

low viscosity

Base	2-Methoxyethyl- 2-Cyanoacrylate
Appearance	Transparent, colorless to pale yellow liquid
Viscosity, Brookfield at 25 °C	25 - 55 mPa·s (cP) / 50 rpm
Specific gravity @ 25°C	1,1 g/cm ³
Full cure	24 h
Max. gap filling capacity	0,1 mm
Temperature resistance	-40°C to +100°C
Shelf-life	12 months unopened when stored at 2 - 10 °C

REACH registered

Not included in this product:

Amines, benzene, benzoyl, biocides, bisphenol, DEHP, peanut oil, halogen, latex, Nanoparticles, persistent, perfluorinated surfactants, PFOA, PFOX, phthalates, silicone

Product **ECO 1** is a low blooming and low odor cyanoacrylate adhesive, and it is formulated for the assembly of a variety of plastic, metal and rubbers. It is specially formulated for the assembly of difficult-to-bond materials, and it is particularly suited for bonding porous or absorbent materials such as wood, paper, leather and fabric. It will highly polymerize with moisture in the air for a fast cure and meet the highest industrial standards. **ECO 1** product does not contain solvent, and it is used in demanding applications where very good performance characteristics are required. They include resistance to most types of environmental exposures, moderate heat, aging and many different chemicals, as well as high strength and fatigue resistance.

Description to use:

The parts to be bonded must be clean, oil- and grease free. Give I-QLUE GLUE thinly on one side and pressing parts together. To accelerate the curing, you can use I-QLUE Activator No.9. To accelerate the curing of materials such as PP, PE, Teflon or silicone you can use our I-QLUE Primer 7.

Cure speed (FIXTURE TIME) vs Substrate		TYPICAL PERFORMANCE OF CURED MATERIAL		
The rate of cure will depend on the substrate used. Acidic surfaces such as paper and leather may have longer cure times than most plastics and rubbers. Some plastic with very low surface free energies, such as polyethylene, polypropylene, PTFE and silicone rubber may require the use of a prime. Materials are tested at 25°C/50% RH and fixture time is defined as the time to develop shear strength of 0,12 N/mm² and the strength keeps at least 10 seconds.		Adhesive properties Cured for 72 hours @ 25 °C Lap Shear Strength According to ISO 4587 / ASTM D1002		
Substrate	Fixture Time (s)	Substrate	Strength (N/mm²)	
Pine wood	approx. 20	ABS	9 - 15 *	
Beech wood	approx. 10	Polycarbonate	8 - 10 *	
ABS	approx. 10	Poly(methyl methacrylate)	6 - 11 *	
Polycarbonate	approx. 20	Pine wood	5 - 10 *	
Mild Steel	approx. 5	Mild Steel	9 - 12	
		Beech wood	9 - 11 *	
(*) Substrate failure				
Chemical / Solvent Resistance				
Aged under indicated conditions and tested @ 25 °C				
		% of initial strength		
Environment	°C	100 h	500 h	1000 h
Water	25	80	60	45
Ethanol	25	95	89	88
Isopropanol	25	102	105	101
Water / Glycol	25	95	85	75
Unleaded Gasoline	25	95	91	85
98% Relative Humidity	40	85	78	69



Chemical / Solvent Resistance

Aged under indicated conditions and tested @ 25°C

Lap Shear Strength

According to ISO 4587 / ASTM
D1002 PC (Polycarbonate)

Environment	°C	% of initial strength		
		100 h	500 h	1000 h
Air	25	95 *	99 *	101 *
98% Relative Humidity	40	88	85	80
(*) Substrate failure				
RoHS compliant				
packaging units		item number		
20 bottles à 50 g		SU01.50		
25 bottles à 20 g		SU01.20		