



Pacer Technology PX Series cyanoacrylate adhesives provide the maximum strength for bonding various plastics and elastomers together or to other substrates. Three viscosities are available to fit a variety of applications requirements.

<b>LIQUID STATE</b>	<b>PX-5</b>	<b>PX-50</b>	<b>PX-500</b>
Base Chemical	Ethyl Propyl Cyanoacrylate		
Color	Clear, Translucent liquid		
Viscosity, cP	2-5	30-80	400-600
Flashpoint, °F (COC)	186	186	186
Vapor Pressure, mmHG @ 70°C	7	7	7
Specific Gravity (@25°C)	1.04	1.04	1.04
Gap Fill, Typical, inches	.002	.004	.008
Soluble in:	Acetone, MEK, Nitromethane		

<b>CURED STATE</b>	<b>PX-5</b>	<b>PX-50</b>	<b>PX-500</b>
Tensile Strength, steel (psi)	4200 (±10%)	4400 (±10%)	4400 (±10%)
Rockwell Hardness, M	70	70	70
Outgassing (@ 10 <sup>-6</sup> mmHG, 72°F)	0	0	0
Softening Point, °F/°C	303/151	303/151	303/151
Melting Point, °F/°C	363/184	363/184	363/184
Elongation, %	<2	<2	<2
Temperature Range	-65F to +200F (-54C to +93C)		
Soluble in:	Pacer X-9 Debonder, Acetone, Nitromethane		

Tensile Shear Strength, (psi)	PX-5	PX-50	PX-500
Steel	2700(±10%)	2700 (±10%)	2700 (±10%)
Aluminum	1000 (±10%)	1000 (±10%)	700 (±10%)
ABS	SF*	SF*	SF*
PVC	SF*	SF*	SF*

\* 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.

**APPROVALS:**

Pacer Technology will certify compliance with the following:

<b>Specification Compliance</b>	<b>PX-5</b>	<b>PX-50</b>	<b>PX-500</b>
MIL-A-46050C (Type/Class)	II/1	II/1	II/2
A-A-3097 (Commercial Spec)	II/1	II/1	II/2

**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.

<b>Size</b>	<b>PX-5</b>	<b>PX-50</b>	<b>PX-500</b>
5 g		FG05085	
20 g	FG05070	FG05080	FG05090
1 lb	FG05073	FG05083	FG05093
20 kg			FG05094

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The information in this Product Data Sheet (PDS) is of a general nature based on our knowledge and experience with this product and should be used for information and consideration purposes only. The product can have a variety of different applications, as well as differing application and working conditions in your environment that are beyond our control. Therefore, this data does not constitute a warranty, expressed or implied, statutory or otherwise, nor is it representation for which Pacer Technology assumes legal responsibility. Pacer Technology strongly recommends that users of the product independently determine the suitability of the product for their use.

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