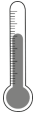




Technical Data Sheet  
Art. No. (9805070917)

# Polycraft 600

High Viscosity Ethyl Cyanoacrylate  
Modified Adhesive

Moisture Cure (Air contact)	5-60 Seconds (At 21°C)	24 Hours (At 21°C)	CLEAR	1500 cps (Typical)	 (21°C)	-50°C To +80°C
Cure Type	Fixture Time	Full Cure	Appearance	Hardness	Working Temperature	Operating Temperature

## Key Features

- High Viscosity
- Air Curing
- Ultra Fast Setting
- Long Shelf life
- Versatile Use
- Can be used to Fill Gaps
- Good Heat Resistant
- Chemical Resistant

Can be used on:

- Cardboard • Metals • Paper
- Plastics (Thermoplastic & Thermoset)
- Rubbers • Wood

## Typical Applications

Polycraft 600 is a high viscosity ethyl cyanoacrylate modified adhesive, suitable for bonding a variety of materials such as cardboard, metals, paper, plastics, rubber, wood.

Capable of bonding many surfaces including many porous surfaces at a fast speed.

Polycraft 600 is also has excellent gap filling capabilities.

## Curing Time

Steel / Steel	<60 Seconds
ABS / ABS	<20 Seconds
Rubber / Rubber	<15 Seconds
Wood (Balsa)	<3 Seconds

(Typical Speed)

## Curing Speed Note

Polycraft adhesives require surface moisture to initiate the cure. Cure speeds are reduced in low humidity.

Low temperatures will also reduce cure speed.

## Technical Overview

Properties	Unit	Value
Appearance		Clear
Specific Gravity	(sg)	1.08
Viscosity (cPs)	(brookfield)	
- Range		1275-1650
- Typical Value		1500
Tensile Strength	(n/mm2)	21
Fixture Time	(Seconds)	5-60
Full Cure	(Hours)	24
Flash Point	(°c)	>85
Shelf Life @5°C	(Months)	12
Max Gap Fill	(mm)	0.2
Operating Temperature Range	(°c)	-50 To +80

## Key Information

### Curing Substrates

The speed of cure will vary according to the substrates to be bonded. Acidic surfaces such as paper or leather will have a longer curing time than most plastics or rubbers. Low surface energy plastics such as polyethylene / polypropylene require a promoter to aid adhesion.

### Gap Filling

Polycraft adhesives give best results on close fit parts. Applied in a thin line to ensure rapid polymerisation and a strong bond. Excessive sized gaps will result in a slower cure speed. Polycraft CA700 / CA800 activator sprays may be used to greatly increase the cure speeds.

### Activators

Polycraft CA700 / CA800 activator sprays can be used in conjunction with the Polycraft 600 for accelerated cure speeds. Speeds of less than 2 seconds can be obtained. Bond strength may be reduced by up to 30% when activators are used.

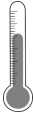
(Continued on page 2)



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### Key Information

#### Heat Resistance

Polycraft adhesives are suitable for use at temperatures upto 80°C. At 80°C the bond will be approximately 70% of the strength compared to that at 21°C, bond strength at 100°C is approximately 50%

#### Chemical Resistance

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

#### Storage

Store in a cool area and out of direct sunlight. Refrigeration to 5°C gives optimum storage stability. (Not suitable for storage in a fridge were foodstuffs are stored)

#### Usage

- Bond speed is ultra fast so ensure parts are properly aligned before bonding.
- Activators usually required for gap filling or porous surfaces.
- Ensure parts are clean, dry and free of oil and grease as bond is likely to fail.
- Hand applied from bottle, apply sparingly to one surface and press parts firmly together until handling strength is achieved.
- Rule of thumb : use as little as possible, over use will delay cure speed and lower bond strength.

#### Safety Precautions

Safety First! Goggles, gloves and appropriate mask whilst working in a well ventilated area is highly recommended. Always read the SDS before use.