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Technical Data Sheet Cybercryl 1326

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 "The Power of Adhesive Information"™

Product Description

Cybercryl 1326 is a medium viscosity, fast curing adhesive for bonding metals, magnets or ferrites, ceramics, and glass. Cybercryl 1326 can be heat cured at temperatures of 200°F in less than ½ hour to total cure, fixtures in minutes with heated parts. Fixture speeds can be greatly increased with the use of Cybercryl 1094 Activator.

Heat Cure

Cure at 200 °F for ½ hour bond-line temperature, higher temperatures will produce faster cures.

Storage

Product should be stored in a cool dry place out of direct sunlight. Shelf life can be extended by refrigeration.

Physical Properties

Liquid

Base Compound	Modified Acrylic
Appearance	Amber Liquid
Viscosity (cP @ 68°F)	12,000 cP
Flash Point (COC)	>200°F
Shelf Life @40°F	6 months unopened
Odor	Pungent
Toxicity	Low to moderate, See msds
Specific Gravity	1.08 (20/20°C)

Solid

Shore D Hardness	65-70
Tensile Shear Strength	>3500 psi on aluminum
Thermal Service Range	-65°F to 325°F
Solvent Resistance	Very Good
Elongation	25%

Electrical Properties

Volume Resistivity	>1 x10 ¹⁴ ohm-cm
Surface Resistivity	>2 x10 ¹³ ohm-cm
Dielectric Strength	>450 volts per mil

General Instructions

Apply adhesive as a bead or in drops to ensure enough material is applied for filling the bond-line with a small amount of squeeze out. Apply Activator to the other mating bonding surface in a thin film using the applicator brush or with another applicator. Assemble the parts and fixture with light clamp pressure for a minimum of 10 seconds where good contact of parts is evident. Larger gaps will take longer to fixture and reach full cure strength. For gaps over 0.020", use Activator on both parts and apply adhesive over one activator primed surface, being careful not to touch adhesive applicator to the other primed surface.

For safe handling information on this product, consult the Material Safety Data Sheet, (MSDS)

NOTE

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