

Instructions for using ergo.® cyanoacrylate adhesives

General

ergo.® cyanoacrylate adhesives are one-component products containing esters of cyanoacrylic acid that cure in the presence of moisture. ergo.® cyanoacrylates are mainly used to bond plastics, elastomers and metals to themselves and with each other.

Curing

ergo.® cyanoacrylate adhesives cure in the presence of moisture, whereby the film of moisture present on the surface is usually sufficient for curing. Relative humidity of 40% to 70% constitutes ideal curing conditions.

If relative humidity is lower – a common occurrence in heated rooms during winter – curing can take much longer.

If curing is delayed or disturbed by factors such as oversized bond gaps, porous or acidic surfaces, ergo.® 5100 Accelerator is recommended. In this case, the accelerator is applied to the porous or the more inactive surface; after evaporation of the solvent, the adhesive can be applied to the other substrate.

To speed up the cure time in open applications (e.g. mesh screens), the accelerator is subsequently sprayed directly onto the adhesive.

Preparation of mating surfaces

To achieve optimum bond strength, remove all traces of oil, grease or other contaminants from the mating surfaces. ergo.® 9195 Cleaner, which is compatible with most materials, can be used to clean surfaces.

Nonetheless, we recommend pre-testing component areas that are not visible. In many cases, the as-delivered surface condition of the components meets requirements.

Again, we recommend as a precaution that the suitability and bond strength of the adhesive is tested for its intended use.

Application

The products are supplied ready for use. They can be applied by hand directly from the container or using the relevant dispensing equipment. Adhesive is generally applied to one side.

Once the product has been applied, the mating surfaces must be quickly assembled and potentially fixed because moisture in the surrounding air or condensing on the mating surfaces starts the curing process.

ergo.® 5150 Primer is designed for use with hard-to-bond, non-polar materials as it greatly improves the wettability of the material.

First, the primer applied (with a brush or sponge or by dipping) and only when it has completely evaporated is the adhesive applied.

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