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CE-280 is a very fast setting, medium viscosity adhesive designed for bonding all types of rubber-bonding applications, PVC and other plastic compounds. CE-280 produces bonds capable of material failure in seconds.

PHYSICAL PROPERTIES

MONOMER(liquid)

Base compound	Ethyl Cyanoacrylate
Appearance	Colorless liquid
Specific Gravity (g/cc)	1.06
Flash Point(TCC)	185F
Viscosity (cps@68F)	200 cps
Shelf Life @ 40F	One year unopened container

Setting Time(68F, 65% R.H.)

Rubber/Rubber	8 Seconds
Metal/Metal	2-4 Seconds
Plastic/Plastic	2-6 Seconds

Military Specifications

Mil-A-46050C
Type II, Class 2

POLYMER(cured)

Appearance	Colorless Solid
Full Cure Time	24 hours
Softening Point	329F
Refractive Index(ND 20)	1.49
Service Temperature Range	-65F to 250F
Dielectric Strength KV/mm	11.6
Dielectric Constant @ 1 Kc	5.4
Coefficient of Thermal Expansion(in/in/F)	.000126
Tensile strength: Steel/Steel	3200 psi
Solubility	Nitromethane, Acetone Dimethylformamide

BOND STRENGTH

(tensile shear strength, cured for 48 hours at 20-25 degrees C(68-77F))

	N/mm2
Rigid PVC to rigid PVC	^5.39
Natural rubber to natural rubber	^0.71
Polycarbonate to polycarbonate	^11.21
Polystyrene to polystyrene	^4.41
ABS to ABS	^6.37
Neoprene to neoprene (TM Dupont)	^0.71
NBR to NBR	^0.64
SBR to SBR	^0.64
Steel to steel	19.78
Stainless steel to stainless steel	16.80
Aluminum to aluminum	17.99
Copper to copper	15.04
ABS to SBR	^0.69
Stainless steel to neoprene	^0.69
Teak to teak	^17.66
Oak to oak	^13.40
Teak to Aluminum	^13.66

^=substrate failure

CURE SPEED (seconds)

Natural rubber to natural rubber	1-2	Steel to steel	5-10
Polystyrene to polystyrene	5-10	Aluminum to alum	7-14
ABS to ABS	3-5	copper to copper	2-4
Rigid PVC to Rigid PVC	3-5	ABS to SBR	3-5
Neoprene to neoprene (TM Dupont)	1-2	Steel to rigid PVC	5-10
NBR to NBR	1-2	Stainless steel to stainless steel	
SBR to SBR	1-2		7-14

CHEMICAL RESISTANCE (steel to steel ...tensile shear strength)

	Before soak (N/mm2)	After soak (N/mm2)
Water	21.17	0
Motor oil	21.17	21.17
Trichloroethylene	21.17	21.17
Gasoline	21.17	21.17
10% NaOH	21.17	0
10%Hcl	21.17	0

The data, statements and recommendations (shown for information only) are based on tests which are believed to be reliable. Since we have no control over the end use of our product, we cannot guarantee the end results. It is the user's responsibility to determine suitability for the product or of any production methods mentioned herein and to adopt such precautions as may be advisable for the protection of property and of persons against any hazards that may be involved in the handling and use thereof.