



## TECHNICAL DATA

# CIANOKOL

## Cyanoacrylate adhesive

### DESCRIPTION

CIANOKOL adhesives are one-component colourless and solvent free cyanoacrylate based adhesives. They cure in seconds at room temperature by catalytic effect of atmospheric humidity.

### FIELDS OF APPLICATION

CIANOKOL adhesives are used for bonding porous and unporous materials. They are also good substitute for joining by soldering or welding specially if materials are sensitive to higher temperatures. They are also used for fixing materials and gluing metals, plastics, elastomers etc.

Cyanoacrylate adhesives are used for various house repairing, in electrical and automotive industries, in instrument manufacture and also in production of toys, sports equipment, souvenirs etc.

### CHARACTERISTICS

CIANOKOL	P80K	P81	P82	P83	G61	PRO	EXACT	UNI	GEL
Chemical base	Ethyl cyanoacrylate								
Viscosity in mPas at 23°C (ISO 2555-Brookfield RVT)	≈ 30 - 50	≈ 30 - 150	≈ 1000 - 2000	≈ 150 - 250	≈ 20 - 45	≈ 30 - 50	≈ 30 - 150	≈ 30 - 150	GEL
Setting time at 23°C and 50% RAH; ICM 4/12 (sec)	2-7	3-10	2-10	2-7	2-10	2-7	3-10	3-10	up to 30
Materials									
Metals	X	X	X	X	X	X	X	X	X
Plastics	XX	XX	XX	XX	X	XX	XX	XX	XX
Rubber, leather	XX	X	X	X	XX	XX	XX	XX	X
Ceramics	X		XX			X	X	X	XX
Wood, cork	X		XX			X	X	X	XX
Water and temperature resistant joint according to EN 204 D4	YES	/	/	/	/	YES	/	YES	/
Temp. resistance from -40°C to +95°C	YES	/	/	/	/	YES	/	/	/

XX – main use, X – possible use

Cianokol adhesives are not suitable for gluing polyethylene, polypropylene, Teflon, EPS (Styropor), XPS (Styrodur), silicone and glass.

### APPLICATION

Surfaces must be well prepared before gluing. Metals must be clean, without traces of fat, dust or rust. Therefore must be treated by brushing, cleaning with solvents or chemical processes. Plastic and rubber surfaces must be free of silicon separators, therefore must be clean with solvent (acetone, alcohol or petrol). Cianokol is applied in small drops to one of the surfaces to be join together. The parts must be placed and fixed immediately. The setting time depend on gluing material and is 10 to 130 seconds. The final setting process is completed after 12 hours. Adhesive cures by reaction with humidity, therefore is setting time depend on relative air humidity and on moisture content in gluing materials.

**Optimum working conditions:**

Temperature of room and all materials involved	20-25°C
Relative air humidity	40-60%

Where is required to separated bonded joint this is best achieved by immersion in acetone or ethyl acetate or by heating at the temperatures up to 200°C.

**PACKING**

Type of the adhesive	CIANOKOL P80K, P81, P82, P83, G61		CIANOKOL PRO	CIANOKOL EXACT	CIANOKOL UNI, GEL
Packing	20g	500g	<b>20g</b>	<b>10g</b>	3g
Description of packing	PE plastic bottle+nozzle	PE plastic bottle	PE plastic bottle+nozzle on blister	PE plastic bottle+nozzle on blister	Al tube on blister
Commercial packing (pcs)	25 pcs	/	20 pcs	8 pcs	12 pcs
Transport packing	/	20 x 500g	/	10x8 pcs=80pcs	10x12 pcs = 120 pcs

**STORAGE**

CIANOKOL has to be stored in dry, dark and cool at temperatures between 2°C to 8°C. Before application adhesive should be warmed on room temperature.

The shelf life of the original packed adhesives at room temperature:

CIANOKOL UNI, GEL, EXACT	18 months,
CIANOKOL PRO	12 months,
CIANOKOL P80K, P81, P82, P83, G61 in 500g packing	6 months,
CIANOKOL P80K, P81, P82, P83, G61 in 20g packing	9 months.

Storing at lower temperatures prolonged shelf life of adhesive. We suggest that once open packing is used as soon as possible.

The information provided herein, especially recommendations for the usage and application of our products, is based on our knowledge, results of laboratory tests and practical experience gained to date.

We guarantee a constant quality of our products under our technical specifications. Technical advice of our application department is available without obligation. This does not release the buyer from testing our products in his own responsibility with respect to their suitability for intended application and application process. Such an evaluation should be repeated if materials are changed in any way or bought from a different source.

We do not accept any liability with regard to above information or with regard to any verbal recommendation since different materials used in conjunction with our products as well as varying working conditions are beyond our control.