BLACK RUBBER TOUGHENED ADHESIVE
PART NO. 143336

PHYSICAL PROPERTIES

MONOMER (Liquid)
- Base Compound: Ethyl Cyanoacrylate
- Appearance: Black Liquid
- Viscosity (cps @ 68°F): 2400 cP
- Specific Gravity (g/cc): 1.06
- Flash Point (TCC): 185°F

Shelf Life @ 60°F: 6mths in unopened containers
Military Specifications: Mil-A-46050C Type II, Class 2

Setting Time: (68°F, 65%R.H.)
- Steel: 40 to 70 seconds
- Aluminum: 30 to 60 seconds
- Neoprene: 25 to 50 seconds
- ABS: 30 to 60 seconds
- Polycarbonate: 50 to 90 seconds
- PVC: 25 to 50 seconds

POLYMER (Cured)
- Appearance: Black Solid
- Service Temperature Range: -65°F to 250°F
- Softening Point: 329°F
- Refractive Index (ND 20): 1.49
- Full Cure Time: 24 Hours
- Dielectric Strength KV/mm: 11.6
- Dielectric Constant @ 1Kc: 5.4
- Coefficient of Thermal Expansion (in./in./F): .000126
- Tensile Strength (Steel/Steel): 3700 psi
- Solubility: Nitromethane, Acetone, Dimethylformamide

DESCRIPTION
Dynatex® Rubber Toughened Adhesive is a black high-viscosity, rubber-toughened ethyl cyanoacrylate adhesive. Provides superior shock and thermal resistance when bonding rubbers, metals and plastics in harsh environments.

FEATURES
- Ready to use
- No mixing
- Permanent bond
- Fills gaps to .004"
- Holding strength to 5000 psi

TYPICAL APPLICATIONS
- Automotive trim
- Minor interior repairs
- Knobs
- Logos
- Household repairs and more...

CURING PERFORMANCE
The gap of the bond line will affect set speed. Smaller gaps tend to increase the speed. Activators can be applied to improve set speed but may also impair overall adhesive performance.

Packaging
- Colors: Black
- Size: 20g Bottle Carded
CURING PROPERTIES
Ambient surface moisture will initiate the hardening process. Handling strength is reached in a short period of time and varies depending on environmental conditions and substrates being bonded. Product will continue to cure for at least 24 hours before full strength and resistances are developed.

PERFORMANCE OF CURED MATERIALS
Tensile shear strength, cured for 48 hours
@ 20-25°C (68-77°F)

<table>
<thead>
<tr>
<th>Substrate</th>
<th>Range in N/mm²</th>
</tr>
</thead>
<tbody>
<tr>
<td>Blasted Steel</td>
<td>20 to 28</td>
</tr>
<tr>
<td>Etched Aluminum</td>
<td>14 to 23</td>
</tr>
<tr>
<td>Neoprene</td>
<td>&gt;10</td>
</tr>
<tr>
<td>ABS</td>
<td>&gt;6</td>
</tr>
<tr>
<td>Polycarbonate</td>
<td>&gt;5</td>
</tr>
<tr>
<td>PVC</td>
<td>&gt;6</td>
</tr>
</tbody>
</table>

STORAGE AND SHELF LIFE
When stored in the original unopened containers at or below 90°F (32°C), Dynatex® Rubber Toughened Adhesive has a shelf life of 12 months from date of shipment.

In Countries where high heat and humidity are a factor, special precautions must be taken. Store product in a covered, well-ventilated warehouse and avoid excessive heat conditions. Storage in high heat, high humidity conditions may reduce shelf life by up to 30%. Rotation of stock is an absolute necessity. Cartons should always be stacked upright. DO NOT stack cartons on their side. NEVER stack cartons more than 8 high. DO NOT store within 1 meter (4 feet) of roofline of the warehouse or storage building.

USERS PLEASE READ
The information and data contained herein is believed to be accurate and reliable; however, it is the user’s responsibility to determine suitability of use. Since the supplier cannot know all the uses, or the conditions of use to which these products may be exposed, no warranties concerning the fitness or suitability for a particular use or purpose are made.

It is the user’s responsibility to thoroughly test any proposed use of our products and independently conclude satisfactory performance in the application. Likewise, if the application, product specifications or manner in which our products are used requires government approval or clearance, it is the sole responsibility of the user to obtain sure authorization.

Non-warranty: Because the storage, handling and application of the material is beyond Dynatex control, we can accept no liability for the results obtained. Dynatex sole limited warranty is the product meets the manufacturing specifications in effect at time of shipment. There is no warranty of merchantability or fitness for use, nor any other express or implied warranty. Dynatex will not be liable for incidental or consequential damages of any kind. The exclusive remedy for breach of such limited warranty is a refund of purchase price or replacement of any product shown to be other than as warranted.

Suggestions of uses should not be taken as inducements to infringe any patents.

CHEMICAL RESISTANCE
Sheer strength on steel after 12-month soak

% Strength Retained

<table>
<thead>
<tr>
<th>Substance</th>
<th>% Strength Retained</th>
</tr>
</thead>
<tbody>
<tr>
<td>Motor Oil</td>
<td>100</td>
</tr>
<tr>
<td>Gasoline</td>
<td>100</td>
</tr>
<tr>
<td>Trichloroethane</td>
<td>100</td>
</tr>
<tr>
<td>Freon TA</td>
<td>100</td>
</tr>
<tr>
<td>10% NaOH</td>
<td>0</td>
</tr>
<tr>
<td>10% HCl</td>
<td>0</td>
</tr>
<tr>
<td>Water</td>
<td>0</td>
</tr>
</tbody>
</table>

DIRECTIONS FOR USE
1. Make sure the surfaces to be bonded are clean and dry.
2. Dispense a drop or drops to one surface only. Apply only enough to leave a thin film after compression.
3. Press parts together and hold firmly for a few seconds. Good contact is essential. An adequate bond develops in less than one minute. (Maximum strength is achieved in 24 to 48 hours.
4. Wipe off excess adhesive from the top of the container and recap. Dynatex® Rubber Toughened Adhesive, if left uncapped, may deteriorate by contamination from moisture in the air.
5. Because Dynatex® Rubber Toughened Adhesive condenses by polymerization, sometimes whitening will occur on the surface of the container or the bonded materials. Should this happen, wipe surfaces well with acetone.