



IA 609 CYANOACRYLATE ADHESIVE

DESCRIPTION

IA 609 is one-component, low viscosity curing ethyl-cyanoacrylate adhesive.

TYPICAL APPLICATION

IA 609 was developed to be non-sensitive to surface. It bonds very quickly and the bond strength is excellent. It can be used on wide range of materials including different massive and foam rubber. **IA 609** can be used to bond difficult to bond Elastomers, e.g. APTK and EPDM and also the low energy plastics or polypropylene.

This product has optimal wetting characteristics and extremely quick initial curing.

Using **IA 609** the bonds are very resistant to climatic factors and also to most of elastomer additives.

ADVANTAGES

- non sensitive to surface
- low viscosity (optimal wetting characteristics)
- extremely fast curing (tacking time is minimized)
- compatible with low energy plastics (it bonds polypropylene, polyethylene).

APPLICATION METHODS

STANDARD APPLICATION :

- make sure the bonded surfaces are clean, degreased, dust-free and free of dirt.
- to obtain better results use the cleaner **S 1950, AC 100** .
- screw off the cap and cut off the top of the tip with sharp knife. Be careful to use the knife at a distance. Fasten appropriate dosing tip (Information regarding the tips you find in IA TDS - Cyanoacrylate Dosing Tips).
- press the bottle softly, apply small quantity of adhesive on one of the surface. One drop bonds about 25 mm² of surface.
- immediately bring two parts together and hold firmly.
- handling strength is achieved within few seconds and it alters depending of the surface used.
- Full Cure Time will be achieved approximately after 6 hours.



REDUCING THE TIME OF CURING:

Before application :

- to reduce the handling time the assortment of IA cyanoacrylates activators can be used together with the adhesive as follows.
- Apply the chosen activator on one of the surfaces and let it dry for few seconds.
- Apply the adhesive on the other surface and bring parts together holding firmly.

BONDING OF DIFFICULT BONDING SUBSTRATES:

- bonding of polyolefine and other low energy plastics e.g. Polypropylene. IA 609 can be used together with the **IA 841 Polyolefin Primer**

RESIDUAL (ADDITIONAL) APPLICATION :

- alternatively the activator may be applied after both surfaces were bonded.
- apply the activator on both bonded surfaces and let it dry (usually 1 - 2 minutes)
- then apply **IA 609** for bonding.

AUTOMATIC APPLICATION:

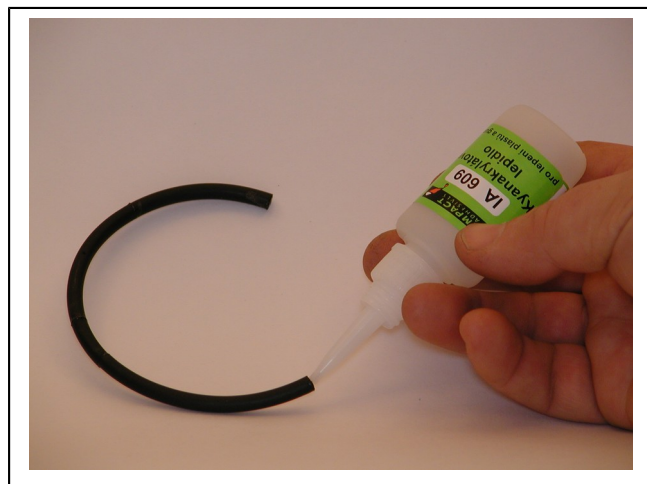
- applying **IA 609** with automatic equipment see the recommendation of the manufacturer of this

equipment and we also recommend to consult the method of application in our technical department. Impact Adhesive provides wide range of application equipments for dosing the cyanoacrylates.



GENERAL CHARACTERISTICS MONOMERIC CYANOACRYLATE

Colour	: colourless
Corrosivity	: none
Flash point	: > 87°C (DIN 53213)
Temperature resistance	: od - 60°C do + 90°C shortly + 120°C
Maximum gap	: up to 0,1 mm
Shelf life	: 12 měsíců (store in cool area : 0°C a + 5 °C)
Specific weight	: 1,05 g/cm ³
Toxicity	: none
Viscosity	: 30 mPas @ 20°C



POLYMER CYANOACRYLATE

Softening temperature	: 165°C
Index of break	: 1,49
Inside resistance	: 5,37 * 10 ¹⁴ Ohm/cm (DIN 53482)
Dielectric constant	: 5,4 @ 1 MHz (DIN 53483)
Dielectric strenght	: 11,6 kv/mm (DIN 52612)
Climate resistance	: 10,5 - 14,5 N/mm ²

Tensile Shear Strenght: 25 - 30 N/mm²

CURING RATE

MATERIAL	HANDLING STRENGHT
Aluminium	300 seconds
Plastics	5 - 15 seconds
EPDM	1 - 2 seconds

PACKAGING

IA 609 is suppllied in bottles a' 20g, 50g, 500g - standard packaging - and according to client's wish it can be supplied also in another packaging.

SHELF LIFE AND STORAGE :

In original packaging and stored in temperature 0°C - 10°C the shelf llife is 6 months. If it is stored in refrigerator in -20°C the shelf life is prolonged to 12 moths. Before using leave the product in room temperature for 24 hours.

HEALTH AND SAFETY : This technical Data Sheet doesn't include the MSDS. Before using this product read carefully the MSDS of the product IA 609. The Specified values are average and do not represent specifications.

Supplier



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