

## DESCRIPTION

The PERMACOL Contact Cement 302FS is a cyanoacrylate adhesive or 'super glue' with a medium viscosity. This product cures through humidity. This adhesive can be used to bond plastics, rubbers, metals, etc.

Technical details	
Basis	Ethylcyanoacrylate
Colour	Transparent
Density	1.06 g/cm <sup>3</sup>
Solid content	100%
Viscosity	80-100 mPa.s at 23°C
Flash point	83°C
Temperature resistance	-40°C up to 95°C
Setting time	45-90 sec
Curing time	16 hrs
Minimum curing temperature	10°C

## Curing recommendations

Use in a well ventilated room. Make sure the substrates are clean and free from dust, water, grease, fingerprints, oil, etc. Metals are to be sanded to remove the oxide layer before cleaning. If the adhesive is stored in a refrigerator or other low temperature storage, allow the adhesive to reach room temperature before usage. Apply a thin layer of adhesive to one part and assemble the parts together immediately, so the adhesive will spread over the parts equally. Setting time is dependent on the humidity and temperature. Don't apply too much adhesive, this will slow down the curing process and reduce the strength of the bond.

## BENEFITS

- Fast settingtime
- Transparent
- Solvent free
- Multi-purpose
- Medium viscosity
- RoHS and REACH compatible

## CLEANING

At room temperature, the remaining uncured adhesive can be removed and cleaned by means of solvents as Ethanol, Acetone, Isopropanol (IPA) or MEK.

Cured adhesives must be removed mechanically. We advise to heat up the adhesive bond over 100°C. At this temperature, the adhesive will become softer and the component can easily be removed using torsion.

## STORAGE

Store in its original packaging. Avoid exposure to high humidity and sunlight. Do not open the package while the adhesive is cold. Remove the adhesive from the fridge at least two hours before use. See packaging for the expiration date. Shelf life: 12 months between 5°C and 10°C.

## SAFETY

This product contains cyanoacrylacidester. Danger: Sticks within few seconds skin and eyelid to eachother. Use protective gloves to avoid direct contact with the skin. Use in a well ventilated room. Use safety glasses to avoid splattering on the eyes. Check the Material Safety Data Sheet for specific safety information.

## PACKAGING

The PERMACOL CA 302FS is available in quantities of 2 and 50 gram.

## Legal Disclaimer

The products of Permacol (the "Supplier"), are sold subject to the supplier's standard conditions of sale, which are included in applicable sales agreements, printed on the back side of invoices, or available upon request. Although the information, recommendations or advice contained herein is given in good faith, supplier makes no warranty or guarantee, express or implied, (I) that the results described herein will be obtained under end-use conditions, or (II) as to the effectiveness or safety of any design incorporating supplier's products, recommendations or advice. Nothing in this or any other document shall alter, vary, supersede or operate as a waiver of any of the supplier's standard conditions of sale.

*Each user bears the full responsibility for making its own determination as to the suitability of Supplier's products, recommendations or advice for its own particular purpose. Each user must identify and perform tests and analyses sufficient to assure it that its finished parts will be safe and suitable for use under end-use conditions. Because actual use of products by the user is beyond the control of Supplier, such use is within the exclusive responsibility of the user, and Supplier cannot be held responsible for any loss incurred through incorrect or faulty use of the products. Further, no statement contained herein concerning a possible or suggested use of any product is intended or should be construed to grant any license under any patent or other intellectual property right of Supplier, or as a recommendation for the use of such material in the infringement of any patent or other intellectual property right.*