



TECHNICAL DATA SHEET

THICK GEL CA

P/N 11454, 50545

DESCRIPTION

ICKYSTICKY® THICK GEL CA HOBBY GLUE is specially formulated to work on vertical and inverted surfaces. Bonds porous and non-porous materials.

- NO DRIPS AND NO RUNS
- GEL VISCOSITY
- LARGE GAP FILLING CAPABILITIES
- USE ON VERTICAL OR INVERTED SURFACES
- EXCELLENT SHOCK AND VIBRATION RESISTANCE
- INSTANT BOND
- ACCELERATE CURE SPEED WITH THE USE OF ICKYSTICKY® CA ACTIVATOR (P/N 11155, 21155)



BONDS

ACRYLIC	STEEL	WOOD	FABRIC
PVC	POLYCARBONATE	ALUMINIUM	LATEX
POLYSULFONE	LEATHER	PAPER	ZINC DICHROMATE

BONDING TIMES

Under normal conditions, the surface moisture initiates the curing process. Functional strength developed in a short-time but curing continues for at least 24 hours before full chemical/solvent resistance is developed. The rate of cure will depend on substrate used.

Stainless Steel	5-20 seconds	Aluminium	2-10 seconds
Polycarbonate	10-40 seconds	PVC	2-10 seconds
Neoprene	>5 seconds	Wood	2-10 seconds
ABS	2-10 seconds	Nitrile Rubber	>5 seconds

PHYSICAL PROPERTIES

Liquid

Composition	Surface Insensitive Ethyl Cyanoacrylate
Appearance	Colourless liquid
Viscosity	Gel

Cured Adhesive

Gap Filling	0.75 mm
Tensile Shear Strength	15-26 n/mm ²
Service Temperature Range	-40 to +85 °C
Full Cure	24 hours
Melting Point Temperature	160 to 170 °C

Mechanical Properties

Glass Transition Temperature, ASTM E228, °C	120
Dielectric Strength, ASTM D149, v/mil	625
Coefficient of thermal expansion, ASTM D696, K ⁻¹	80 x 10 ⁻⁶
Coefficient of thermal conductivity, ASTM C177, W.m ⁻¹ K ⁻¹	0.1

Shear Strength ASTM D 1002/DIN 53283

Wood	25-27 N/mm ²
Etched Aluminium	18-28 N/mm ²
Neoprene Rubber	10-18 N/mm ²
PVC	3-9 N/mm ²
Etched Aluminium	11-19 N/mm ²
Polycarbonate	5-20 N/mm ²

APPLICATION INSTRUCTIONS

- All surfaces must be clean, dry, dust and grease free. Best result will be achieved with surfaces that have been lightly abraded immediately prior to bonding.
- If using accelerator apply to one component surface only. Apply thin film of adhesive to the other surface and bring the pieces together immediately. Hold for few seconds without disturbing the joints.

DIRECTIONS FOR USE

DIRECTIONS: TEST ON SCRAP MATERIAL BEFORE USE.

1. Ensure parts are clean and dry. Best results will be achieved with surfaces that have been slightly abraded prior to bonding.
2. Protect clothing and work surfaces. Use in a well-ventilated area. Carefully open bottle while keeping bottle pointed away from face.
3. Apply glue to one surface. Assemble parts and hold together with pressure for 10-30 seconds or until set.
4. If using with ICKYSTICKY® CA ACTIVATOR (P/N 11155, 21155) apply to one surface only and apply a thin film of adhesive to the other surface. Bring pieces together immediately. Hold for a few seconds without disturbing joints.
5. After use wipe top of nozzle to remove any excess glue before recapping bottle securely.
6. STORE UPRIGHT IN A COOL AREA AWAY FROM SUNLIGHT OR HEAT SOURCES.

NOTE: Not for use with Teflon, polyethylene, polypropylene, certain silicone rubber types, glass, rear view mirrors or parts that are subjected to great shock or continuous immersion in water.

CAUTION

EYE IRRITANT. BONDS SKIN & EYES IN SECONDS. Contains ethyl cyanoacrylate. Use with adequate ventilation. Avoid contact with clothing as can cause burn. In case of eye contact, flush with water for 15 minutes; get medical attention for eye or internal contact. To remove from skin, soak in acetone (nail polish remover) and gently peel adhesive off with fingernail; water exposure will wear off residual adhesive in a few days (do not use polish remover around eye area). KEEP OUT OF REACH OF CHILDREN.



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21 Hobart Street Riverstone NSW 2765 PH: +61 2 9627 7125

www.ickysticky.com.au



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