



C 2040

INSTANT ADHESIVE FOR RUBBER & PLASTICS

DESCRIPTION

Very rapid bonding cyanoacrylate glue for all materials. It is excellent for gluing rubber and plastics.

PRODUCT BENEFITS

- High-performance gluing.
- Instant adherence.
- Easy-to-use.
- Clean gluing.
- Significant resistance to wrenching.
- Economical: 1 20g bottle can glue up to 4,000 times.
- 1 drop = 1 cm², approx.
- Approved for use in food environments.

APPLICATIONS

- O-rings, window joints, electrical appliances, rubber stoppers, mechanical uses, electronic uses, optical uses, jewellery, watchmaking, plastics processing, domestic appliances, knick-knacks, dishes.
- All materials except Teflon, polyethylene and their derivatives.
- Also glues glass, metals and many other materials.
- PVC pipes.
- Food-related industries.

PHYSICAL PROPERTIES

Colour	Transparent
Density	1.05
Viscosity	20-40 cP
Flash point.....	>85°C
Operating temperature	-60°C to +100°C
Setting time:	
• Plastics, glass, rubber	2 to 5 seconds
• Metals, wood	20 to 40 seconds
• Tensile strength, SBR/SBR	200 daN/cm ² (ASTM D 2095)
• Tensile strength EPDM/EPDM	24 daN/cm ² (ASTM D 2095)
• Resistance to shearing strength, aluminium/aluminium.....	27.5 MPa
• Resistance to shocks.....	15 daN/cm ² (ASTM 950)

APPROVALS

- APPROVED FOOD-SAFE NSF
- P1 – No. 140139



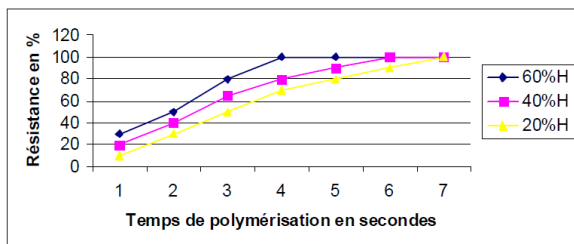
SETTING TIME

Setting time depends on the materials, their surface conditions, the backlash between the parts, and relative humidity. Tests performed at 20°C and 50% relative humidity. The times given are the times after which shearing strength is 0.1 N/mm² (14.5 psi) according to the ASTM D1002 standard.

Comments: Maximum resistance (mechanical and chemical) is obtained after 24 hours of polymerisation. The less the backlash, the faster the adhesion.

ABS.....	5 to 10 seconds
PVC.....	5 to 10 seconds
Glass.....	5 to 15 seconds
Rubber.....	<5 seconds
Neoprene.....	<10 seconds
Steel.....	5 to 15 seconds
Aluminium.....	5 to 15 seconds
Treated surfaces.....	5 to 30 seconds
Wood.....	90 to 120 seconds
Balsa wood.....	5 to 15 seconds
Leather.....	5 to 30 seconds
Fabric.....	5 to 30 seconds
Polycarbonate.....	5 to 40 seconds
Paper.....	5 to 60 seconds

POLYMERISATION SPEED BASED RELATIVE HUMIDITY



PHYSICAL PROPERTIES OF THE POLYMERISED PRODUCT

Linear expansion coefficient, ASTM D696.....	80.10-6 K-1
Thermal conductivity coefficient, ASTM C177.....	0.1 W.m-1.K-1
Glass transition temperature, ASTM E228.....	120°C

ELECTRICAL PROPERTIES OF THE POLYMERISED PRODUCT

Volume Resistivity, ASTMD257.....	1.1016 Ω.cm
Surface resistivity, ASTM C177.....	1. 1016 Ω.cm
Dielectric strength, ASTM D149.....	25 Kv/mm
Dielectric constant and loss at 25°C, ASTM D150.....	C=2.75 and P<0.02 for 0.1, 1 and 10 kHz

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The ORAPI Group designs, manufactures and markets " Highly Technical Solutions" for Maintenance Repair and overhaul of machines and equipments. The Group is present in over 100 countries with 32 subsidiaries and an international network of import-distributors. The Group operates 7 manufacturing plants and 4 laboratories of R&D. ORAPI is certified ISO 9001 and ISO 14001.

MECHANICAL PERFORMANCE AFTER 24 hours

Resistance to shearing strength, ASTM D1002, DIN 5328	
Blasted steel.....	26 N/mm (3800 psi)
Aluminium without oxide	19 N/mm (2800 psi)
Zinc dichromate.....	10 N/mm (1500 psi)
ABS.....	20 N/mm (3000 psi)
PVC.....	20 N/mm (3000 psi)
Polycarbonate	20 N/mm (3000 psi)
Phenolic material.....	15 N/mm (2200 psi)
Neoprene rubber	15 N/mm (2200 psi)
Nitrile rubber.....	15 N/mm (2200 psi)
Tensile strength, ASTM D2095, DIN 5328	
Blasted steel	25 N/mm (3600 psi)
Buna N rubber.....	15 N/mm (2200 psi)

RESISTANCE TO CHEMICAL PRODUCTS, measured after returning to 22°C

Motor oil at 40°C (1000 hours)	95% of initial resistance
Leaded petrol at 22°C (1000 hours)	100% of initial resistance
Ethanol at 22°C (1000 hours)	100% of initial resistance
Isopropanol at 22°C (1000 hours)	100% of initial resistance
Air with 95% RH at 40°C (1000 hours)	40% of initial resistance
Freon TA at 22°C (1000 hours)	100% of initial resistance
Do not allow to come into contact with oxygen.	

RESISTANCE TO HEAT AGING

Aging at the temperature indicated, measured after return to room temperature,

INSTRUCTIONS FOR USE

Ready to use. For optimal polymerisation (or ideal gluing), the humidity in the air must be less than 50% in the area where it is used, and the assembled parts must be clean and dry. **016 - ORAPI NETTOYANT 3141** was specially designed for cleaning surfaces before gluing. To reduce setting time when relative humidity is low or when there is significant backlash between the parts, use **ACTIVATEUR 6140**. This can, however, cause a decrease in mechanical resistance.

To improve mechanical resistance on certain surfaces, use **PRIMAIRE 3440**.

To disconnect assembled parts or clean the materials removed, use **DECOLLEUR 3720**.

PACKAGING

5 g bottle	Ref. O 355 F1	x 12
20 g bottle	Ref. O 355 F2	x 6
50 g bottle	Ref. O 355 F3	x 6
500 g bottle	Ref. O 355 F6	x 1

The data contained in this document is based on average values from testing that is updated periodically.

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