

Superglue No.250 black



Cyanoacrylate Adhesive for special requirements rubber-filled, high viscosity high temperature resistant

Superglue No.250 black is highly viscous (2000-3000 mPa•s) and temperature resistant between -50°C (-58°F) and +140°C (+284°F). It hardens slowly and with residual elasticity, is rubber-filled and black, and has high peel and impact strength.

Thanks to its curing with residual elasticity, Superglue No.250 black is particularly suitable under changing climatic conditions. It is insensitive even under a longer influence of humidity. It is best suited for the bonding of diverse rubber materials such as solid rubber or cellular rubber, plastics and metal/plastic joints.

Superglue No.250 black can be used in various fields of industry.

Technical Data

Ester type	Ethyl
Composition	black
Viscosity at +20°C (+68°F) according to Brookfield	2.000 - 3.000 mPa•s
Max. Gap Bridging	0,2 mm
Initial strength on aluminium	90 -120 sec.
Initial strength on NBR-Rubber	20 -40 sec.
Initial strength on hard PVC	40 -80 sec.
Final strength approx. after	24 h
Shear strength according to DIN 53283 on	
Sand-blasted Steel	24 N/mm ²
Sand-blasted Aluminium	18 N/mm ²
Rigid PVC	13 N/mm ²
ABS	12 N/mm ²
PC	13 N/mm ²
NBR	> 8 N/mm ²
Temperature resistance	-55 to +140 / squatting temp. +160 °C

Surface pre-treatment

To ensure a perfect bonding, the surfaces to be joined must be clean and dry. Smooth surfaces should be mechanically roughened.

Processing

- Apply Superglues only on one of the surfaces to be bonded. The bond line should be between 0.05 mm and max. 0.2 mm (acc. to type) in thickness. Otherwise complete hardening cannot be guaranteed.

- For bonding large surfaces Superglues should be applied drop by drop to avoid inner tensions.

- Superglues are very economical. One drop is sufficient to cover approx. 3 - 5 cm² of bonded surface.

- The parts to be joined should be bonded in an atmosphere of 40 - 80 % relative humidity. In conditions of below 40%, the cure will be considerably slowed or even inhibited. With a relative air humidity of more than 80% or with basic substrates (e.g. glass), shock-curing can occur. In such cases, some materials show a drop in bond strength of 10 - 15 %, due to inner tensions in the bond line.

- Basic-reacting surfaces (pH-value smaller 7) will speed up the cure whereas acidic-reacting surfaces will retard and, under extreme conditions, completely inhibit the polymerization.

Storage

Superglues can be stored in the unopened original container for at least 9 months at room temperature (+ 18°C to + 25°C). Keep away from moisture and direct sunlight. At temperatures of about + 5°C, the shelf life can be extended up to 12 months.

Safety and health

When using products, the physical, safety technical, toxicological and ecological data and regulations in our EC safety data sheets must be observed.

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