

high viscosity

Base	2-Methoxyethyl- 2-Cyanoacrylate
Appearance	Transparent, colorless to pale yellow liquid
Viscosity, Brookfield at 25 °C	2400 - 2600 mPa·s (cP) / 50 rpm
Specific gravity @ 25°C	1,1 g/cm ³
Full cure	24 h
Max. gap filling capacity	0,35 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 4** 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 4** 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

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.

TYPICAL PERFORMANCE OF CURED MATERIAL

Adhesive properties

Cured for 24 hours @ 22 °C

Lap Shear Strength

According to ISO 4587 / ASTM D1002

Substrate	Fixture Time (s)	Substrate	Strength (N/mm ²)
Pine wood	approx. 35	Polycarbonate	8 - 11 *
Beech wood	approx. 25	Pine wood	9 - 11 *
ABS	approx. 20	Beech wood	11 - 13 *
Polycarbonate	approx. 35	DM fiber wood	3,5 - 4,5 *
Mild Steel	approx. 5	Mild Steel	8 - 12
		PMMA	9 - 11 *

(*) Substrate failure

Chemical / Solvent Resistance

Aged under indicated conditions and tested @ 22 °C

Environment	°C	% of initial strength		
		100 h	500 h	1000 h
Water	22	85	65	60
Ethanol	22	100	96	93
Isopropanol	22	108	104	120
Water / Glycol	22	104	92	97
Unleaded Gasoline	22	105	95	92
98% Relative Humidity	40	86	77	65

Chemical / Solvent Resistance

Aged under indicated conditions and tested @ 22°C

Lap Shear Strength

According to ISO 4587 / ASTM D1002

PC (Polycarbonate)

		% of initial strength		
Environment	°C	100 h	500 h	1000 h
Air	22	110 *	115 *	105 *
98% Relative Humidity	40	88	65	65
(*) Substrate failure				
RoHS compliant				
packaging units		item number		
20 bottles à 50 g		SU04.50		
25 bottles à 20 g		SU04.20		