



# TECHNICAL DATA SHEET

## THIN FOAM SAFE CA P/N 13996, 13408, 50408, 13427

### DESCRIPTION

ICKYSTICKY® THIN FOAM SAFE CA HOBBY GLUE is a very low viscosity cyanoacrylate adhesive with low odour and low-blooming characteristics. This technology offers excellent product performance and ease of processing. Eliminates the need for ventilation and reduces frosted residues in critical cosmetic bonding. Can be used in conjunction with ICKYSTICKY® FOAM SAFE ACTIVATOR to speed up curing.

- LOW ODOUR
- LOW VISCOSITY
- LOW BLOOM
- SUITABLE FOR MOST FOAMS AND PLASTICS
- BONDING APPLICATIONS WHERE VENTILATION IS A PROBLEM
- ACCELERATE CURE SPEED WITH THE USE OF ICKYSTICKY® FOAM SAFE ACTIVATOR
- IDEAL FOR CRITICAL COSMETIC BONDING
- USE FOR A WIDE RANGE OF INDUSTRIAL AND CONSUMER APPLICATIONS



### BONDS

FOAM BOARD	XPS FOAM	EPS FOAM	CELL FOAM
ALUMINIUM	FIBREGLASS	CARBON FIBRE	BALSA WOOD
METAL	CERAMIC	ACRYLIC	WOOD
POLYSTYRENE	PVC	LATEX	POLYSTYRENE
POLYIMIDE	PEEK	PETG	POLYCARBONATE

### 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	30-70 seconds	ABS	20-60 seconds
Polycarbonate	20-60 seconds	PVC	20-50 seconds
Neoprene	< 5 seconds	Phenolics	30-60 seconds
Nitrile Rubber	5 – 7 seconds	Aluminium	5-20 seconds

### PHYSICAL PROPERTIES

#### Liquid

Composition	Alkoxy-Ethyl Cyanoacrylate Adhesive
Appearance	Colour less liquid
Viscosity	3-5 cps @ 25°C Brookfield LVF

#### Cured Adhesive

Gap Filling	0.05 mm
Tensile Shear Strength	15-26 n/mm <sup>2</sup>
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	150
Dielectric Strength, ASTM D149, v/mil	625
Coefficient of thermal expansion, ASTM D696, K <sup>-1</sup>	90 x 10 <sup>-6</sup>
Coefficient of thermal conductivity, ASTM C177, W.m <sup>-1</sup> K <sup>-1</sup>	0.1

## **Shear Strength ASTM D 1002/DIN 53283**

Grit Blasted Steel	14-22 N/mm <sup>2</sup>
Neoprene Rubber	10-15 N/mm <sup>2</sup>
PVC	3-9 N/mm <sup>2</sup>
Etched Aluminium	10-15 N/mm <sup>2</sup>
Polycarbonate	5-10 N/mm <sup>2</sup>

## **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 and allow to **dry completely**. If the activator is wet when placed together with the CA it will create too much heat and melt the foam. 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. If using with ICKYSTICKY® FOAM SAFE ACTIVATOR apply a thin coating to one surface only and allow to dry completely. If the activator is wet when placed together with the CA it will create too much heat and melt the foam. Apply a thin film of adhesive to the other surface. Bring pieces together immediately. Hold for a few seconds without disturbing the joints.
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 & 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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