

PACER[®]
TECHNOLOGY

INDUSTRIAL • PRIVATE LABEL



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High Impact Cyanoacrylate Adhesives

High Impact Cyanoacrylate adhesives offer excellent toughness and impact resistance compared to competitive formulations. These adhesives provide outstanding performance for metal-to-metal structural bonding applications and are available in two viscosity ranges to meet most application requirements.

LIQUID STATE	20404	20405
Base Chemical	Ethyl Hybrid Cyanoacrylate	
Color	Clear, Translucent liquid	
Viscosity, cP	30-70	100-200
Flashpoint, °F (COC)	185	185
Vapor Pressure, mmHg @ 70°C	8	8
Specific Gravity (@25°C)	1.07	1.07
Gap Fill, Typical, inches	.004	.005
Soluble in:	Pacer X-9 Debonder, Acetone, MEK, Nitromethane	
CURED STATE	20404	20405
Tensile Strength, steel (psi)	5000 (±10%)	5000 (±10%)
Impact Strength, (ft.lbs/in ²) Steel, (ASTM D950-54)	10-15	15-20
Rockwell Hardness, M	75	75
Outgassing (@ 10 ⁻⁶ mmHg, 72°F)	0	0
Temperature Range	-65F to +180F (-54C to +82C)	
Soluble in:	Pacer X-9 Debonder, Acetone, Nitromethane	
Tensile Shear Strength, (psi)	20404	20405
Steel	2700 (±10%)	2700 (±10%)
Aluminum	1600 (±10%)	1600 (±10%)
ABS	SF*	SF*
PVC	SF*	SF*
EPDM	100 (±10%)	100 (±10%)

* Substrate failure

STORAGE AND SHELF LIFE:

Refrigerate unopened cyanoacrylate @ 40F (4C) for optimum results. Allow adhesive to reach room temperature before opening. Once opened, store in a cool, dry location. Stored under these conditions, a one-year shelf life can be expected.

**APPLICATION AND CURE CHARACTERISTICS:**

For best results, parts should be clean, free from oil and grease or other contaminants. Apply adhesive to one surface to be bonded and mate the other surface to it carefully and without delay. For best results, use a minimal amount of adhesive. In general, one free-falling drop covers one square inch of bond area. Avoid over-application, as excess adhesive is difficult to remove from unwanted areas. Fixture time occurs in 1-5 minutes with 80% of full strength developing in 15-30 minutes. Fixture time and full cure rates are dependent upon temperature, relative humidity, bondline thickness, and substrates being bonded. To speed full cure through larger gaps, Pacer accelerators for instant adhesives are compatible and can be used. Post application of accelerators to exposed adhesive may cause a white frosting (chlorosis) of the exposed adhesive onto parts, which can usually be removed using Pacer X-9 Debonder and a cotton swab. Overall cure strength can be decreased as a result of using accelerators. Testing on actual parts is recommended.

Specification Compliance	20404	20405
A-A-3097 (Commercial Spec)	II/1	II/2
Container Size	20g	20g

SAFETY AND HANDLING PRECAUTIONS:

Cyanoacrylate adhesives bond skin in seconds. In case of skin contact, flush with water. If skin becomes bonded, peel (not pull) apart after immersion in warm, soapy water. In case of eye or mouth contact, flush with water and get immediate medical attention. Use with adequate ventilation. Vapors can irritate eyes and mucous membranes. Symptoms disappear after removal of individual from vapors. For more information, refer to Material Safety Data Sheet, available upon request.

In case of emergency, call CHEMTREC at (800) 424-9300 or call Pacer Technology at (800)-538-3091 (outside CA only), or 909-987-0550.

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The data contained herein is furnished for descriptive purposes only and is believed to be reliable. Users of any products described in the data sheet have the responsibility to determine the suitability for their particular use thereof, and Pacer relies upon such users to adopt all necessary precautions to ensure the protection of property and persons against hazards involved in the use thereof.

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