

**ALTECO**

**ALTECO**  
Industrial Cyanoacrylate  
Adhesive Catalogue

**Speed & Power**  
Cyanoacrylate Adhesives

# Rationalization / Workability

## We provide answer to your adhesion demand.

From hand craft work to ultratech industry, adhesion works are involved in any kind of industry. Substances newly made are used in many of industrial field, and environmental and human health laws are decided in worldwide against chemical products. To cover up such a newly demand from users, we introduce wide range of cyanoacrylate adhesive that is from general purpose to special purpose grade.

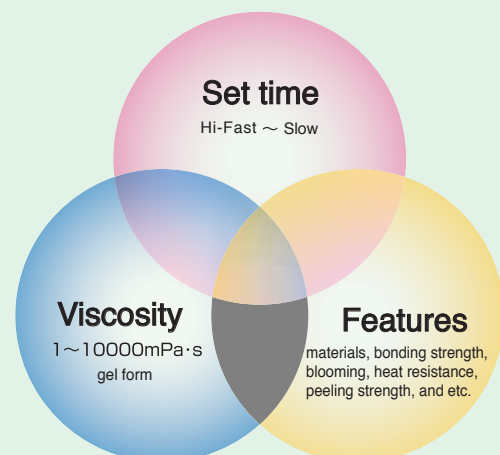
### Cyanoacrylate Adhesives

<b>Metal</b>	High bonding strength to metal adhesion. Chemical resistance.	M, MR, MX13
<b>General purpose</b>	Plastic, rubber and metal	EE, E50, V2
<b>Wood /porous material</b>	Wood, ceramic, clay	W1, W200X, W500X, W1000X, W2
<b>Hard-to-Bond</b>	For EPDM or POM	D, Z125, 88, Z114
<b>Impact resistance</b>	Good for metal adhesion. High impact resistance	CN2, CN4, CN6
<b>High viscosity / Gel</b>	Non-thread type. Gap filling. / Gap filling or vertical surface	Z106, GEL, SPEED GEL
<b>High-Speed</b>	Surface insensitive. Range of viscosity available.	EZ3, EZ20, EZ100, EZ300, EZ500, EZ800, EZ1500
<b>High peel strength*</b>	Rubber toughened. Higher heat resistance	Z200M, Z200H
<b>Low strength*</b>	1/2 bonding strength for temporally fixing	Z135
<b>Low odor / Odorless</b>	Low odor, less blooming / No odor, no blooming	Z28S, Z27, Z26 / Z84, Z84X, Z84V
<b>Artificial marble</b>	Transparent or white color	EC200, EC600X, EC1500X, EW300*, EW1000*, EW
<b>Heat resistance*</b>	Better heat resistance	HI3, HI100
<b>Flexible*</b>	Shore D 40	T10, T100, T600
<b>Humidity resistance*</b>	Flexible	Z180-A, Z180-1, Z180-2
<b>Accelerator</b>	Speed up a set time	PR150, PR310, Spray primer
<b>Primer</b>	For PP, PE, Silicone, LSE plastic	PR500, PR550, PR700

- Above is typical grade only. We may select grades available upon consultation
- Color additives are also available. ●\*Make-to-order products

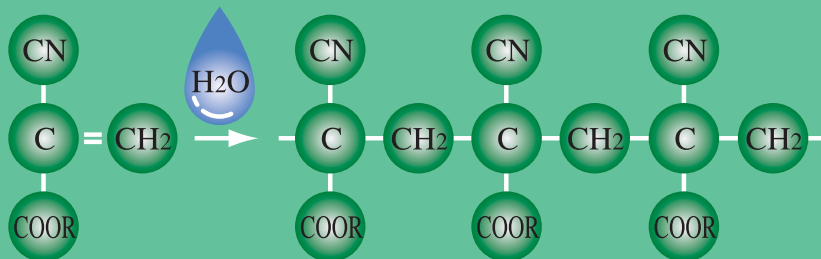
### Full order system

Grade in a catalogue is part of the grade mainly sold only. In case you cannot find appropriate grade for your demand, please use our full order system. Depend on the material to be adhered and quantity demand; we can adjust viscosity, set time and bonding strength as per your request. It is possible to add a color for applied area checking. Please contact us for a detail.



# Speed & Power

## Cyanoacrylate Adhesives



- Rapid cure.....Bond in a second. Reduce working time, and easy to establish automation line.
- Bonding capability....Possible to bond most of the materials used in industrial purpose.
- Easy application...1 component adhesive. Room temperature curing.
- VOC free.....Solvent free adhesive. Low toxicity.
- Insulation.....Does not conduct electricity.
- No mess.....Transparent after cure.



Classification	1			2								
Type	Metal			General purpose			Wood /porous material					
Product Code	M	MR	MX13	EE	E50	V2	W1	W200X	W500X	W1000X	W2	
Harding	Standard	Standard	Standard	Standard	Standard	Standard	F a s t	F a s t	F a s t	F a s t	F a s t	
Appearance	Transparent	Transparent	Transparent	Transparent	Transparent	Transparent	Transparent	Transparent	Transparent	Transparent	Transparent	
Viscosity (mPa.s)	3	15	500	3	75	2000	150	150	500	1000	1700	
Suitability	Metal	◎	◎	◎	○	○	○	○	○	○	○	
	Plastic	○	○	○	○	○	○	○	◎	○	○	
	Rubber	○	○	○	○	○	○	○	◎	○	○	
	Wood, porous material						◎	◎	◎	◎	◎	
	Hard to bond material							○				
Features	Heat resistance											
	Impact resistance											
	Chemical resistance	◎	◎	◎								
	Low-odor											
	Low-blooming											
Set-time (sec)	Steel plate	15	15	20	15	20	30	10	5	15	15	20
	Aluminium	15	15	20	15	20	30	15	10	15	15	25
	ABS	10	10	10	10	10	15	10	5	10	10	10
	PMMA (Acrylic)	10	10	10	10	10	20	10	5	10	15	15
	Hard PVC	10	10	20	10	20	25	20	10	20	20	20
	PC (Polycarbonate)	10	10	20	10	20	30	20	10	20	20	25
	CR (Chloroprene)	5	5	5	5	5	15	5	3	5	5	10
	EPDM	—	—	—	—	—	—	—	10	—	—	—
	Wood (a birch)	—	—	—	—	—	—	40	20	40	40	40
Tensile shear strength (psi)	Steel plate	3600	3600	3600	2200	2900	2900	2900	2900	2900	2900	2900
	Aluminium	1900	2300	2300	1200	1700	1700	1700	1700	1700	1700	1700
	ABS	※870	※870	※870	※870	※870	※870	※870	※870	※870	※870	※870
	PMMA (Acrylic)	※870	※870	※870	※870	※870	※870	※870	※870	※870	※870	※870
	Hard PVC	※870	※870	※870	※870	※870	※870	※870	※870	※870	※870	※870
	PC (Polycarbonate)	※1300	※1300	※1300	※1300	※1300	※1300	※1300	※1300	※1300	※1300	※1300
	CR (Chloroprene)	※72	※72	※72	※72	※72	※72	※72	※72	※72	※72	※72
	EPDM	—	—	—	—	—	—	—	※72	—	—	—
	Wood (a birch)	—	—	—	—	—	—	※1400	※1400	※1400	※1400	※1400
Packing available	2g×6	2g×6	2g×6	2g×6	2g×6	2g×6	2g×6	2g×6	2g×6	2g×6	2g×6	
	20g, 50g	20g, 50g	20g, 50g	20g, 50g	20g, 50g	20g, 50g	20g, 50g	20g, 50g	20g, 50g	20g, 50g	20g, 50g	
	100g	100g	100g	100g	100g	100g	100g	100g	100g	100g	100g	
	500g	500g	500g	500g	500g	500g	500g	500g	500g	500g	500g	
	1kg	1kg	1kg	1kg	1kg	1kg	1kg	1kg	1kg	1kg	1kg	

[Explanation of technical term]

Set Time : refers to the time taken for the adhesive fluid that was applied on the required surfaces to be hardened. According to JIS standard. The adhered surface must be able to withstand a load of at least 5kg.

Tensile strength : refers to the load per unit area required to be applied to the cross-sectional surfaces before the bonding begins to give way.

Compression strength : refers to the load per unit area required to be applied on top of the bonded surfaces before it begins to give way.

### Application for a safe use



1

Surface must be clean. If the surfaces are effected by dust or grease, the cure speed will be lengthened and adhesive strength will also be deteriorated.



2

Flip the nozzle for dropping the adhesive deposited. Make a small hole on the top of the tip with attached pin. Point tip away from face and body.



3

Apply only a small amount to one surface. Excessive amount may lengthen curing speed, create whitening on bonding materials and weaken bonding strength.

Classification		2									
Type	Hard to bond				Impact resistance			High viscosity / Gel			
Product Code	D	Z125	88	Z114	CN2	CN4	CN6	Z106	Gel	Speed-Gel	
Harding	F a s t	Hi-Fast	F a s t	Hi-Fast	Standard	Standard	Standard	S l o w	S l o w	Standard	
Appearance	Transparent	Transparent	Transparent	Transparent	Transparent	Transparent	Transparent	Transparent	Transparent	Transparent	
Viscosity (mPa.s)	3	3	3	3	3	75	1000	2000	gel form	gel form	
Suitability	Metal	○	○	○	○	◎	◎	◎	◎	◎	
	Plastic	◎	◎	◎	◎	○	○	○	○	○	
	Rubber	◎	◎	◎	◎	○	○	○	○	○	
	Wood, porous material								◎	◎	
	Hard to bond material	◎	◎	◎	◎						
Features	Heat resistance					○	○	○	○	○	
	Impact resistance					◎	◎	◎	◎	◎	
	Chemical resistance										
	Low-odor										
	Low-blooming										
Set-time (sec)	Steel plate	5	3	5	2	15	25	30	30	40	25
	Aluminium	5	3	5	2	15	25	30	30	40	25
	ABS	3	3	3	2	10	10	15	20	30	10
	PMMA (Acrylic)	3	3	3	2	15	15	20	30	40	15
	Hard PVC	5	5	5	3	10	20	25	30	40	20
	PC (Polycarbonate)	3	3	3	2	10	20	30	40	50	20
	CR (Chloroprene)	3	3	3	2	5	10	10	15	15	10
	EPDM	3	3	3	2	—	—	—	—	—	—
	Wood (a birch)	—	—	POM 15	—	—	—	—	—	60	50
Tensile shear strength (psi)	Steel plate	2200	2200	2200	2200	3600	3600	3600	3600	3600	3600
	Aluminium	1200	1200	1200	1200	1900	1900	1900	2300	2300	2300
	ABS	※870	※870	※870	※870	※870	※870	※870	※870	※870	※870
	PMMA (Acrylic)	※870	※870	※870	※870	※870	※870	※870	※870	※870	※870
	Hard PVC	※870	※870	※870	※870	※870	※870	※870	※870	※870	※870
	PC (Polycarbonate)	※1300	※1300	※1300	※1300	※1300	※1300	※1300	※1300	※1300	※1300
	CR (Chloroprene)	※72	※72	※72	※72	※72	※72	※72	※72	※72	※72
	EPDM	※72	※72	※72	※72	—	—	—	—	—	—
	Wood (a birch)	—	—	POM ※870	—	—	—	—	—	※2200	※2200
Packing available	2g×6	2g×6	2g×6		2g×6	2g×6			3g×4		
	20g, 50g	20g, 50g	20g	20g, 50g	50g	50g	50g	20g, 50g	20g, 50g	20g	
	100g	100g	100g	100g	100g	100g	100g	100g	AL tube	AL tube	
	500g	500g	500g	500g	500g	500g	500g	500g			
	1kg	1kg	1kg	1kg	1kg	1kg	1kg	1kg			

refers as substrate failure

1mPa·s=1cPs    1psi = 0.0069 N/mm<sup>2</sup>

Test method : JIS K6861(1995), JIS K6852(1994)



4

Place the other surface quickly together without spreading. Good spread and high bonding strength can be obtained.

### ■ Affect Set Time

Set Time	Slow	←→	Fast
Surface Condition	Acetic	←→	Alkalic
Temperature	Low	←→	High
Humidity	Low	←→	High

### ■ Capillary nozzle

Please use designated capillary nozzle in case require to adhere with tiny amount.



Classification		2					
Type		High-Speed					
Product Code	EZ3	EZ20	EZ100	EZ300	EZ500	EZ800	EZ1500
Harding	Hi-Fast	Hi-Fast	Hi-Fast	Hi-Fast	Hi-Fast	Hi-Fast	Hi-Fast
Appearance	Transparent	Transparent	Transparent	Transparent	Transparent	Transparent	Transparent
Viscosity (mPa.s)	3	20	100	300	500	800	1500
Suitability	Metal	○	○	○	○	○	○
	Plastic	◎	◎	◎	◎	◎	◎
	Rubber	◎	◎	◎	◎	◎	◎
	Wood, porous material	○	○	◎	◎	◎	◎
	Hard to bond material	◎	◎	◎	◎	◎	◎
Features	Heat resistance						
	Impact resistance						
	Chemical resistance						
	Low-odor						
	Low-blooming	○	○	○	○	○	○
Set-time (sec)	Steel plate	2	2	2	3	3	3
	Aluminium	2	2	2	3	3	3
	ABS	2	2	2	3	3	3
	PMMA (Acrylic)	2	2	2	3	3	3
	Hard PVC	3	3	3	5	5	5
	PC (Polycarbonate)	2	2	2	3	3	3
	CR (Chloroprene)	2	2	2	3	3	3
	EPDM	2	2	2	3	3	3
	Wood (a birch)	30	30	20	20	20	30
Tensile shear strength (psi)	Steel plate	2200	2200	2900	2900	2900	2900
	Aluminium	1200	1200	1700	1700	1700	1700
	ABS	※870	※870	※870	※870	※870	※870
	PMMA (Acrylic)	※870	※870	※870	※870	※870	※870
	Hard PVC	※870	※870	※870	※870	※870	※870
	PC (Polycarbonate)	※1300	※1300	※1300	※1300	※1300	※1300
	CR (Chloroprene)	※72	※72	※72	※72	※72	※72
	EPDM	※72	※72	※72	※72	※72	※72
	Wood (a birch)	1200	1200	※1400	※1400	※1400	※1400
Packing available	20g, 50g 100g	20g, 50g 100g	20g, 50g 100g	20g, 50g 100g	20g, 50g 100g	20g, 50g 100g	20g, 50g 100g

Classification		2					
Type		Artificial marble					
Product Code	EC200	EC600X	EC1000	EC1500X	EW300*	EW1000*	EW
Harding	F a s t	F a s t	Standard	F a s t	Standard	Standard	S l o w
Appearance	Transparent	Transparent	Transparent	Transparent	White	White	White
Viscosity (mPa.s)	200	600	1000	1500	300	1000	8000
Suitability	Metal	○	○	○	○	○	○
	Plastic	○	○	○	○	○	○
	Artificial marble	◎	◎	◎	◎	◎	◎
	Wood, porous material	◎	◎	◎	◎		
Acrylic artificial marble	Set-time (sec)	5	5	15	10	15	60
	Compression shear strength (psi)	※3600	※3600	※3600	※3600	※3600	※3600
	Compression shear strength after 24hours boiling (psi)	1200	1200	1400	1400	2900	2900
Packing available	50g 100g	50g 100g	50g 100g	50g 100g	50g 100g	50g 100g	50ml 300ml

Classification	2			3			4			
Type	High peel strength*		Low strength*	Low odor			Odorless			
Product Code	Z200M	Z200H	Z135	Z28S	Z27	Z26	Z84	Z84X	Z84V	
Harding	S l o w	S l o w	S l o w	F a s t	Standard	Standard	Standard	Standard	Standard	
Appearance	Transparent	Transparent	B l u e	Transparent	Transparent	Transparent	Transparent	Transparent	Transparent	
Viscosity (mPa.s)	300	3000	20	3	70	150	5	60	1000	
Suitability	Metal	⊙	⊙	○Low strength	○	○	○	○	○	
	Plastic	○	○	○Low strength	⊙	⊙	⊙	○	○	
	Rubber	○	○	○Low strength	⊙	⊙	⊙	○	○	
	Wood, porous material									
	Hard to bond material				⊙	⊙	⊙			
Features	Heat resistance	○	○							
	Impact resistance	○	○							
	Chemical resistance									
	Low-odor				○	○	○	⊙	⊙	
	Low-blooming				○	○	○	⊙	⊙	
Set-time (sec)	Steel plate	30	60	20	5	10	15	15	20	30
	Aluminium	30	60	20	5	15	15	15	20	30
	ABS	20	40	20	5	10	15	15	30	40
	PMMA (Acrylic)	30	60	100	15	20	20	90	100	110
	Hard PVC	30	60	50	5	10	25	15	40	50
	PC (Polycarbonate)	30	40	30	10	20	25	30	60	70
	CR (Chloroprene)	15	20	5	3	5	5	3	5	10
	EPDM	—	—	—	3	10	15	—	—	—
	Wood (a birch)	—	—	—	—	—	—	—	—	—
Tensile shear strength (psi)	Steel plate	3600	3600	720	2200	2900	2900	2200	2900	2900
	Aluminium	1900	1900	430	1200	1700	1700	1200	1700	1700
	ABS	※870	※870	※870	※870	※870	※870	※870	※870	※870
	PMMA (Acrylic)	※870	※870	※870	580	580	580	580	580	580
	Hard PVC	※870	※870	430	430	430	430	430	430	430
	PC (Polycarbonate)	※1300	※1300	※1300	※1300	※1300	※1300	※1300	※1300	※1300
	CR (Chloroprene)	※72	※72	※72	※72	※72	※72	※72	※72	※72
	EPDM	—	—	—	※72	※72	※72	—	—	—
	Wood (a birch)	—	—	—	—	—	—	—	—	—
Packing available	20g, 50g 100g 500g 1kg	20g, 50g 100g 500g 1kg	20g, 50g 100g 500g 1kg	20g, 50g 100g 500g 1kg	20g, 50g 100g 500g 1kg	20g, 50g 100g 500g 1kg	20g, 50g 100g 500g 1kg	20g, 50g 100g 500g 1kg	20g, 50g 100g 500g 1kg	

refers as substrate failure

\*Make-to-order products

## ■ Solvent cracking

Cyanoacrylate adhesive may crack or dissolve surface of plastic like styrol, polycarbonate, PMMA or ABS.

### [How to prevent]

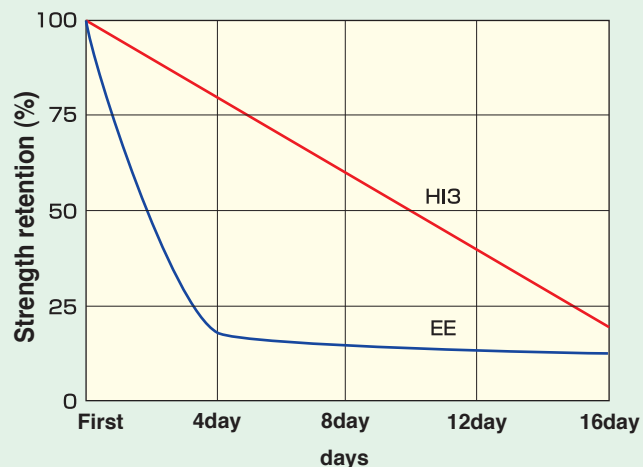
- Use appropriate amount
- Use high-speed type
- Reduce internal strain of plastic parts

# To-order products

## Heat resistance cyanoacrylate adhesive

Recommend to use for an auto parts or temporally fixing of print circuit board before soldering.

Type		Heat resistance	
Product Code		HI3	HI100
Harding		S l o w	S l o w
Appearance		Transparent	Transparent
Viscosity (mPa.s)		300	1000
Suitability	Metal	◎	◎
	Plastic	○	○
	Rubber	○	○
Features		Heat resistance ◎	Heat resistance ◎
Set-time (sec)	Steel plate	30	60
	Aluminium	30	60
	ABS	20	40
	CR (Chloroprene)	15	20
Tensile shear strength (psi)	Steel plate	3600	3600
	Aluminium	1900	1900
	ABS	※ 870	※ 870
	CR (Chloroprene)	※ 72	※ 72
Packing available		20g, 50g	20g, 50g



Stored in 248°F (120°C) for each days.  
Measure tensile share strength after returns to room temperature.

## Flexible cyanoacrylate adhesive

For bonding rubber and plastic. Z180 has better humidity resistance.

Type		Flexible			Flexible / Humidity resistance		
Product Code		T10	T100	T600	Z180-A	Z180-1	Z180-2
Harding		S l o w	S l o w	S l o w	Standard	Standard	Standard
Appearance		Transparent	Transparent	Transparent	Transparent	Transparent	Transparent
Viscosity (mPa.s)		10	100	600	4	4	300
Suitability	Metal	○	○	○	○	○	○
	Plastic	○	○	○	○	○	○
	Rubber	◎	◎	◎	○	○	○
Features	Flexible	◎	◎	◎	○	○	○
	Humidity resistance				○	○	○
	Hardness (HDD)	40	40	40	70	70	70
Set-time (sec)	Steel plate	40	60	70	10	20	20
	ABS	40	60	60	10	20	20
	CR (Chloroprene)	5	10	10	5	5	5
	NBR	5	10	10	10	15	15
Tensile shear strength (psi)	Steel plate	1400	1400	1400	2900	2900	3600
	ABS	※ 870	※ 870	※ 870	※ 870	※ 870	※ 870
	CR (Chloroprene)	※ 72	※ 72	※ 72	※ 72	※ 72	※ 72
	NBR	※ 72	※ 72	※ 72	※ 72	※ 72	※ 72
Packing available		20g, 50g	20g, 50g	20g, 50g	20g, 50g	20g, 50g	20g, 50g

refers as substrate failure



## General Property

Monomer (Property before curing)

Classification	1	2	3	4
Appearance	Colorless and transparent			
Specific gravity ( $d_4^{20}$ )	1.100	1.056	0.976	1.070
Freezing Point (°F)	35 ( 1.5 )	-21 ( 29.5 )	28 ( -2.0 )	<-4 ( <-20 )
Flash point (°F)	190 ( 83.0 )	185 ( 75.0 )	200 ( 93.0 )	203 ( 95.0 )
Ignition Point (°F)	870 ( 465 )	905 ( 485 )	770 ( 410 )	626 ( 330 )

Base Classification 1, 2, 3 : Alkyl Cyanoacrylate

Classification 4 : Alkoxyalkyl Cyanoacrylate

Polymer (Property after curing)

Classification	1	2	3	4
Appearance	Clear solid			
Specific gravity	1.260	1.244	1.126	1.171
Hardness (HDD)	90	85	70	60
Softening point (°F)	330 ( 165 )	295 ( 145 )	230 ( 110 )	140 ( 60 )
Glass transition point (°F)	340 ( 170 )	285 ( 140 )	255 ( 125 )	175 ( 80 )
Coefficient of linear expansion $\times 10^{-4}$	0.9	1.1	1.3	1.0
Dielectric constant (10MC, 50°F)	3.5	3.5	3.5	3.5
Dielectric loss tangent (10MC, 50°F)	0.07	0.07	0.07	0.07
Dielectric breakdown voltage (kV/0.1mm, 73.4°F)	14	14	14	14
Volume resistivity ( $\Omega\text{cm}$ , 86°F)	$10^{14}$	$10^{14}$	$10^{14}$	$10^{14}$
Soluble in	DMF DMSO	Acetone DMF, DMSO		

## Blooming

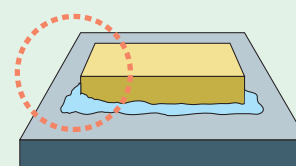
Evaporate gas from uncured Cyanoacrylate adhesive react with moisture in the air that turns out a surrounding to be white powdery appearance.

### [How to prevent]

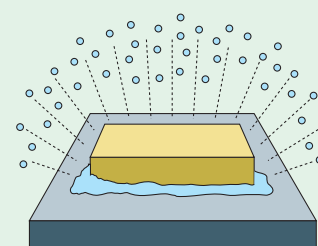
- Clean out materials to be free from dust, moisture or grease.
- Lower a humidity in the working area
- Use appropriate amount.
- Wear PE glove while working
- Use or store in well ventilated place
- Use accelerator

### [How to clean up a blooming]

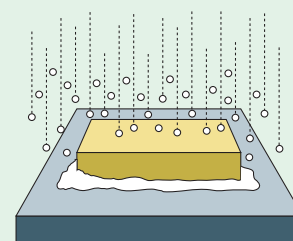
- Wipe off by clean dry cloth
- Use acetone or alcohol.  
(Please make sure solvents will not attack base material)



Excess amount of CA will not cure for long time.






CA start to evaporate



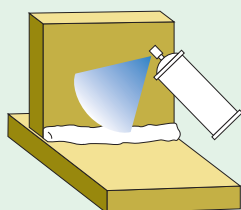
React with moisture in the air.  
Cured evaporated CA turns out white powdery substance.

# Accelerator

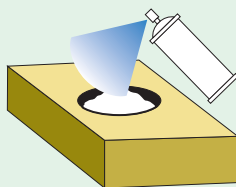
		
<b>PR150</b>	<b>PR310</b>	<b>Spray Primer</b>
liquid	liquid	aerosol
Cyclopentane	alcohol	Cyclopentane
250ml	250ml	100ml, 420ml

## [ The followings can be easily done. ]

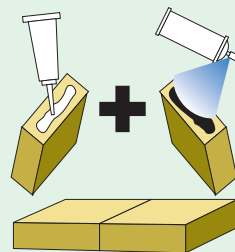
- Prevent whitening:  
Surroundings are prevented from whitening.
- Filling bonding  
Heap up and filling bonding.
- hardening acceleration:  
Curing time is fastened.  
Bonding for porous material (wood)



Heap up



Filling



Bonding for porous material (wood)



Without accelerator



With accelerator

## ● Application method

- Prevent whitening and hardening acceleration:  
Apply accelerator on one surface of materials first .  
Apply the CA on the other surface after accelerator completely dries and put both surfaces together, with which much faster curing can be got compared to the bonding with CA only.
- Filling bonding  
Apply the CA to the surface, and overlay accelerator carefully.

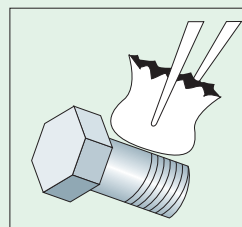
## [ Caution ]

- Excess amount of accelerator may weaken bonding strength and/or discoloration. Please be careful not to apply too much. Applying too much accelerator to CA may cause heat and smoke. Appearance might be ruined by rapid curing reaction.
- Reactions starts immediately after applying. Curing process cannot be stopped once started.
- Please make sure to test with actual materials before mass production.

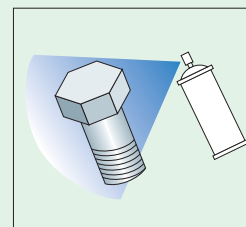
## [ Caution to handle ]

- Contains solvent. Use at well-ventilated area.
- Flammable.
- In case of skin contact, wash it off well with soap.
- In case of contacts eye, wash it off well with fresh water and get a medical attention.
- Store in a cool and dark place after using.
- Store apart from cyanoacrylate adhesives.

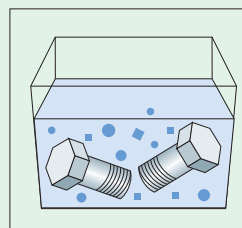
## ● How To Use



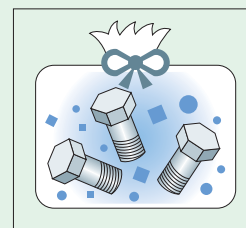
By cloth or brush



Spraying



Soak into accelerator



Leave into evaporated accelerator

Please carry out individual tests to make sure product fits your specific needs.

# Primer

The PRIMER is the primer for polyolefin, silicone rubber, EPDM, POM, and SPVC. It makes a surface of those material to a suitable surface, which can be bonded by ALTECO cyanoacrylate adhesive. It works on a wide variety of materials so that the product should be applied to variuos industrial usages.



for PE

for PP

for silicone rubber

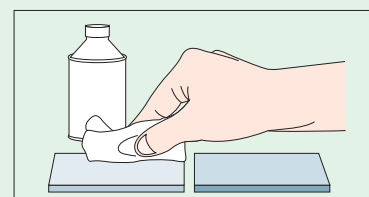
		PR500	PR550	PR700
Appearance		Clear Liquid	Clear Liquid	Clear Liquid
Specific gravity		0.72	0.79	0.76
Main Componets		Octane	Acetone	alcohol, Methylcyclohexane
Packing available		250ml	250ml, 40ml	250ml
Open Time		20min	12hr	2hr
the Bonding materials		PE, PP, POM, EPDM, SPVC, TPO	PP, PE, POM, EPDM, SPVC, TPO, nylon	silicone rubber, SPVC
Tensile shear strength (psi)	PE	※580	※580	
	PP	※580	※580	
	EPDM	※140	※140	
	SPVC	※290	※290	
	Silicone rubber / Silicone rubber			※72
	Silicone rubber / Chloroprene rubber			※72
	Silicone rubber / Urethane rubber			※72
	Silicone rubber / Stailless Steel			※72
Peel strength (lbf/635in)	PE	160	160	
	PP	※1500	※1500	
	EPDM	※89	※89	
	SPVC	※270	※270	

refers as substrate failure

The open time may vary on appying quantity, working area's atmosphere, or on bonding materials. You should be careful to bond the materials as soon as you apply PRIMER.

## Application method

- Clean off the dirt or grease on the surface of the bonding materials.
- Soak PRIMER in clothes or brushes. Apply on the surface of bonding material.
- Let PRIMER dry enough.
- Soon after the solvent in PRIMER dried, apply the CA on the other surface of material by dropping or lining, and put both surfaces together.
- Keep the bonded materials for about 30 minutes to get an initial cure.



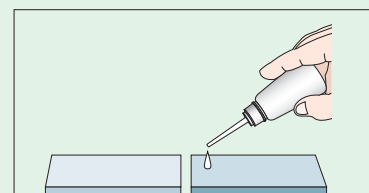
Apply primer by cloth or brush

### [ Caution ]

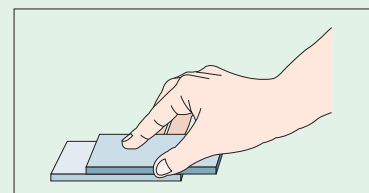
- Excess amount of PRIMER may weaken bonding strength. Please be careful not to apply too much.
- Use PRIMER to polyolefin only. Using on the material, which can be bonded with CA only may weaken bonding strength.

### [ Caution to handle ]

- Contains solvent. Use at well-ventilated area.
- Flammable.
- In case of skin contact, wash it off well with soap.
- In case of contacts eye, wash it off well with fresh water and get a medical attention.
- Store in a cool and dark place after using.
- Store apart from cyanoacrylate adhesives.



Let Primer dry, and apply CA



Set together and leave it for 30min.

Please carry out individual tests to make sure product fits your specific needs.

## The standard table

	Wood	Ceramic, clay	Stone	EPDM	Chloroprene (CR)	Natural Rubber (NR)	TPO	Silicone Rubber	PP / PE	Nylon	Urethane	POM / PBT	Polyester	PET	Polycarbonate	Phenol	Hard PVC	Acrylic	ABS	Plating	Steel/Al/SUS	
Steel/Al/SUS	W	CN W	EE W	D EZ	EE CN	D	88 EZ	EE CN	D EZ	D EZ	88 EZ	88 EZ	D EZ	D CN	EE CN	EE CN	EE CN	EE CN	EE CN	EE CN	CN M	CN M
Plating	W	CN W	EE W	D EZ	EE CN	D	88 EZ	EE CN	D EZ	D EZ	88 EZ	88 EZ	D EZ	D CN	EE CN	EE CN	EE CN	EE CN	EE CN	EE CN	CN M	
ABS	W	CN W	EE W	D EZ	EE	D	88 EZ	EE	D EZ	D EZ	88 EZ	88 EZ	D EZ	D EZ	EE	EE	EE	EE	EE	EE		
Acrylic	W	CN W	EE W	D EZ	EE	D	88 EZ	EE	D EZ	D EZ	88 EZ	88 EZ	D EZ	D EZ	EE	EE	EE	EE	EE	EE		
Hard PVC	W	CN W	EE W	D EZ	EE	D	88 EZ	EE	D EZ	D EZ	88 EZ	88 EZ	D EZ	D EZ	EE	EE	EE					
Phenol	W	CN W	EE W	D EZ	EE	D	88 EZ	EE	D EZ	D EZ	88 EZ	88 EZ	D EZ	D EZ	EE	EE						
Polycarbonate	W	CN W	EE W	D EZ	EE	D	88 EZ	EE	D EZ	D EZ	88 EZ	88 EZ	D EZ	D EZ	EE							
PET	EZ	EZ	EZ	D EZ	D EZ	D EZ	88 EZ	D EZ	D EZ	D EZ	88 EZ	88 EZ	D EZ	D EZ								
Polyester	EZ	EZ	EZ	D EZ	D EZ	D EZ	88 EZ	D EZ	D EZ	D EZ	88 EZ	88 EZ	D EZ									
POM / PBT	EZ	EZ	EZ	88 EZ	88 EZ	88 EZ	88 EZ	88 EZ	D EZ	88 EZ	88 EZ	88 EZ										
Urethane	EZ	CN W	EZ	D EZ	D EZ	D EZ	88 EZ	D EZ	D EZ	D EZ	88 EZ											
Nylon	EZ	CN W	EZ	D EZ	D EZ	D EZ	88 EZ	D EZ	D EZ	D EZ												
PP / PE	EZ	EZ	EZ	D EZ	D EZ	D EZ	88 EZ	D EZ	D EZ													
Silicone Rubber	EZ	EZ	EZ	D EZ	D EZ	D EZ	88 EZ	88 EZ														
TPO	EZ	EZ	EZ	88 EZ	88 EZ	88 EZ	88 EZ															
Natural Rubber (NR)	W	CN W	EE W	D EZ	D T	D T																
Chloroprene (CR)	W	CN W	EE W	D EZ	EE T																	
EPDM	EZ	EZ	EZ	D EZ																		
Stone	W	CN W	EE W																			
Ceramic, clay	W	CN W																				
Wood	W																					

- Better using PR500 or PR550 for a stable bonding
- Use PR700
- Use PR500 or PR550

- When there is a need to speed up the set time: use hard-to-bond, high speed type or accelerator
- When there is a need to delay the set time: use slow curing type
- When there is a need to prevent blooming: use low odor type, odorless type or accelerator
- When there is a distinct odor: use low odor type, or odorless type
- When there is a need for filling and plugging gaps: use high viscosity or gel
- When material is not easily adhere: use high speed type or primer

※ Standard table is for selecting reference. Upon your necessary condition, such as viscosity, set time and bonding strength, decide an appropriate grade from a base type.

## CAUTION



### If on skin

Wash with plenty of soap and water.



### If in eyes

Rinse cautiously with water for several minutes. Remove contact lenses, if present and easy to do. Continue rinsing. Immediately call a POISON CENTER or doctor/physician.



### If inhaled

Remove victim to fresh air and keep at rest in a position comfortable for breathing. Immediately call a POISON CENTER or doctor/physician.



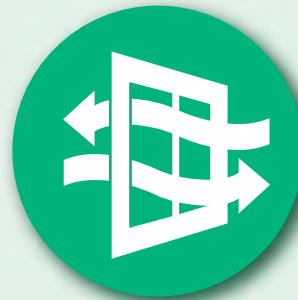
### If swallowed

Do not induce vomiting. Rinse your mouth with plenty of water, and seek a medical attention.



### If spilled

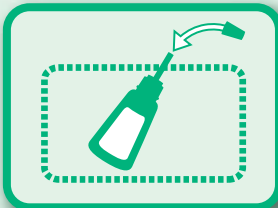
For small spills: Absorb spill with inert material (dry cloth, dry sand), then place in a chemical waste containers using non-sparking tools.  
For large spills: Flush residual spill (area) with plenty of water. Dike for later disposal. Wash with plenty of water.



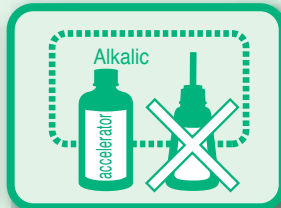
### Handling

Keep away from heat/sparks/open flames/hot surfaces. No smoking. Avoid breathing mist/vapours/spray. Use only outdoors or in a well-ventilated area.

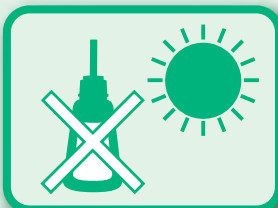
## After Use



- Wipe off the glue on the nozzle and replace cap. Store in cool and dark place. Avoid direct sunlight and basic materials.



- Do not store close to accelerator or base material



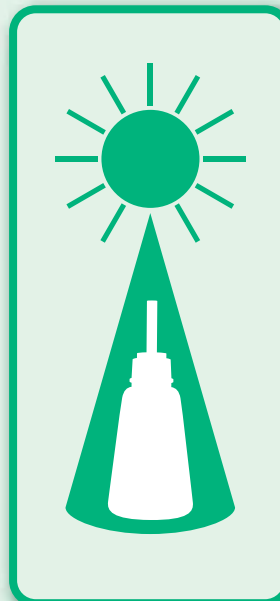
Avoid direct sunlight.



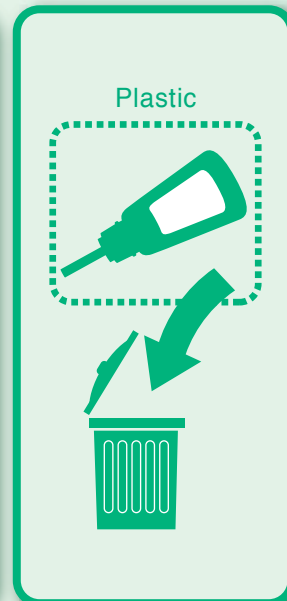
Keep out of reach of children.

## Disposure

If small amount, let it cure by direct sunlight. If large amount, do not let it cure at once. After cured, dispose as plastic under local regulation.



- Store under direct sunlight



- Dispose as plastic

- \*Actual adhesive properties may vary according to various conditions upon actual  
Please carry out individual tests to make sure product fits your specific needs.
- \*Product spec, design and appearance may change without prior notice.
- \*For further information, request Material Safety Data Sheet (MSDS).
- \*All existing chemicals may have unknown hazards, so please handle with care.

●An agency

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