



TECHNICAL DATA SHEET

THICK CA

P/N 13999, 13416, 50416, 13426, 13423

DESCRIPTION

ICKYSTICKY® THICK CA HOBBY GLUE is a high viscosity, maximum gap filling formula. This is a very slow curing formula.

- MAXIMUM GAP FILLING FORMULA
- HIGH VISCOSITY
- SLOW CURE, ALLOW APPROXIMATELY 30 TO 40 SECONDS FOR PART POSITIONING
- FULL CURE IN 60 SECONDS OR LESS
- ACCELERATE CURE SPEED WITH THE USE OF ICKYSTICKY® CA ACTIVATOR (P/N 11155, 21155)
- SPECIALLY FORMULATED TO BOND VARIOUS PLASTICS, METALS AND ELASTOMERS
- ROUGH OR IRREGULAR SURFACES
- MEETS MIL-A-46050C TYPE II CLASS II



BONDS

| | | | |
|---------|-----------|---------------|-----------------|
| CERAMIC | ALUMINIUM | POLYCARBONATE | FORMING FILLETS |
| RUBBER | LATEX | ACRYLIC | MOST PLASTICS |
| WOOD | METAL | LAMINATE | PVC |

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.

| | | | |
|---------------|---------------|----------------|---------------|
| Steel | 25-35 seconds | ABS | 10-30 seconds |
| Polycarbonate | 15-50 seconds | PVC | 10-30 seconds |
| Neoprene | < 5 seconds | Phenolics | 10-15 seconds |
| Aluminium | 10-20 seconds | Nitrile Rubber | 5 – 7 seconds |

PHYSICAL PROPERTIES

Liquid

| | |
|-------------|--------------------------------|
| Composition | Ethyl Cyanoacrylate Adhesive |
| Appearance | Colourless liquid |
| Viscosity | 1500 cps @ 25°C Brookfield LVF |

Cured Adhesive

| | |
|---------------------------|-------------------------|
| Gap Filling | 0.45 mm |
| Tensile Shear Strength | 15-22 n/mm ² |
| Service Temperature Range | -60 to +80 °C |
| Full Cure | 24 hours |
| Melting Point Temperature | 160 to 170 °C |

Mechanical Properties

| | |
|---|-----------------------|
| Glass Transition Temperature, ASTM E228, °C | 125 |
| Dielectric Strength, ASTM D149, v/mil | 625 |
| Coefficient of thermal expansion, ASTM D696, K ⁻¹ | 90 x 10 ⁻⁶ |
| Coefficient of thermal conductivity, ASTM C177, W.m ⁻¹ K ⁻¹ | 0.1 |

Shear Strength ASTM D 1002/DIN 53283

| | |
|-----------------|-------------------------|
| Neoprene Rubber | 10-15 N/mm ² |
| PVC | 6-9 N/mm ² |
| Acrylic | 10-15 N/mm ² |
| Polycarbonate | 5-10 N/mm ² |
| ABS | 8-14 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.
- Thin bond lines favour high cure speed. Increasing the bond gap will slow down the rate of cure.

DIRECTIONS FOR USE

TEST ON SCRAP MATERIAL BEFORE USE

1. Ensure parts are clean and dry.
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 30- 40 seconds or until set.
4. After use wipe top of nozzle to remove any excess glue before recapping bottle securely.
5. 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 & 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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