

TECHNICAL DATA SHEET

Product Description

4W06 is a low-medium viscosity Ethyl Cyanoacrylate adhesive. 4W06 is formulated for high speed, high strength bonding of plastics and rubbers.

4W06 grade adhesive is designed to give superior performance on all types of plastic and rubber substrates when bonding to themselves or to other common substrates.

Typical Application

4W06 is specially formulated for the bonding most common plastics and rubbers, but will also bond other substrates. Recommended for use on close-fitting parts and smooth, even surfaces.

	UNIT	VALUE
Chemical type		Ethyl
Appearance		Clear Liquid
Specific Gravity		1.06
Viscosity ¹	(Range) cPs	34 - 44
	Typical Value cPs	40
Tensile Strength ²		
	After 24 Hours N/mm ²	20
Fixture Time ³	Secs.	3 - 20
Full Cure @ 20°C	Hours	24
Max. Gap Fill	mm	0.10
Flash Point	°C	>85
Shelf Life @ 5°C	Months	12
Temperature Range	°C	-50 to +80

¹ Cone and Plate Rheometer, controlled stress

² ISO 6922

³ Depending on substrates and application conditions

TYPICAL CURING PERFORMANCE

SUBSTRATE	CURE TIME (SECONDS)
Steel/steel (degreased)	<20
Rubber / Rubber	<5
ABS/ABS	<10
Wood (Balsa)	<3

Direction For Use:

Bond speed is very fast so ensure that parts are properly aligned before bonding. Winkel Pro CA Activator may be required if there are gaps or porous surfaces. Some plastics may require application of Winkel Pro CA Primer.

Ensure parts are clean, dry and free from surface corrosion, 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.

Storage:

Store in a cool area out of direct sunlight. Refrigeration to 5° C gives optimum storage stability.

Art. Nr. : Packaging:
20110 20 g

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