

TECHNICAL DATA SHEET

My-T-Glue® 760

Low Blooming

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METLOK PRIVATE LIMITED
(An ISO 9001 Certified Company)
W-27, M.I.D.C. Industrial Area
Kalmeshwar – 441 501, Nagpur

Product Description

My-T-Glue® 760 is one component, low odor and low blooming instant bonding adhesive, suitable for bonding applications where appearance of the product/assembly is vital.

Properties

Technology	: Cyanoacrylate
Chemical Type	: Alkoxyethyl cyanoacrylate
Appearance	: Transparent, colorless to pale yellow liquid
Sp. Gravity @ 25 °C	: 1.05
Viscosity @ 25±2 °C, Brookfield, Spindle no. 1, Speed 50 r.p.m. ASTM D1084	: 20 to 50 cP
Secondary Cure	: Activator
Service Temperature	: -50 °C to 120 °C
Key Substrate	Metals, Plastics and Rubbers
Application	: Bonding

Curing Performance

Under normal conditions, the atmospheric moisture initiates the curing process. Although full functional strength is developed in a relatively short time, curing continues for at least 24 hours before full chemical/solvent resistance is developed.

Cure Speed vs. Substrate

The rate of cure will depend on the substrate used. The fixture time achieved on different materials at 25°C /60 % relative humidity is shown below. This is defined as the time to develop shear strength of 0.1 N/mm².

Fixture Time, Seconds

Mild Steel (degreased)	: 20 to 30
Aluminium	: 5 to 20
Neoprene	: <5
Rubber, Nitrile	: <5
ABS	: 15 to 30
PVC	: 15 to 30

Cure Speed vs. Bond Gap

The rate of cure will depend on the bond-line gap. Thin bond lines result in high cure speeds, increasing the bond gap will decrease the rate of cure.

Cure Speed vs. Activator

Where cure speed is unacceptably long due to large gaps, applying activator to the surface will improve cure speed. However, this can reduce ultimate strength of the bond and therefore testing is recommended to confirm effect.

Adhesive Properties of Cured Material

After 24 hours @ 25±2 °C

Lap Shear Strength, ASTM D 1002

Steel	: 13 to 25 N/mm ²
Aluminum	: 9 to 13 N/mm ²
ABS	: 3 to 10 N/mm ²
PVC	: 3 to 10 N/mm ²
Polycarbonate	: 5 to 8 N/mm ²
Phenolic	: 4 to 15 N/mm ²
Neoprene	: 5 to 15 N/mm ²
Nitrile	: 5 to 15 N/mm ²

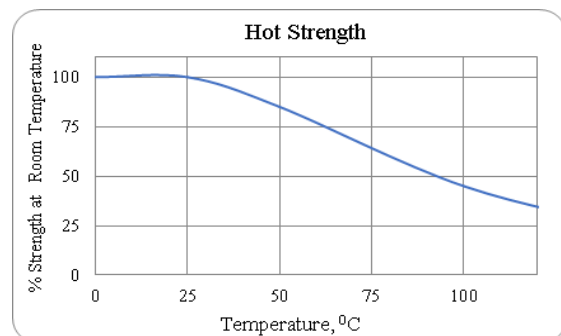
After 24 hours @ 25±2 °C

Tensile Strength, ASTM D 897

Steel	: 10 to 20 N/mm ²
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Hot Strength

Test	: Lap Shear Strength, ASTM D 1002
Substrate	: Steel
Cure	: 24 hrs @ 25±2 °C



Chemical/Solvent Resistance

Test : Lap Shear Strength, ASTM D 1002
Substrate : Steel
Cure : 24 hrs @ 25±2 °C

Aged under condition indicated and tested @ 25±2 °C.

Environment	Temp (°C)	% of Initial Strength
		100 Hrs
Engine oil	40	100
Ethanol	25	100
Isopropanol	25	100
1,1,1-Trichloroethane	40	100

Directions for Use

1. For best performance clean all surfaces with a cleaning solvent and allow to dry
2. The bond surfaces should be clean and free from grease.
3. This product performs best in thin bond gap.
4. Excess adhesive can be clean with cleanup solvents, nitro methane or acetone.
5. Adhesive can be applied using dispensing tips supplied. Once the adhesive is dispensed, the bonded parts should be held in contact until the part has developed handling strength.

Handling

- ❖ For safe handling My-T-Glue® 760 must be handled in a manner as indicated in Material Safety Data Sheet (MSDS) and in compliance with relevant local regulations.
- ❖ My-T-Glue® 760 is not recommended for use in pure oxygen and/or oxygen rich systems and should not be selected as a sealant for chlorine or other strong oxidizing materials
- ❖ Where aqueous washing systems are used to clean the surfaces before bonding, it is important to check for compatibility of the washing solution with the adhesive. In some cases these aqueous washes can affect the cure and performance of the adhesive.
- ❖ My-T-Glue® 760 is non-volatile and non-flammable at room temperature.

Storage

- ❖ Store My-T-Glue® 760 in a cool, dry location in unopened containers at a temperature between 10°C to 20°C unless otherwise labeled. Optimal storage is at the lower half of this temperature range.
- ❖ Store away from sunlight and heat sources.

- ❖ My-T-Glue® 760 will exhibit a shelf life of six months when stored in above mentioned conditions.
- ❖ To prevent contamination of unused product, do not return any material to its original container. For further specific shelf life information, contact our Technical Service center R&D Center.

Pack Size

My-T-Glue® 760 is ideally available in 20 gm and 50 gm pack size.

Note

All statements, technical information and recommendations set forth herein are based on tests which Metlok Private Limited, believes to be reliable. However, Metlok Private Limited does not guarantee their accuracy or completeness. We cannot assume responsibility for the results obtained by others over whose methods we have no control. It is the user's responsibility to determine suitability for the user's purpose of any production methods mentioned herein and to adopt such precautions as may be advisable for the protection of property and of persons against any hazards that may be involved in the handling and use thereof. In no case will Metlok Private Limited be liable for direct, consequential economic or other damages.

METLOK PRIVATE LIMITED

(Bonding and Sealing Solutions)

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