours, depending on the substrate
<u>Chemical Resistance:</u>	Motor oil, leaded petrol, ethanol, isopropanol and Freon® TA