

RX – Surface Insensitive Cyanoacrylates

Pacer Technology RX Series Range Extended cyanoacrylate adhesives are a family of non-surface sensitive adhesives for porous, acidic, contaminated, or hard-to-bond substrates, such as certain plastics and plated surfaces. Viscosities range from water-thin to a non-running gel to fit a variety of application requirements.

Liquid State	RX-5	RX-50	RX-100	RX-500	RX-700	RX GEL
Base Chemical	-----Ethyl Hybrid Cyanoacrylate-----					
Color	-----Translucent Liquid-----					
Viscosity, cP	2-5	30-70	80-120	400-600	600-800	45-85000
Flashpoint, F (C)	185 (85)	185 (85)	185 (85)	185 (85)	185 (85)	185 (85)
Vapor Pressure, mmHg @70C	8	8	8	8	8	8
Specific Gravity (@25F)	1.05	1.05	1.06	1.06	1.06	1.08
Soluble In:	-----Acetone, MEK, Nitromethane-----					
Cured State	RX-5	RX-50	RX-100	RX-500	RX-700	RX GEL
Temperature Range	-65F to +180F (-54C to +82C)					
Hardness, Rockwell (M)	75	74	74	74	74	74
Typical Gap, inches	.002	.004	.005	.008	.010	.020
Outgassing (@10 ⁻⁶ mmHg, 72F)	0	0	0	0	0	0
Softening Point, F (C)	311 (155)	306 (152)	306 (152)	306 (152)	306 (152)	303 (151)
Melting Point, F (C)	365 (185)	365 (185)	365 (185)	365 (185)	365 (185)	368 (187)
Glass Transition, F (C)	347 (175)	347 (175)	347 (175)	347 (175)	347 (175)	347 (175)
Soluble In:	-----X-9 Debonder, Acetone, Nitromethane-----					
Shear Strength, psi	ASTM D-1002					
Steel	2200 (±10%)	2200(±10%)	2000(±10%)	2200(±10%)	2200(±10%)	2400(±10%)
Aluminum	1600 (±10%)	1600(±10%)	1600(±10%)	1600(±10%)	1600(±10%)	1600(±10%)
Copper	1400 (±10%)	1400(±10%)	1400(±10%)	1400(±10%)	1400(±10%)	1400(±10%)
ABS	SF*	SF*	SF*	SF*	SF*	SF*
Rigid PVC	SF*	SF*	SF*	SF*	SF*	SF*
Nylon	SF*	SF*	SF*	SF*	SF*	SF*
Polycarbonate	SF*	SF*	SF*	SF*	SF*	SF*
SBR	SF*	SF*	SF*	SF*	SF*	SF*
EPDM	SF*	SF*	SF*	SF*	SF*	SF*
Tensile Strength, psi						
Steel (ASTM D-2095)	4000(±10%)	4000(±10%)	4000(±10%)	4000(±10%)	4000(±10%)	4000(±10%)
Dielectric Constant (1MC)	3.98	3.98	3.98	3.98	3.98	3.98
Volume Resistivity (ohm-cm)	8.4x10 ¹²	8.4x10 ¹²	8.4x10 ¹²	8.4x10 ¹²	8.4x10 ¹²	8.4x10 ¹²

* Substrate Failure

APPLICATION AND CURE CHARACTERISTICS

For best results, parts should be clean, free from oil and grease or other contaminants. Apply adhesive to one surface to be bonded and mate the other surface to it carefully and without delay. For best results, use a minimal amount of adhesive. In general, one free-falling drop covers one square inch of bond area. Avoid over-application, as excess adhesive is difficult to remove from unwanted areas. Fixture time occurs in 1-5 minutes with 80% of full strength developing in 15-30 minutes. Fixture time and full cure rates are dependent upon temperature, relative humidity, bondline thickness, and substrates being bonded. To speed full cure through larger gaps, Pacer accelerators for instant adhesives are compatible and can be used. Post application of accelerators to exposed adhesive may cause a white frosting (chlorosis) of the exposed adhesive onto parts, which can usually be removed using Pacer X-9 Debonder and a cotton swab. Overall cure strength can be decreased as a result of using accelerators. Testing on actual parts is recommended.

STORAGE AND SHELF LIFE

Refrigerate unopened cyanoacrylate for optimum results. Once opened, store in a cool, dry location away from heat sources. Stored under these conditions, a one-year shelf life can be expected.

APPROVALS

Pacer will certify compliance for the following:

Specification Compliance	RX-5	RX-50	RX-100	RX-500	RX-700	RX-GEL
MIL-A-46050C (Type/Class)	II/1	II/1	II/2	II/3	II/3	-
A-A-3097 (Commercial Spec)	II/1	II/1	II/2	II/3	II/3	II/5

SAFETY AND HANDLING PRECAUTIONS

Cyanoacrylate adhesives bond skin in seconds. In case of skin contact, flush with water. If skin becomes bonded, peel (do not pull) apart after immersion in warm, soapy water. In case of eye or mouth contact, flush with water and get immediate medical attention. Use with adequate ventilation. Vapors can irritate eyes and mucous membranes. Symptoms disappear after removal of individual from vapors. Avoid contact with clothing as can cause burn. For more information, refer to Material Safety Data Sheet available upon request or from our website at: www.pacertech.com.

In case of emergency, call CHEMTREC at (800) 424-9300 or call Pacer Technology (800) 637-9803 (outside CA only) or (909) 987-0550.

Size	RX-5	RX-50	RX-100	RX-500	RX-700	RX GEL
5 g	FG04055	FG04015	FG04025			FG04075
20 g	FG04050	FG04010	FG04020	FG04040	FG04060	FG04070
1 lb	FG04053	FG04013	FG04023	FG04043	FG04063	
200 g (cartridge)						FG04072
20 kg			FG04026			

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