



Data Sheet

410013

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Chuangxin Park, West of Dayabay, Huizhou City, Guangdong, P.R. China
TEL (86 752) 5533798FAX (86 752) 5533798-811

DESCRIPTION:

Tacusil™ 410013 is a high viscosity, surface insensitive cyanoacrylate instant adhesive. It provides excellent adhesion to plastics, metals and elastomers as well as acidic surfaces such as woods, leather and paper. It provides high strength bonds within seconds of assembly and achieves full cure within 24 hours of assembly. Tacusil™ 410013 is a premium surface insensitive instant adhesive used in applications including white goods assembly, filter assembly, electronic housing assembly and general industrial manufacturing. The one component nature of Tacusil™ 410013 lends itself to easy automation of dispensing on production lines.

CHARACTERISTICS :

Resin:	Ethyl Cyanoacrylate
Appearance	Clear
Cure Speed with Activator:	<3 seconds
Cure Speed w/o Activator:	10-40 seconds
Viscosity:	20000-28000 cps (@30rpm)
Gap Fill:	0.25mm
Flash Point:	>185°F
Specific Gravity:	1.1
Max. Operating Temp:	-58°F to +176°F
Full Cure Time:	24hrs @ 68°F
Tensile Strength	600-2900 psi
Cure Speed	
Metal/Metal:	<90 seconds
Plastic/Plastic:	<60 seconds
Rubber/Rubber:	<40 seconds

CURED SPEED INFLUENCE:

Cyanoacrylates cure confined in close fitting gaps and in the presence of surface moisture on substrates. Cure speed can be negatively influenced by large gap thickness or low humidity environments. Activators can be used to speed up cure speed and cure excess cyanoacrylate outside of the bondline. Use of an activator can reduce bond strength.

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INSTRUCTIONS FOR USE:

1. Ensure parts are clean, dry and free from oil and grease.
2. Apply approximately one drop of adhesive per square inch of bond area. Product performs best with minimal gap between substrates.
3. Hold parts together firmly until handling strength is achieved.
4. Product is normally hand applied from the bottle. Dispensing systems are available for high volume assembly applications.

STORAGE:

Store in a cool area out of direct sunlight. Refrigeration to 5° gives optimum stability.

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