



TECHNICAL DATA SHEET

MEDIUM CA HOBBY GLUE

P/N 13401

DESCRIPTION

ICKYSTICKY® MEDIUM CA HOBBY GLUE is a quick-setting, gap filling formula Adhesive that bonds through oily or dirty surfaces. It is specifically formulated to bond difficult surfaces with high industrial strength.

- SUPERIOR GAP FILLING FORMULA
- MEDIUM VISCOSITY
- ALLOW APPROXIMATELY 10 TO 15 SECONDS FOR PART POSITIONING
- FULL CURE IN APPROXIMATELY 20 SECONDS
- WORKS ON OILY SURFACES
- ACCELERATE CURE SPEED WITH THE USE OF ICKYSTICKY® CA ACTIVATOR (P/N 11155, 21155)
- IDEAL FOR BONDING ROUGH, POROUS AND ACIDIC SURFACES INCLUDING WOOD, CARDBOARD, BALSA WOOD, RUBBERS, PLASTICS, METALS, LEATHER.
- WIDE VARIETY OF INDUSTRIAL MANUFACTURING AND REPAIRING APPLICATIONS
- MEETS MILITARY SPECIFICATION MLLA 46050 TYPE II CLASS II



BONDS

CERAMIC	ALUMINIUM	POTTERY	FIBREGLASS
RUBBER	LEATHER	VENEER	MOST PLASTICS
WOOD	METAL	BALSA WOOD	CARDBOARD

BONDING TIMES

Under normal conditions, the surface moisture initiates the curing process. Functional strength developed in a short-time but curing continues for at least 24 hours before full chemical/solvent resistance is developed. The rate of cure will depend on substrate used.

Plastics	2-5 seconds	Rubbers	< 3 seconds
Wood	1-5 seconds	Leather	5-15 seconds
Metals	8-10 seconds	Ceramics	12-18 seconds

PHYSICAL PROPERTIES

Liquid

Composition	Surface Insensitive Ethyl Cyanoacrylate
Appearance	Colour less liquid
Viscosity	80-120 cps @ 25°C Brookfield LVF
Specific Gravity	1.05

Cured Adhesive

Gap Filling	0.2 mm
Tensile Shear Strength	18-28 n/mm ²
Service Temperature Range	-60 to +80 °C
Full Cure	24 hours
Melting Point Temperature	160 to 170 °C

Mechanical Properties

Glass Transition Temperature, ASTM E228, °C	122
Dielectric Strength, ASTM D149, v/mil	625
Coefficient of thermal expansion, ASTM D696, K ⁻¹	90 x 10 ⁻⁶
Coefficient of thermal conductivity, ASTM C177, W.m ⁻¹ K ⁻¹	0.1

Shear Strength ASTM D 1002/DIN 53283

Grit Blasted Steel	> 20 N/mm ²
Etched Aluminium	> 18 N/mm ²
Rubbers	> 22 N/mm ²
Wood	> 25 N/mm ²
Polycarbonate	> 12 N/mm ²
ABS	> 10 N/mm ²

CHEMICAL RESISTANCE PROPERTIES

Chemical	Temp.	% Initial strength retained	
		500 hours	1000 hours
Isopropanol	22 °C	85	85
Gasoline	22 °C	80	75
Motor Oil	40 °C	90	90
Mineral Spirit	22 °C	90	90

APPLICATION INSTRUCTIONS

- All surfaces must be clean, dry, dust and grease free. Best result will be achieved with surfaces that have been lightly abraded immediately prior to bonding.
- If using accelerator apply to one component surface only. Apply thin film of adhesive to the other surface and bring the pieces together immediately. Hold for few seconds without disturbing the joints.
- When bonding "O" rings, cut a fresh surface onto each end of the rubber to gain the best possible strength.

DIRECTIONS FOR USE

TEST ON SCRAP MATERIAL BEFORE USE.

1. Ensure parts are clean and dry.
2. Protect clothing and work surfaces. Use in a well-ventilated area. Carefully open bottle while keeping bottle pointed away from face.
3. Apply glue to one surface. Assemble parts and hold together with pressure for 10-15 seconds or until set.
4. After use wipe top of nozzle to remove any excess glue before recapping bottle securely.
5. STORE UPRIGHT IN A COOL AREA AWAY FROM SUNLIGHT OR HEAT SOURCES.

NOTE: Not for use with Teflon, polyethylene, polypropylene, certain silicone rubber types, glass, rear view mirrors or parts that are subjected to great shock or continuous immersion in water.

CAUTION

EYE IRRITANT. BONDS SKIN & EYES IN SECONDS. Contains ethyl cyanoacrylate. Use with adequate ventilation. Avoid contact with clothing as can cause burn. In case of eye contact, flush with water for 15 minutes; get medical attention for eye or internal contact. To remove from skin, soak in acetone nail polish remover & gently peel adhesive off with fingernail; water exposure will wear off residual adhesive in a few days (do not use polish remover around eye area). KEEP OUT OF REACH OF CHILDREN.



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21 Hobart Street Riverstone NSW 2765 PH: +61 2 9627 7125

www.ickysticky.com.au



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