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CE-005 TECHNICAL DATA

Glenmarc CE-005 is a fast setting, low viscosity general purpose adhesive. CE-005 wicking grade is ideal for bonding preassembled parts.

PHYSICAL PROPERTIES

MONOMER(liquid)

Base compound	Ethyl cyanoacrylate
Appearance	Colorless liquid
Viscosity (cps@68F)	5 cps
Specific Gravity (g/cc)	1.055
Flash Point(TCC)	185F
Shelf Life @ 40F	One year unopened container

SETTING TIME (68F, 65% R.H.)

Ambient surface moisture will initiate hardening process. Handling strength is reached in a short time dependent on materials used and environmental conditions. Product will continue to cure for 24 hours before full strength is achieved.

Steel	5-8 Seconds
Aluminum	7-13 Seconds
Neoprene	<5 Seconds
PVC	3-5 Seconds
Polycarbonate	5-10 Seconds
ABS	3-5 Seconds

Military Specifications **Mil-A-46050C Type II, Class 1**

POLYMER (cured)

Appearance	Colorless Solid
Service Temperature Range	-65F to 200F
Softening Point	329F
Refractive Index(ND 20)	1.49
Full Cure Time	24 hours
Dielectric Strength KV/mm	11.6
Dielectric Constant @ 1 Kc	5.4
Coefficient of Thermal Expansion (in/in/F)	.000126
Tensile strength: Steel/Steel	3200 psi
Solubility	Nitromethane, Acetone Dimethylformamide

CURING PERFORMANCE

The gap of the bond line will affect set speed. Smaller gaps tend to increase the speed. Activators can be applied to improve set speed but may also impair overall adhesive performance.

PERFORMANCE OF CURED MATERIALS

Tensile shear strength after 48 hours at 20-25C

Blasted steel	19-26 N/mm2
Etched aluminum	12-21 N/mm2
Neoprene	>10
ABS	>6
Polycarbonate	>5
PVC	>6

CHEMICAL RESISTANCE

Sheer strength on steel after 12 month soak

Solvent	% strength retained
Motor oil	95
Gasoline	100
Tricloroethane	100
Freon TA	100
10% NaOH	0
10% Hcl	0
Water	0

INSTRUCTIONS

Surfaces to be bonded should be clean and dry
Apply only enough to leave a thin film layer after compression.
Good contact is essential. Firm pressure required to bond parts.
Keep product sealed when not in use. Moisture in the air will affect product remaining in container.

Store unopened in cool, dry place out of direct sunlight.
Refrigerate for maximum shelf life and use at room temperature (optimum 65-70F)