

N109 W13300 ELLSWORTH DRIVE GERMANTOWN, WI 53022  
262-253-5900 FAX 262-253-5919

### **DESCRIPTION:**

Resinlab® Cynergy CA7015 is a one part gel ethyl cyanoacrylate adhesive. It is formulated for non-sag or vertical applications where run-off or dripping needs to be avoided. It is specifically formulated for bonding plastic parts, but it can be used with a variety of substrates including metal and elastomeric compounds.

At standard indoor temperature and humidity, surface moisture on the substrate(s) initiates the cure. Handle strength is developed in a short time but curing continues for at least 24 hours before a full chemical/solvent resistance is developed.

### **TYPICAL PROPERTIES:**

All properties given are at 25 °C unless otherwise noted.

<b>Property:</b>	<b>Value:</b>	<b>Test Method or Source:</b>
<b>Color</b>	Colorless	Visual
<b>Viscosity</b>	Non sag gel	
<b>Specific Gravity</b>	1.05	Calculated
<b>Cure Schedule</b>	24 hours for full cure Rate of cure dependent on substrate	
<b>Set Times for handle strength:</b>	<b>In seconds:</b>	
<b>Stainless Steel</b>	50 – 95	
<b>Polycarbonate</b>	20 – 60	
<b>Neoprene</b>	15 – 25	
<b>ABS</b>	20 – 60	
<b>Aluminum</b>	5 – 30	
<b>PVC</b>	50 – 95	
<b>Phenolics</b>	30 – 60	
<b>Nitrile Rubber</b>	15 – 25	
<b>Gap Filling</b>	0.50 mm	
<b>Tensile Strength</b>	2175 – 3770 psi	
<b>Lap Shear Strength:</b>	<b>In psi:</b>	ASTM D1002/DIN 53283
<b>Grit Blasted Steel</b>	2030 – 3190	
<b>Neoprene Rubbers</b>	1450 – 2175	
<b>Polycarbonate</b>	725 – 1450	
<b>Etched Aluminum</b>	1450 – 2175	
<b>Wood</b>	435 – 1305	
<b>Dielectric Strength</b>	625 v/mil	ASTM D149
<b>Glass Transition Temperature</b>	120 °C	ASTM E228
<b>Coefficient of Thermal Expansion</b>	90 ppm/ °C	ASTM D696
<b>Thermal Conductivity</b>	0.1 W / (m.K)	ASTM C177
<b>Melt Point Temperature</b>	160 – 170 °C	
<b>Service Temperature Range</b>	-60 to 80 °C	

---

N109 W13300 ELLSWORTH DRIVE GERMANTOWN, WI 53022  
262-253-5900 FAX 262-253-5919

**INSTRUCTIONS:**

- 1.) Bring to room temperature prior to use if stored refrigerated. Surfaces should be clean and dry and free of grease and or debris. A light abrasion is recommended to achieve best results.
- 2.) If using an accelerator, apply to one surface only. Apply a thin film of adhesive to the other side and assemble immediately. Hold for several seconds and do not disturb or re-align the joint until parts are set.
- 3.) When bonding "O" rings, cut a fresh surface onto each end of the rubber to gain the best possible strength.
- 4.) Thin bondlines cure fastest. Increasing the bond gap will slow the rate of cure.

**SHELF LIFE AND STORAGE:**

12 months at 25 °C

Refrigerated storage is recommended to maximize shelf life.

If stored refrigerated, allow the adhesive to gradually warm prior to use.

Avoid heat, direct sunlight and high moisture areas when storing.

Do not return unused adhesive to the original container and do not refrigerate open containers.