



TECHNICAL DATA SHEET
TDS #: M 60
CYANOACRYLATE ADHESIVE
 REVISED: DECEMBER/2010

ADVANCE PERFORMANCE SERIES
M 60 CYANOACRYLATE ADHESIVE
 METAL BONDING

DESCRIPTION:

M 60 is a low viscosity, methyl based cyanoacrylate adhesive. It is designed to bond a wide range of similar and dissimilar materials involving metal. Handling strength in most applications is in 5 to 10 seconds.

PHYSICAL PROPERTIES:

Color: Opaque/Slight Amber
 Viscosity: 60 cps
 Specific Gravity: 1.07
 Base: Methyl

PERFORMANCE PROPERTIES:

Substrate	Fixture Time	Bond Strength
Steel	< 20 Seconds	> 2100 psi
Aluminum	< 15 Seconds	> 1750 psi
Neoprene	< 5 Seconds	> 750 psi
ABS	< 15 Seconds	> 900 psi
PVC	< 10 Seconds	> 900 psi
Polycarbonate	< 20 Seconds	> 900 psi
Phenolic	< 15 Seconds	> 850 psi

NOTE: Method used, ISO 4587.

Tensile Strength:

Steel: > 1800 psi
 NOTE: Method used, ISO 6922

ELECTRICAL PROPERTIES:

Dielectric Constant ASTM D 150 Dissipation Factor
 1 kHz 2 to 3.50/ < 0.02

Volume Resistivity ASTM D 257: 2×10^{15} to 10×10^{15}

FACTORS AFFECTING CURE SPEED:

GAP: Thin bond line results in faster cure speed. Larger gaps will lengthen cure speed.

HUMIDITY: Cure and fixture times can be influenced by the humidity conditions at the time of assembly. The higher the RH the faster cure and fixture times will be. Fixture time data based on our testing is conducted at 50% relative humidity.

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What we bond:

ABS	NBR
Acrylic	Neoprene
Aluminum	Nitrile
Bakelite	Nylon
Brass	Phenolic
Chloroprene	Polycarbonate
Chrome	Polyester
Cooper	Polystyrene
EPDM	Porcelain
Fiberglass	PVC
Latex	SBR
Leather	Steel
Natural Rubber	Valox
	Wood

CHEMICAL/SOLVENT RESISTANCE:

% OF STRENGTH RETAINED AFTER AGING FOR 500 HOURS	
GASOLINE @ 22°C:	100%
ISOPROPANOL @ 22°C:	100%
ETHANOL @ 22°C:	100%
FREON TA @ 22°C%:	100%
MOTOR OIL @ 40°C%:	100%
POLYCARBONATE 40°C @ 95% RH	100%

DIRECTIONS FOR USE:

For optimum results parts should be clean and free from any contamination on the bonding surface. If parts do not mate flush together use a higher viscosity product to compensate for the gap. Any excess adhesive can be removed using Remove Debonder.

STORAGE:

Store product in unopened containers, out of direct sunlight, in a dry location. Material should be stored at or below 22°C. For extended shelf life unopened containers of the product may be refrigerated. Shelf life is two years provided product is stored properly.

Engineering Excellence

For technical information and support call 1-800-552-0299 or visit our website at

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