



2001 S. Blue Island Ave. Chicago IL 60608
Ph: 312-243-0800 Fax: 312-243-4670
Email: info@glenmarc.com Web: www.glenmarc.com

CE3000EH TECHNICAL DATA

Glenmarc CE3000EH is a high viscosity cyanoacrylate adhesive designed for general purpose use. Used for maximum gap filling properties and extended repositioning time.

PHYSICAL PROPERTIES

MONOMER(liquid)

Base compound	Ethyl Cyanoacrylate
Appearance	Colorless liquid
Viscosity (cps@68F)	4000 cps
Specific Gravity (g/cc)	1.06
Flash Point(TCC)	176F
Shelf Life @ 40F	One year unopened container

Military specifications:

Mil-A-46050C Type II Class 3

CURING PROPERTIES

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	20-30 Seconds
Aluminum	15-20 Seconds
Neoprene	<15 Seconds
PVC	15-25Seconds
Polycarbonate	20-35 Seconds

Curing performance:

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

POLYMER (cured)

Appearance	Colorless Solid
Service Temperature Range	-65F to 200F
Softening Point	300F
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

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Performance of Cured Materials:

Tensile strength after 48 hours at 20-25C

Blasted Steel 18-26 N/mm²

Etched Aluminum 12-21 N/mm²

Neoprene <10 N/mm²

ABS <6 N/mm²

Polycarbonate <5 N/mm²

PVC <6 N/mm²

Chemical Resistance:

Sheer strength on steel after 12 month soak

Solvent	% Strength Retained
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Motor oil	100
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Gasoline	100
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Trichloroethane	100
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Freon TA	100
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10% NaOH	0
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10% Hcl	0
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Water	0
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General Instructions:

Surfaces to be bonded should be clean and dry. Apply only enough to leave a thin film layer after compression.

Press parts together firmly and hold for a few seconds. Good contact is essential. An adequate bond develops in less than 1 minute and maximum strength is achieved in 24 hours.

Wipe off excess material from the top of the container and cap. Air and moisture will deteriorate product.

Whitening may appear on surface of the container or bonded materials. Wipe surfaces well with acetone to remove.

Storage:

Store product in unopened cool, dry place out of direct sunlight. Products can be refrigerated for improved shelf life, but should be brought back to room temperature before use.

Consult MSDS sheet for safe handling of product.

This data contained herein are furnished for information only. The data, statements and recommendations (shown for information only) are based on tests which are believed to be reliable. Since we have no control over the end use of our product, we cannot guarantee the end results. It is the user's responsibility to determine suitability for the product or of any production methods mentioned herein and to adopt such precautions as may be advisable for the protection of property and of persons against any hazards that may be involved in the handling and use thereof.