



IA 610



EXTREMELY STRONG, CURES QUICKLY, SURFACE INSENSITIVE CYANOACRYLATE ADHESIVE

DESCRIPTION

IA 610 HIGH TECH Impact Adhesive is one-component cyanoacrylate adhesive with low viscosity, curing modified ethyl.

TYPICAL APPLICATION

IA 610 was developed to bond special plastics, which are difficult to bond with common cyanoacrylates. It bonds very quickly and the bond strength is excellent. It can be used on wide range of materials including different massive and foam rubber (**NITRILE rubbers**, **NEOPRENE rubbers** and „**natural rubbers**“ **bonds in 1-2 seconds and the bonds are stronger than the material being bonded !!**).

IA 610 can be used on **Elastomers**, which are difficult to bond, e.g. **APTK and EPDM, ETP, EVA, ABS, soft PVC, Polyacetaty** (all bond in 1-2 seconds, and the bonds are stronger than the material being bonded !!), bonding low energy plastics or polypropylene it is necessary to test if the effect would not be better using primer **IA 701**, for more information contact the technical department of **HF Market** tel. **00420 377 279 251**.

Slower cures of up to 12 seconds are found on **Polymethyl Methacrylate (PMMA), Bakelite, Polycarbonate and VITON rubber**.

Metal such as **Aluminium, Copper and Brass** all bond in under 5 seconds and the bond strengths are superior to other manufacturers low viscosity products - up to **30N/mm² 0,1mm**.

This product has optimal wetting characteristics and extremely quick initial curing.

Using **IA 610** the bonds are very resistant to climatic factors and also to most of elastomer additives.

USING MOLECULAR PRIMER IA 701 IT IS POSSIBLE TO BOND

- ✚ **Silicone rubber**
- ✚ **PTFE (TEFLON)**
- ✚ **HDPE/LDPE plastics**
- ✚ **Bonds many other difficult to bond materials, which cannot be bonded using common cyanoacrylates !**

ADVANTAGES

- „**Bonds everything else other cyanoacrylates CANNOT**“
- **EXTREMELY STRENGTH 25-30N/mm²**
- **Spreading rate 5 000mm²**
- non sensitive to surface
- low viscosity(optimal wetting characteristics)
- extremely fast curing (minimize the time of tack)
- compatible with low energy plastics (bonds polypropylene, polyethylene, silicone, TEFLON, tec.)

APPLICATIONS METHODS

- make sure the bonded surfaces are clean, degreased, dust-free and free of dirt.
- to obtain better results use the cleaner **S 1950, AC 100**.
- screw off the cap and you can bond straight, be careful to bond at a distance. Fasten appropriate dosing tip (Information regarding the tips you find in **IA TDS - Cyanoacrylate Dosing Tips**).
- **press the bottle softly, apply small quantity of adhesive on one of the surface. One drop bonds about 25 mm² of surface.**
- **Bottle 20g contains about 200 drops , this quantity is enough for the area of 5 000mm² !!!**
- immediately bring two parts together and hold firmly.
- handling strength is achieved within few seconds and it alters depending of the surface used.
- Full Cure Time will be achieved approximately after 6 hour

IA 610 HIGH-TECH CYANOACRYLATE ADHESIVE

REDUCING THE TIME OF CURING:

Befor application :

- To reduce the handling time the assortment of IA cyanoacrylates activators AC 12 can be used together with the adhesive as follows.
- Apply the chosen activator AC 12 on one of the surfaces and let it dry for few seconds.
- Apply the adhesive on the other surface and bring parts together holding firmly.

BONDING OF DIFFICULT BONDING SUBSTRATES:

- bonding of polyolefine and other low energy plastics (e.g. polypropylene) IA 610 can be used together with the **IA 701 Primer**

RESIDUAL (ADDITIONAL) APLICATION :

- alternatively the activator may be applied after both surfaces were bonded.
- apply the activator AC 12 on both bonded surfaces and let it dry (usually 1 - 2 minutes)
- then apply **IA 610** for bonding.

AUTOMATIC APPLICATON:

- applying **IA 610** with automatic equipment see the recomentadion of the manufacturer of this equipment and we also recommend to consult the method of application in our technical department.
- Impact Adhesive provides wide range of application equipments for dosing the cyanoacrylates.

GENERAL CHARACTERISTICS

MONOMERIC CYANOACRYLATE

Colour : colourless
Corrovisity : none
Flash point : > 85°C (DIN 53213)
Temperature resistance : od - 60°C do + 90°C
shortly + 120°C at peak time up to + 140°C

Maximum gap : up to 0,1 mm

Shelf life : 12 měsíků
(store in cool area : 0°C a + 5 °C)

Specific veight : 1,06 g/cm³

Toxicity : none

Viscosity : 20 mPas @ 20°C

POLYMER CYANOACRYLATE

Softening temperature : 165°C

Index of break : 1,49

Inside resistance : 5,37 * 10¹⁴ Ohm/cm (DIN 53482)

Dielectric constant : 5,4 @ 1 MHz (DIN 53483)

Dielectric strenght : 11,6 kv/mm (DIN 52612)

Climate resistance : 10,5 - 14,5 N/mm²

Tensile Shear Strenght: 25 - 30 N/mm²

CURING RATE

MATERIAL HANDLING STRENGHT

Metals <5 seconds

Plastics <2 seconds

Rubbers <4 seconds

PACKAGING

IA 610 is supllied in bottles a' 20g, 50g, 500g - standard **STRENGHT GRADE** according to client's wish it can be supplied also in another packaging. MATERIAL RESULT

SHELF LIFE AND STORAGE : In original packaging and standard **Metals** temperature 0°C - 10°C shelf life is 12 months. Before using leave the product in room temperature for 12 hours. **Plastics** **substrate destroyed**

HEALTH AND SAFETY : This technical Data Sheet doesn't include the MSDS. Before using this product read carefully the MSDS of the product **IA 610**. The Specified values are average and do not represent specifications. **Rubbers** **substrate destroyed**

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