

Product Information:

Super Glue 351

All-round, fast curing, patented application system

General description and applications:

Super Glue 351 is a 1-component fast curing cyanoacrylate adhesive, which due to its versatility is well suited everywhere varied bonding are carried out.

Super Glue 351 is suitable for all minor bonding of metal, rubber, wood, textiles, leather etc.



Physical / chemical properties:

Adhesive:

Type: Ethyl-2-cyanoacrylate
 Colour: Translucent
 Consistency: Thin liquid
 Shelf life: 12 months if stored cool and dry. Must be protected from sunlight. If stored below 5 °C the shelf-life can be increased.

Packaging:

Item no.	Size
8120	5 g bottle (blistered)

Joint:

Temperature resistance: -30 °C to 100 °C when bonding metal.
 -30 °C to 70 °C when bonding plastics and rubber
 Chemical resistance: Good resistance to water, heptane and ethanol.
 Affected by esters, acid and lye and by aliphatic- and chlorinated carbon compounds.
 Generally, however, it is not possible to speak of resistance to solvents (incl. water), as the resistance of cyanoacrylates is highly dependent on temperature and the surface of the materials.



Directions for use:

Preparation:

The surfaces must be clean, dry and free of oil, grease and loose particles. When bonding metals and plastics, a sanding of the surfaces will give the best result. However, usually most plastics only require ordinary cleaning. Make sure the contact between the surfaces is good (max. 0, 2 mm gap). Higher tolerances can be accepted when using Super Glue Gel 359.

It is always recommended to carry out test bonding in order to estimate the strength of the bond.

The bottle is opened by carefully turning the red cap – approx. a quarter of a turn. The adhesive is applied by pressing the bottom button. After application the cap is turned back and the nozzle is cleaned.

Application temperature:

The adhesive must always be used at room temperature.

Humidity of the air:

For optimum bonding the relative humidity of the air must be between 40 and 70 %, and the elements should be conditioned at the same humidity. If the humidity of the air is too high, the strength of the adhesive is reduced, and in some cases a white coating (blooming) will appear around the bonding.

Application:

The adhesive should be applied drop by drop in a thin layer on one side. Too much adhesive causes an imperfect hardening process. A medium drop-size covers approx. 4 – 5 cm².

Pressing time:

Approx. 10 – 60 seconds.

Cyanoacrylate adhesives cures in a reaction with moisture, and curing time therefore depends on humidity of the air, temperature and the substrate. Alkaline surfaces accelerate the curing, whereas acid reacting surfaces slow down or completely stop the curing. If necessary, clean with a weak base before bonding acid surfaces.

F.ex:	Aluminium / aluminium	55 seconds
	SBR / SBR	3 seconds
	EPDM / EPDM	6 seconds

Pressure:

The elements are pressed together immediately without adjusting, and a fast and complete curing will take place.

Dissolving joints:

At temperatures between 200 °C and 250 °C a joint is quickly separated. By soaking the bonded elements in ethyl acetate, a slow dissolving of the joint will take place.

Cleaning:

Before the adhesive is cured it can be removed with acetone. After curing only mechanically by sanding. Cured adhesive will slowly be dissolved if kept in ethyl acetate. If adhesive gets on the skin, rinse with water and soap. If necessary, use pumice stone to remove remnants.

Health and safety:

For further information on safety, refer to product safety data sheet.

The information and data contained in this Product Information sheet are based on extensive laboratory testing and our practical experiences and are meant for helping the user to find optimum working methods. As the conditions at the user are beyond our control, we make no warranties concerning the results, achieved by the products. The information's in this Product Information sheet are typical values, intended as a guideline. They should not be regarded as product specifications. Please also refer to our standard sales conditions and terms of delivery.

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