

**TECHNICAL DATA SHEET FOR PROCURE PC06**

**TYPICAL APPLICATIONS**

PC 06 is specially formulated for the bonding of plastics, rubbers, wood, metals and other common substrates.

Recommended for use on close-fitting parts and smooth, even surfaces.

**PROPERTIES OF UNCURED MATERIAL**

Chemical type	Ethyl
Appearance	Clear
Specific Gravity	1.06
Viscosity cPs <sup>1</sup>	
– range	34-44
– typical value	40
Tensile Strength <sup>2</sup>	(N/mm <sup>2</sup> ) 21
Fixture Time	(secs) 2-20
Full Cure	(hours) 24
Flash Point	(°C) > 85
Shelf Life @ 5°C	(months) 12
Max Gap Fill	(mm) 0.10
Operating Temperature Range (°C)	-50 to +80
<sup>1</sup> ISO 3104/3105	
<sup>2</sup> ISO 6922	

**PRODUCT DESCRIPTION**

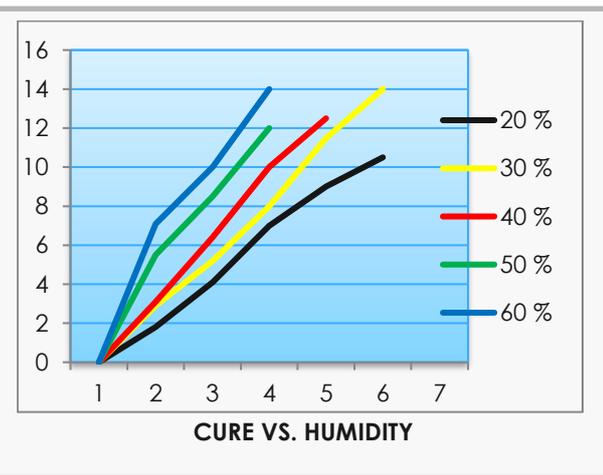
PC 06 is a low-medium viscosity (40cPs) modified Ethyl Cyanoacrylate adhesive.

PC 06 is suitable for bonding a very wide range of materials, including some porous ones, where very fast cure speed is required.

**TYPICAL CURING PERFORMANCE**

Typical Speed:

Steel/steel	<15 seconds
ABS/ABS	<10 seconds
Rubber/Rubber	<5 seconds
Wood (balsa)	<3 seconds



**CURE SPEEDS VS. ENVIRONMENTAL CONDITIONS**

Cyanoacrylates require surface moisture on the substrates in order to initiate the curing mechanism. The speed of cure is reduced in low-humidity conditions. Low temperatures will also reduce cure speed. All figures relating to cure speed are tested at 21°C.

**CURE SPEED VS. SUBSTRATE**

The speed of cure of cyanoacrylates varies according to the substrates to be bonded. Acidic surfaces such as paper and leather will have longer cure times than most plastics and rubbers. Some plastics with very low surface energies, such as polyethylene, polypropylene and Teflon® require the use of Procure 77 Primer (See PC 77 TDS for further info).

**CURE SPEED VS. ACTIVATOR**

Activators 780 and 750 may be used in conjunction with cyanoacrylates where cure speed needs to be accelerated.

Cure speeds of less than 2 seconds can be obtained with most cyanoacrylates.

The use of an activator can reduce the final bond strength by up to 10% testing on the parts to measure the effect is recommended.

**CURE SPEED VS. BOND GAP**

PROCURE / REACT cyanoacrylates give best results on close fitting parts. The product should be applied in a very thin line in order to ensure rapid polymerisation and a strong bond. Excessive bond gaps will result in slower cure speeds. PROCURE / REACT cyanoacrylate activators may be used to greatly increase cure speeds (see PC780 and PC750 TDS for further info).

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### TYPICAL ENVIRONMENTAL RESISTANCE HOT STRENGTH

PROCURE / REACT cyanoacrylates are suitable for use at temperatures up to 80°C. At 80°C the bond will be approximately 70% of the strength at 21°C. The bond strength at 100°C is approximately 50% of full strength at 21°C.

### CHEMICAL / SOLVENT RESISTANCE

Cyanoacrylates exhibit excellent chemical resistance to most oils and solvents including motor oil, leaded petrol, ethanol, propanol and freon.

Cyanoacrylates are **not** resistant to high levels of moisture or humidity over time.

### STORAGE

Store in a cool area and out of direct sunlight. Refrigeration to 5° C gives optimum storage stability.

### REMOVAL OF CURED CYANOACRYLATE

Cured cyanoacrylate may be removed from most substrates, and parts disassembled, with a debonder.

**It is not possible to fully remove cyanoacrylate from fabrics**

### PRESENTATION

Cyanoacrylates are supplied in 20g, 50g, 500g and bulk packs

### DIRECTIONS FOR USE

Bond speed is very fast so ensure that parts are properly aligned before bonding.

Activators may be required if there are gaps or porous surfaces. Some plastics may require application of a primer.

Ensure parts are clean, dry and free from oil and grease.

Product is normally hand applied from the bottle. Apply sparingly to one surface and press parts firmly together until handling strength is achieved. As a general rule, as little cyanoacrylate as possible should be used – over application will result in slow cure speed and lower bond strength.

Please contact your representative for further advice on dispensing solutions.

### GENERAL INFORMATION

For safe handling of this product consult the Material Safety Data Sheet.

### NOTES AND DISCLAIMER

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#### CYANOTECH LTD

Bay 2, Building 62, Third Avenue, Pensnett Trading Estate, Kingswinford DY6 7XT  
TEL 0845 618 3120 FAX 0845 618 3121 EMAIL sales@cyanotec.com

**PC 06**  
**V1.4**  
**MAY 19**