



Z396

Z 396 is a single component, low to medium viscosity ethyl cyanoacrylate adhesive. It is designed as a slow-setting formulation suited specifically to rubber to metal bonding.

Technology / Base	Modified Ethyl
Type of Product	Cyanoacrylate
Components	One Component
Curing	Humidity
Appearance / Color	Clear
Consistency	Wicking Liquid

Technical Data		
Rheology	Value	Condition/Method
Viscosity	110 +/- 15 cPs	Brookfield SC4-27, 20°C to 25°C (68°F to 77°F)
Density		
Specific Gravity	1.06	
Uncured Material Characteristics		
Flash Point	85°C (185°F)	
Set Time	Steel ABS EPDM	25 sec n/a 15 sec
Shelf Life		12 mo
Cured Material Characteristics		
Full Cure Time		24 hours
Cure Appearance		Clear
Service Temperature		-55 to 130°C
RoHS Compliant		yes
Cured Mechanical Properties	See Graphs and Table Below	

General Instructions

Surfaces to be bonded should be clean and dry. Dispense a drop or drops to one surface only. Apply only enough to leave a thin film layer after compression. Press parts together and hold firmly for a few seconds. Good contact is essential. An adequate bond develops in less than one minute and maximum strength is attained in 24 hours. Wipe off excess adhesive from the top of the container and recap. Products if left uncapped may deteriorate by contamination from moisture in the air. Because products cure by polymerization, whitening may appear on the surface of the container or the bonded materials. This will not affect adhesive performance.

Curing Performance

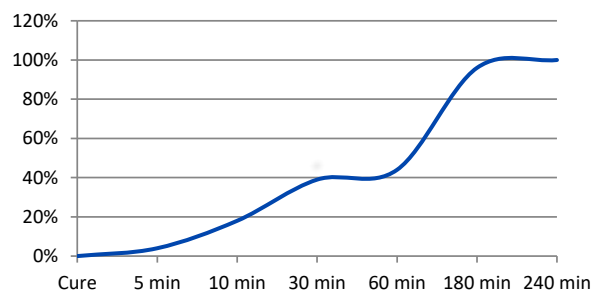
Ambient surface moisture initiates the curing process. Handling strength is reached in a short time, and will vary based on environmental conditions, bond line gap, and other factors. Product will continue to cure for at least 24 hours before full strength and solvent resistance is developed.

Storage

Containers should be stored in a cool, dry, dark area. Storage temperature 15.5°C - 25°C (60°F - 77°F), without exposure to direct light or heat. Do not refrigerate.

Specifications and Approvals

Time Until Full Cure (% of RT strength)

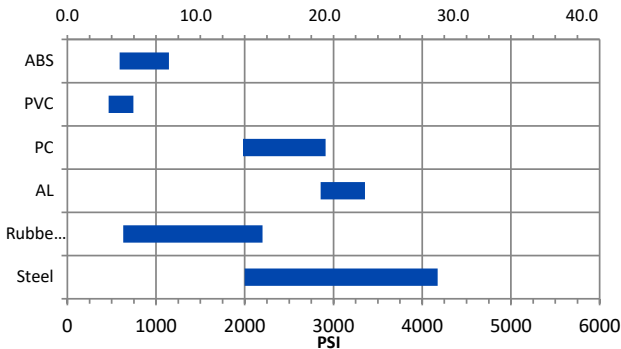


Safety & Disposal

For safe handling information and disposal instructions on this product, consult the Safety Data Sheet (SDS)



Performance Range by Substrate (N/mm²)



Performance of Cured Adhesive

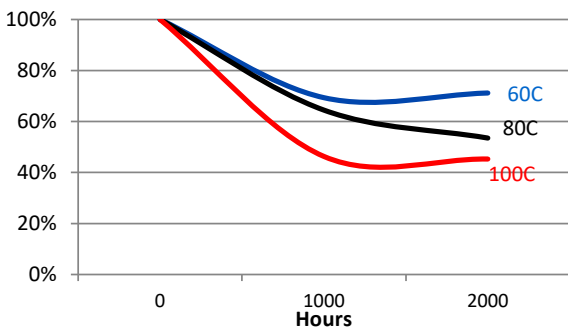
Substrate	N/mm ²	PSI
Steel	13.8 to 28.8	2000 to 4174
Rubber*	4.3 to 15.2	630 to 2200
AL	19.7 to 23.1	2855 to 3355
PC**	13.7 to 20.1	1980 to 2910
PVC**	3.2 to 5.1	465 to 745
ABS**	4.1 to 7.9	590 to 1145

*Rubber figures given are typical. Your results may vary by specific rubber type.

**Tested to ASTM 4501

***n/r = not recommended

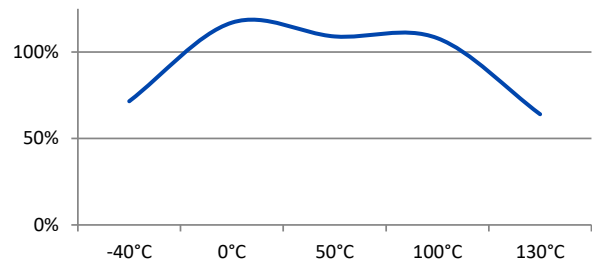
Heat Aging (aged at temp indicated and tested @ 22°C)



Solvent Resistance

Solvent	Example	Resistance
Alcohol	Ethanol, Methanol	+++
Ester (aromatic)	Ethylacetate	+++
Ketone (aromat	Acetone, Benzophenone	---
Aliphatic hydrocarbon	Petrol, Heptanes, Hexane	+-
Aromatic hydrocarbons	Benzyl, Toluol, Xylol	+-
Halogenated hydrocarbons	Methylenchloride, Chloroform, Chlorobenzol	---
Weak aqueous	Nitrite, muriatic acid, sulphuric acid, phosphoric acid	+++ (--- if concentrated)
Weak aqueous base	sodium hydroxide solution, caustic potash	+++ (--- if concentrated)

Hot Strength (%RT strength, tested at temperature)



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