



Product Model High Viscosity Superglue

PC 16 is a high viscosity modified Ethyl Cyanoacrylate adhesive. PC 16 is suitable for bonding a very wide range of materials, including many porous ones, where a fast cure speed is required.

Typical Curing Performance / Typical Speed

Steel/steel	60 seconds
ABS/ABS	20 seconds
Rubber/Rubber	15 seconds
Wood (balsa)	3 seconds

Typical Applications

PC 16 is specially formulated for the bonding of plastics, rubbers, wood, paper, cardboard, leather, metals and other common substrates. PC 16 relies less on surface moisture for cure speed than standard cyanoacrylates. PC 16 has excellent gap-filling capability.

Chemical type	Ethyl
Appearance	Clear
Specific Gravity	1.08
Viscosity cPs¹	
· Range	1275-1650
· Typical value	1500
Tensile Strength² (N/mm²)	21
Fixture Time (secs)	5-60
Full Cure (hours)	24
Flash Point (°C)	> 85
Shelf Life @ 5°C (months)	12
Max Gap Fill (mm)	0.20
Operating Temperature Range (°C)	-50 to +80

¹ Brookfield LVF, spindle 3, 30rpm, ² ISO 6922

Technical data
supplied by the
manufacturer



Cure speed 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 30% Testing on the parts to measure the effect is recommended.

Solutions, Service and Supplies to the Trade

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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).

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 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.

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.

Presentation

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

General Information

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

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

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Typical Applications

“On demand” curing of Procure Cyanoacrylate. Especially suitable on slower high viscosity grades. Can be used to “fillet cure” adhesive Procure Cyanoacrylate and cure adhesive outside the Joint.

Directions for Use

PC780 should be applied to the area to be bonded by spraying. Wait for the solvent carrier to evaporate (normally 10-30 seconds). Apply the appropriate Procure cyanoacrylate grade to the part to be bonded and assemble. PC780 has an on-part life of approximately 1 hour, if parts are not assembled within 1 hour, PC780 should be re-applied. Alternatively assemble parts using Procure cyanoacrylate then spray the exposed bond joint with PC780 to cure the adhesive instantly. The speed of cure with activator will depend on the substrates being bonded and the adhesive grade. May cause discoloration if used excessively.

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Product Model Superglue Activator

PC780 is a solvent-based activator formulated to increase the cure speed of Procure Cyanoacrylate adhesives. It is designed for the bonding of Upvc plastics where “yellowing” can be a consideration.

Physical Properties of Liquid Adhesive

Chemical type	Organic solvent base
Appearance	Clear
Specific gravity	(@ 25°C) 0.7
Viscosity cPs.	1
Flash point	(°C)<15 (highly flammable)
Shelf life @ 20°C	12 Months

Technical data
supplied by the
manufacturer



Benefits

- Low risk of staining on UPVC plastic
- Cures off Procure Cyanoacrylate in adverse conditions
- Sets cure off in seconds

General Information

For safe handling of this product consult the Material Safety Data Sheet. Procure activators are formulated for use in conjunction with Procure adhesives.

Storage

Store in a cool dry area out of direct sunlight.

Packaging

Available in 200ml aerosol.