



2245

2245 is an opaque, medium viscosity, rubber-toughened ethyl cyanoacrylate adhesive. It provides superior shock and thermal resistance when bonding rubbers, metals, and plastics in harsh environments, and shows excellent strength and flexibility on a variety of substrates.

| | |
|---------------------------|---------------|
| Technology / Base | Ethyl |
| Type of Product | Cyanoacrylate |
| Components | One Component |
| Curing | Humidity |
| Appearance / Color | Clear |
| Consistency | Liquid |

Technical Data

| Rheology | Value | Condition/Method |
|---|----------------------------|------------------|
| Viscosity | 550 +/- 50 cPs | |
| Density | | |
| Specific Gravity | 1.06 | |
| Uncured Material Characteristics | | |
| Flash Point | 85°C (185°F) | |
| Set Time | Steel 30 - 90 sec | |
| | ABS 7 - 13 sec | |
| | EPDM 7 - 13 sec | |
| Shelf Life | 9 mo | |
| Cured Material Characteristics | | |
| Full Cure Time | 24 hours | |
| Cure Appearance | Clear | |
| Service Temperature | -55 to 130°C | |
| RoHS Compliant | yes | |
| Cured Mechanical Properties | See Graphs and Table Below | |

General Instructions

Surfaces to be bonded should be clean and dry. Dispense a drop or drops to one surface only. Apply only enough to leave a thin film layer after compression. Press parts together and hold firmly for a few seconds. Good contact is essential. An adequate bond develops in less than one minute and maximum strength is attained in 24 hours. Wipe off excess adhesive from the top of the container and recap. products if left uncapped may deteriorate by contamination from moisture in the air. Because products cure by polymerization, whitening may appear on the surface of the container or the bonded materials. This will not affect adhesive performance.

Curing Performance

Ambient surface moisture initiates the curing process. Handling strength is reached in a short time, and will vary based on environmental conditions, bond line gap, and other factors. Product will continue to cure for at least 24 hours before full strength and solvent resistance is developed.

Storage

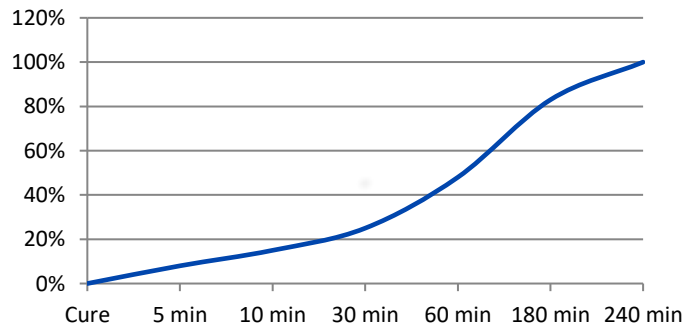
Containers should be stored in a cool, dry, dark area. Storage temperature 15.5°C - 25°C (60°F - 77°F), without exposure to direct light or heat. Do not refrigerate.

Specifications and Approvals

10993-5

A-A-3097, Type II Class 3

Time Until Full Cure (% of RT strength)

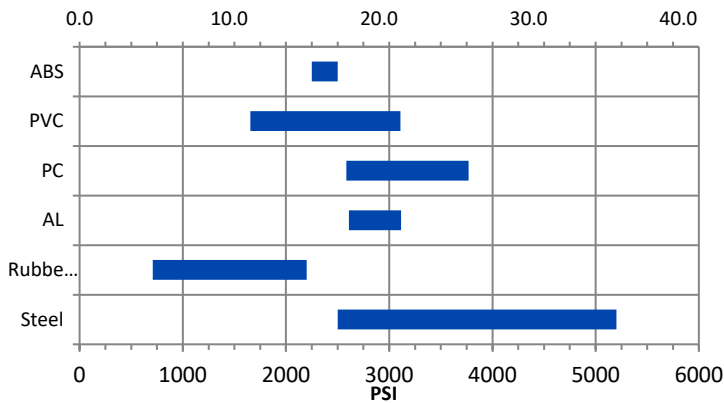


Safety & Disposal

For safe handling information and disposal instructions on this product, consult the Safety Data Sheet (SDS)



Performance Range by Substrate (N/mm²)



Performance of Cured Adhesive

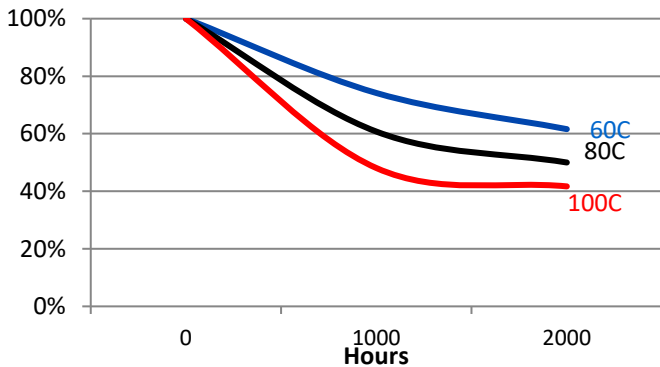
| Substrate | N/mm ² | | PSI | |
|-----------|-------------------|---------|------|---------|
| Steel | 17.2 | to 35.9 | 2500 | to 5200 |
| Rubber* | 4.9 | to 15.2 | 710 | to 2200 |
| AL | 18.0 | to 21.5 | 2610 | to 3115 |
| PC** | 17.8 | to 26.0 | 2585 | to 3770 |
| PVC** | 11.4 | to 21.4 | 1655 | to 3110 |
| ABS** | 15.5 | to 17.2 | 2250 | to 2500 |

*Rubber figures given are typical. Your results may vary by specific rubber type.

**Tested to ASTM 4501

***n/r = not recommended

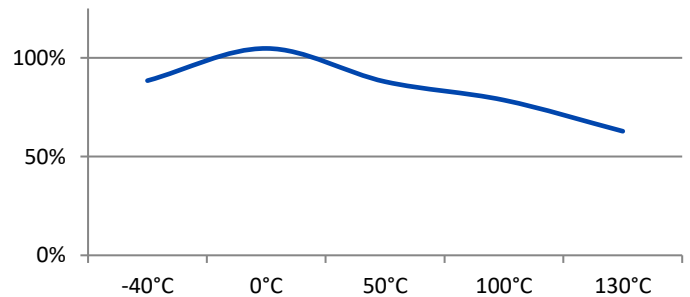
Heat Aging (aged at temp indicated and tested @ 22°C)



Solvent Resistance

| Solvent | Example | Resistance |
|---------------------------------|---|---------------------------|
| Alcohol | Ethanol, Methanol | +++ |
| Ester (aromatic) | Ethylacetate | +++ |
| Ketone (aromatic) | Acetone, Benzophenone | --- |
| Aliphatic hydrocarbon (alkanes) | Petrol, Heptanes, Hexane | ++- |
| Aromatic hydrocarbons | Benzyl, Toluol, Xylol | ++- |
| Halogenated hydrocarbons | Methylenchloride, Chloroform, Chlorobenzol | --- |
| Weak aqueous | Nitrite, muriatic acid, sulphuric acid, phosphoric acid | +++ (--- if concentrated) |
| Weak aqueous base | sodium hydroxide solution, caustic potash | +++ (--- if concentrated) |

Hot Strength (%RT strength, tested at temperature)



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