



**IFI CYANOACRYLATE SUPERGLUE. HIGH VISCOSITY.**

**1. PRODUCT DESCRIPTION:**

**IFI Superglue High Viscosity** is an ethyl cyanoacrylate liquid adhesive of high viscosity.

Outstanding adhesion to most common non-porous construction substrates.  
It is also suitable for bonding irregular or porous components, or surfaces.

**2. PROPERTIES:**

**IFI Superglue High Viscosity** has outstanding adhesion for bonding rubbers, filled rubbers, PVC trims, many plastics and wood to wood.

**IFI Superglue High Viscosity** is 100% solventless with a slower cure (depending on substrate) to allow adjustment during assembly.

**IFI Superglue High Viscosity** has a high impact strength and is suitable for vertical use, with gap filling of up to 0.25mm.

**3. APPLICATIONS:**

**IFI Superglue High Viscosity** is an excellent general purpose grade for universal bonding and is particularly suitable for bonding rubbers, ceramics, sintered bearings, magnets, metals, PVC trims, plastics, woods, MDF and china.

**IFI Superglue High Viscosity** is suitable for use with selected cyanoacrylate activators to increase cure speed.

**4. CHARACTERISTICS:**

Before Curing:

Monomer.....	Ethyl cyanoacrylate
Appearance.....	Colourless liquid
Specific gravity.....	1.10
Viscosity @ 25°C (Brookfield), cPs.....	1200-1800
Flashpoint (Cleveland open cup), °C.....	>81
Shelf life (stored below 25°C).....	12 months unopened
Toxicity.....	Non-toxic

After Curing;

Refractive index (ND20).....	1.45
Hardness (Rockwell).....	85
Specific resistance, OHM/cm.....	8 x 10 <sup>12</sup>
Dielectric constant @ 1MHZ.....	3.44
Softening point, °C.....	160

Performance, typical steel/steel substrate values;

Tensile strength (ASTM D2095), N/mm <sup>2</sup> .....	28-32
Tensile sheer strength (ASTM D1002), N/mm <sup>2</sup> .....	15-20
Impact strength (ASTM 950), N/mm <sup>2</sup> .....	2.0-2.5



## 5. CONFORMITY TO SPECIFICATIONS:

**IFI Superglue High Viscosity** has no requirements to meet any known standards for its intended application.

## 6. WORKING PROCEDURE:

### Surface Preparation:

All surfaces must be clean, dry and free from dust or traces of contaminants, which may effect adhesion.

To degrease, wipe with a pad soaked in solvent then dry with a clean cloth.

Dust should be removed using oil-free compressed air.

**IFI Superglue High Viscosity** should be applied sparingly to one of the surfaces to be bonded. Assemble immediately to opposite surface and apply pressure until bonded, taking care to align surfaces carefully and quickly.

Cure performance can be enhanced if necessary by using selected cyanoacrylate activators.

### Typical bonding times (without activators);

Plastics	15-60 seconds, depending on substrates
Rubbers	10-20 seconds, depending on substrates
Metal (degreased)	10-60 seconds, depending on substrates

Where possible the working environment should have a relative humidity of 50%+.

Always use in a well ventilated environment.

Care should always be taken when working with cyanoacrylate adhesives as there is a risk of inadvertent skin bonding.

## 7. LIMITATIONS OF USE:

**IFI Superglue High Viscosity** is not suitable for permanent glass bonding or applications where the bonded joint may be immersed in water.

Always surfaces are degreased prior to bonding and ensure surfaces are close fitting.

## 8. AVAILABLE COLOURS:

**IFI Superglue High Viscosity** is only available as a colourless liquid.

## 9. PACKAGING:

**IFI Superglue High Viscosity** is supplied in 20 gram or 50 gram bottles, fitted with a pin cap screw-on lid,

20g are boxed in 25 bottles

50g are 25 bottles



## 10. STORAGE AND SHELF LIFE:

**IFI Superglue High Viscosity** has a shelf life of at least 12 months from its date of manufacture, if stored in tightly closed original containers under cool temperatures (between +3°C and +20°C), in dry conditions and stored upright and out of direct sunlight. IFI Ltd guarantees the product for 12 months from the shipment date, when stored under these conditions.

The lower the temperature, the longer the ultimate shelf life, but always bring to room temperature before use.

If the material is kept beyond the shelf life shown on the product label, it is not necessarily unusable, but quality control should be performed on the properties relevant to the application.

## 11. SAFETY

Consult the Material Safety Data Sheet for **IFI Superglue High Viscosity** and follow the directions and health & safety information on the product label.

Care should always be taken when working with cyanoacrylate adhesives as there is a risk of inadvertent skin bonding.

The information provided in this Technical Data Sheet is correct to the best of our knowledge, information and belief at the date of its publication. The information given is designed only as a guidance for safe handling, use, processing, storage, transportation, disposal and release and is not to be considered a warranty or quality specification. The information relates only to the specific material designated and may not be valid for such material used in combination with any other materials or in any process, unless specified in the content of the Technical Data Sheet.



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