GLENMARC INDUSTRIES INC.

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CEGEL is a slower setting, thixotropic adhesive for general purpose use. CEGEL is ideal for vertical and horizontal applications or when the issue of adhesive migration is critical.

PHYSICAL PROPERTIES

MONOMER(liquid)	
Base compound	Ethyl Cyanoacrylate
Appearance	Colorless liquid
Specific Gravity (g/cc)	1.06
Flash Point(TCC)	176F
Viscosity (cps@68F)	thixotropic
Shelf Life @ 40F	One year unopened container
Setting Time(68F, 65% R.H.)	
Rubber/Rubber	15 Seconds
Metal/Metal	60 Seconds
Plastic/Plastic	25 Seconds
Military Specifications	Mil-A-46050C Type II, Class 4
POLYMER(cured)	
Appearance	Colorless Solid
Full Cure Time	24 hours
Softening Point	293F
Refractive Index(ND 20)	1.49
Service Temperature Range	-65F to 250F
Dielectric Strength KV/mm	11.6
Dielectric Constant @ 1 Kc	5.4
Coefficient of Thermal Expansion(in/in/F)	.000126
Tensile strength: Steel/Steel	3500 psi
Solubility	Nitromethane, Acetone Dimethylformamide

Cured State CE-GEL

Color	Clear
Specific gravity	1.176
Refractive Index(n 20/d)	1.49
Softening Point	293F
Dielectric constant	3.3
Dielectric Loss(@10MHz)	0.06

Setting Time and Strength of Test Piece:

Material	**Setting Time(seconds)**	**Lap Shear Strength (N/mm²)**
Steel/Steel	60-100	18.0
SUS/SUS	120-240	17.0
ALUM/ALUM	60-120	16.0
VinylChloride	10-40	3.0 (substrate failure)
ABS/ABS	10-40	5.0 (substrate failure)
Polyacrylate/ Polyacrylate	10-40	6.0 (substrate failure)
NBR rubber/ NBR rubber	5-20	0.9 (substrate failure)
Chloroprene/ Chloroprene/	5-20	0.8 (substrate failure)

-Test conditions: Temperature 23C, Humidity 50%RH, Setting time to JIS K6861, Lap Shear strength to ISO 4587

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.