

## CL50

### PRODUCT DESCRIPTION

CL-50 is a medium viscosity, low-odour alkoxy-ethyl cyanoacrylate adhesive. CL-50 has low volatility compared to standard grades, which means that the white deposit known as blooming or chlorosis can be virtually eliminated. Its low odour can also improve worker comfort in production areas where ventilation is limited.

### TYPICAL APPLICATIONS

CL-50 is formulated for general purpose bonding of most plastics, rubbers and other common substrates. Recommended for use on close-fitting parts and fairly smooth, even surfaces it will not attack many low density foams such as expanded polystyrene, allowing the use of cyanoacrylate to bond these substrates.

### PROPERTIES OF MATERIAL

		Value
Chemical type		Alkoxy Ethyl
Appearance		Clear Liquid
Specific Gravity		1.06
Viscosity <sup>1</sup>	cPs	45-60
Typical Value	cPs	50
Tensile Strength <sup>2</sup>	(M Pa)	
- after 3 minutes		4 -11
- after 24 hours		9 - 21
Fixture Time <sup>3</sup>	(secs)	10-60
Full Cure	(hours)	24
Flash Point	(°C)	> 85
Shelf Life @ 5°C	(months)	6
Max Gap Fill	(mm)	0.10
Temperature Range	(°C)	
	Continuous	-50 to +70

<sup>1</sup> Cone and Plate Rheometer, controlled stress

<sup>2</sup> ISO 6922

<sup>3</sup> Depending on substrates and application conditions

### CURING PERFORMANCE

#### Typical Speed:

Steel/steel (Degreased)	<40 seconds
ABS/ABS	<15 seconds
Nitrile Rubber/Rubber	<10 seconds
Balsa wood	< 5 seconds

#### Cure speed vs. substrate

The speed of cure of cyanoacrylates varies according to the substrates to be bonded. Acidic surfaces such as leather and paper have longer cure times than most plastics and rubbers. Some plastics such as polyethylene, polypropylene and PTFE require the use of AC77 Primer (see LA-77 TDS for further info).

#### Cure speed vs. bond gap

Chemence cyanoacrylates give best results on close fitting parts. The product should be applied in a very thin line in order to ensure rapid polymerisation and a strong bond. Excessive bond gaps will result in slower cure speeds.

#### Cure speed vs. activator

Chemence Activators LA-11 and LA-12 may be used in conjunction with Chemence cyanoacrylates where cure speed needs to be accelerated. Cure speeds of less than 2 seconds can be obtained with most Chemence cyanoacrylates. The use of an activator can reduce the final bond strength by up to 30% - Chemence recommends testing on the parts to measure the effect.

#### Cure speed vs. environmental conditions

Cyanoacrylate adhesives require surface moisture on the substrates in order to initiate the curing mechanism. The speed of cure is reduced in low humidity conditions. Low temperatures will also reduce cure speed. All figures relating to cure speed are tested at 21°C.

### ENVIRONMENTAL RESISTANCE

#### Hot strength

Chemence alkoxy-cyanoacrylate adhesives are suitable for use at temperatures up to 70°C. At 70°C the bond will be approximately 70% of the strength at 21°C. The bond strength at 80°C is approximately 50% of full strength at 21°C.

#### Heat ageing

Chemence cyanoacrylates retain over 90% of their strength when heated to 70°C for 90 days and then tested at 21°C. Heating the bond to 80°C and then testing at 21°C gives bond strength of approximately 50% of initial strength.

#### Chemical / Solvent Resistance

Chemence cyanoacrylates exhibit excellent chemical resistance to most oils and solvents including motor oil, leaded petrol, ethanol, propanol and freon. Cyanoacrylates are not resistant to high levels of moisture or humidity over time.

### REMOVAL OF CURED CYANOACRYLATE

Cured cyanoacrylate may be removed from most substrates, and parts disassembled, with Chemence LA-68 Debonder. It is not possible to fully remove cyanoacrylate from fabrics.

### GENERAL INFORMATION

For safe handling of this product consult the Material Safety Data Sheet.



TECHNICAL

**DIRECTIONS FOR USE**

Bond speed is very fast so ensure that parts are properly aligned before bonding.

Chemence Activators may be required if there are gaps or porous surfaces. Some plastics may require application of Chemence LA-77 Primer.

Ensure parts are clean, dry and free from oil and grease.

Product is normally hand applied from the bottle. Apply sparingly to one surface and press parts firmly together until handling strength is achieved. As a general rule, as little cyanoacrylate as possible should be used – over application will result in slow cure speed and lower bond strength.

Please contact your Chemence representative for further advice on dispensing solutions.

**PRESENTATION**

Bottles: ..... 20g, 50g and 500g.  
Available in bulk for use with dispensing systems.

**STORAGE**

Store in a cool area out of direct sunlight. Refrigeration to 5°C gives optimum storage stability.

**DATA RANGES**

The data contained in this data sheet may be reported as typical value and/or range. Values are based on actual test data and are verified on a regular basis.

**NOTES**

The information contained herein is produced in good faith and is believed to be reliable but is for guidance only. Chemence Ltd. and its agents cannot assume liability or responsibility for results obtained in the use of its product by persons whose methods are outside or beyond our control. It is the user's responsibility to determine the suitability of any of the products and methods of use or preparation prior to use mentioned in our literature and furthermore the user's responsibility to observe and adapt such precautions as may be advisable for the protection of personnel and property in the handling and use of any of our products.