TECHNICAL DATA SHEET

CYANOCRYLATE ADHESIVES
two-components

HIGH PERFORMANCE
SUPER GLUE GEL 2C

Premium superglue for highest demands. WIKO SUPER GLUE GEL 2C is a gel-type 2-components superglue with a mixing ratio of 4:1. This high-performance superglue serves as a problem solver for ambitious applications on substrates like metals, plastics and wood. There it serves as a gap filling link and also between low energetic and porous substrates. SUPER GLUE GEL 2C is ideal for overhead work and vertical surfaces because of its adjusted viscosity and gel-type texture. In addition, it scores with its shrinkage behavior, technologically typical above-average toughness and mechanical processing capability. SUPER GLUE GEL 2C scores with its speed and few hazard labels compared to other 2-components adhesives.

Technical properties uncured product

Chemical base:	Ethyl-2-cyanoacrylate monomer
Mixing ratio:	4:1
Colour A-component:	clear to cloudy
Colour B-component:	transparent
Colour mixed:	transluscent
Viscosity A- component[1)] [mPas]:	175.000-200.000
Viscosity B-component [mPas]:	20 – 100
Density[2)] [g/ml]:	A-component: 1,05-1,07 B-component: 1,15 – 1,16
Flashpoint[3)] [°C]:	+87
Application temperature [°C]:	optimal at +23

1) At 25 °C, Brookfield viscometer
2) Measured according to DIN 53217, part 2 density sphere model 475/III
3) Measured according to DIN 51755

Cured*

Open time (joined) [min]:	3:00 – 4:00

Fixing time (joined):

Steel [s]:	5-10
Steel (sand blasted) [s]:	10-15
Stainless steel [s]:	15-20
Aluminum [s]:	5-10
Polycarbonate [s]:	10-15
ABS [s]:	20-30
PMMA [s]:	70-90
Pine wood [s]:	30-45
Beech wood [s]:	7-15
Final strength after [h]:	8

Technical properties hardened product

Tensile shear strength[1)] [N/m²]:	14-16
Service temperature range [°C]:	-10 to +40
Temperature range [°C]:	-40 to +100
Gap filling capability [mm]:	0-5 mm
Optimal gap [mm]:	0-2 mm

1) Tested to GLUETEC AA-310

Sizes / article number

11g double-piston syringe (4:1)	SGG2C.S10

Accessories / article number

Mixing nozzle	MXWk100_konisch
SUPER GLUE AKTIVATOR	SGAK
SUPER GLUE PRIMER	SGP
SUPER GLUE REMOVER	SGR

Storage & Durability

The shelf life is, at the optimum storage temperature of +2 °C to +10 °C in the closed original container, a maximum of 9 months. A higher storage temperature leads to a significantly lower durability. The storage temperature must not fall below +2 °C. Protect the product from direct sunlight or heat, frost and humidity.

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Application

Processing instructions:
The surfaces to be bonded should always be free of dust, oil, grease or other contaminants. Always use the WIKO INDUSTRIAL CLEANER (AISR.D400) and a lint-free cleaning cloth to ensure an ideal process. Please also take into account the flash off times of the cleaner used. The adhesive and the substrates to be bonded should have a temperature between +18 ° C and +25 ° C before processing.

Usage oft he 11g double-piston syringe:
Place the double piston, provided separately, into the intended recesses of the syringe-body. Then, remove the frontal sealing cap and press a small amount of the adhesive onto a piece of pulp/cloth until both components run freely. Afterwards, clean the outlet of the cartridge, attach the mixing nozzle (MXWk10O_konisch) and press a small amount of the adhesive through the mixing nozzle onto a piece of pulp/cloth until the material results in a homogeneous mixture. Dispense a sufficient amount of the adhesive onto the adherents and make sure that a maximum gap of 2 mm is reached when grouting. Thicker layers are possible, but require a composite- and application-related testing. Make sure that the adhesive leaks to the sides to ensure a complete filling of the gap. Fixate the bonded parts to prevent them from shifting during the curing process, if necessary. Avoid excessive pressure or premature stress on the parts since that might have a negative effect on the thickness of the adhesive layer and thus on the quality of the bond. In case of doubt, use a spacer and try out the point of stress or contact GLUETEC. The achievement of the functional hardness of the adhesive is influenced by numerous factors like environmental and substrate temperature. Therefore, please note that the parameters mentioned above were determined at standard climate (+23 °C to +25 °C / 50% humidity).

Note:
Please note the information and notes in our respective safety data sheets. The data contained herein are for informational purposes only and are believed to be accurate to the best of our knowledge. We assume no liability for the results. For optimum functionality of the adhesive system, please only use the cartridge and mixer systems tested and released by GLUETEC. The product is only suitable for professional and experienced users. It is the user's own responsibility to take precautions to protect property and people from the hazards that may be encountered in handling and using these products. Accordingly, GLUETEC specifically disclaims any warranty, expressed or implied, including any warranty or suitability commitments for a particular purpose. In particular, GLUETEC disclaims all liability for consequential or indirect damages of any kind.

* according to GLUETEC testing method for cyanoacrylate

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