

**PACER**<sup>®</sup>  
**TECHNOLOGY**

INDUSTRIAL • PRIVATE LABEL



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**CP - Cyanoacrylate for Plated Surfaces**

Pacer Technology CP Series cyanoacrylate adhesive for plated metal surfaces is a high impact resistant product especially formulated for bonding plated surfaces to themselves and other materials. Typical applications include bonding rubber trim to chrome bumpers, lipstick tube components, speaker components, costume jewelry assembly, and bonding name plates to machinery.

<b>LIQUID STATE</b>	CP-100
Base Chemical	Ethyl Hybrid Cyanoacrylate
Color	Yellow, fluorescent liquid
Viscosity, cP	80-120
Flashpoint, °F (COC)	185
Vapor Pressure, mmHg @ 70°C	8
Specific Gravity (@25°C)	1.05
Gap Fill, Typical, inches	.005
Soluble in:	Acetone, MEK, Nitromethane

<b>CURED STATE</b>	CP-100
Tensile Strength, steel (psi)	4500
Impact Strength, (ft.lbs/in <sup>2</sup> )	7-10
Steel, (ASTM D950-54)	
Rockwell Hardness, M	67
Outgassing (@ 10 <sup>-6</sup> mmHg, 72°F)	0
Soluble in:	Pacer X-8 Debonder, Acetone, Nitromethane

Tensile Shear Strength, (psi)	CP-100
Steel	3200 (± 10%)
Chrome Plated Steel	3000 (± 10%)
Aluminum	2000 (± 10%)
ABS	SF*
PVC	SF*
Nylon	SF*

\* SF = Substrate failure (adhesive bond stronger than substrate)

### **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-8 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 @ 40F (4C) for optimum results. Allow adhesive to reach room temperature before opening. Once opened, store in a cool, dry location. Stored under these conditions, a one year shelf life can be expected.

### **SAFETY AND HANDLING PRECAUTIONS:**

Cyanoacrylate adhesives bond skin in seconds. In case of skin contact, flush with water. If skin becomes bonded, peel (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. For more information, refer to Material Safety Data Sheet, available upon request.

In case of emergency, call Pacer Technology at 800-538-3091 (outside CA only), or 909-987-0550.

**PART NUMBER:** FG04324 (1 lb)

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