

CB200 ACRYLIC STRUCTURAL ADHESIVE



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PRODUCT DESCRIPTION

CB200 acrylic structural adhesive is a two part thixotropic paste adhesive which bonds a wide variety of prepared or unprepared metals and engineering plastics. It cures quickly at room temperature and exhibits excellent environmental and chemical resistance. CB200 adhesive replaces welding, riveting, and other mechanical fastening methods and is recommended for bonding Click Bond adhesive bonded fasteners.

PRODUCT FEATURES

AEROSPACE SPECIFICATIONS
Boeing – DPM6336-1 Lockheed – LMA-ML074 Northrop – 1LKX179
GSA No. – 8040-01-422-3958

- Bonds unprepared metal - needs little or no surface preparation.
- Fast cure - cures quickly at room temperature.
- Good flow - bonds irregular shapes and inaccessible surfaces.
- Excellent environmental resistance - water resistant.
- Versatile - bonds many different substrates.
- Service Temperature Range: -67°F to 250°F (-55°C to 121°C)

UNCURED PROPERTIES

Appearance: Part A: off-white to yellow liquid
Part B: off-white liquid

Mix Ratio (B:A): 8:1 (volume), 7:1 (weight)

Cure time at 75°F (24°C): 30 minutes - handling strength.
2 hours - 90% of ultimate strength.
24 hours - full cure.

Working time at 75°F (24°C): 3 minutes (small quantities).

TYPICAL CURED PROPERTIES

Shear Strength: (ASTM D1002)
4400 psi (30.3 MPa)

Peel Strength: (ASTM D1876)
21 pli (3.7 kN/m)

Lap Shear testing performed at room temperature using .063 inch thick 2024-T81 aluminum adherends.

T-Peel testing performed at room temperature using .020 inch thick 2024-T3 aluminum adherends.

STORAGE AND SHELF LIFE

CB200 should be stored below 72°F (22°C) in a dry place when not used for a long period of time. CB200 has a minimum shelf life of 6 months when stored in the original package at 72°F (22°C). Shelf life may be extended to one year by refrigeration at between 35°F and 50°F (2°C and 10°C).

SURFACE PREPARATION

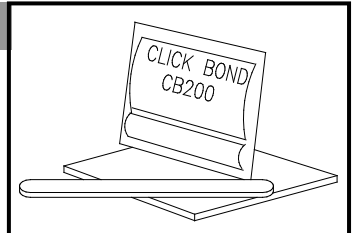
Surface preparation is an important part of adhesive bonding. Lightly abrade glossy surfaces to improve the adhesive bond. Just prior to adhesive application, clean surfaces with solvent using clean rags or paper towels. Do not use shop towels, rags or paper wipes contaminated with oil, soap, or reclaimed solvents. Wash one small area at a time, then dry with a clean cloth before the solvent evaporates to prevent redeposition of contaminants. To maintain a clean solvent supply, always pour the solvent on the washing cloth.

MIXING AND APPLYING ADHESIVE

Dispense 8 parts of component B and one part of component A (by volume). Mix until a uniform color is obtained (or use a disposable mixing nozzle). Apply to one of the surfaces to be bonded. To assure maximum bond strength, surfaces must be mated within 2 minutes. Use sufficient material to insure 100% joint fill when parts are mated. All adhesive application, part positioning, and clamping should occur before the 3 minute working time of the mix has expired. Movement of the parts after working time has expired can result in bond strengths lower than normal. Insure that the assembly remains undisturbed for 30 minutes to allow adhesive cure to progress to the handling strength stage where the fixtures or clamps may be removed.

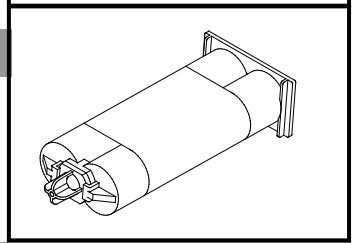
CB200 ADHESIVE PACKAGING – 3.5 gm FOIL PACKS

3.5 gram (.12 ounce) foil packs contain a pre-proportioned quantity of adhesive. Tear end of package to release adhesive. Mix contents on flat non-porous surface before applying to fastener. A 3.5 gram (.12 ounce) foil pack contains enough adhesive to install 4 - 5 fasteners with a 1.25 inch (31.8 mm) diameter baseplate or 6 - 8 nutplates or .62 inch (15.8 mm) diameter baseplate fasteners.



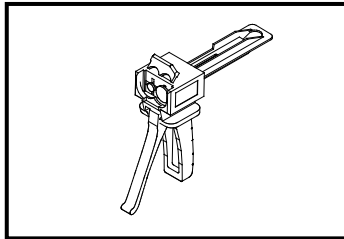
CB200-40 ADHESIVE PACKAGING – 40 ml CARTRIDGES

Standard 40 ml (1.35 ounce) dual pack syringe cartridges improve efficiency by reducing installation time. Click Bond dispensing tools with static mixing tips provide quick and accurate mixing and application of CB200 adhesive.

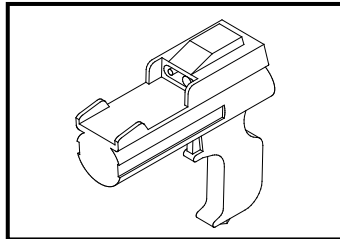


DISPENSING TOOLS AND MIXING TIPS FOR CB200 ADHESIVE

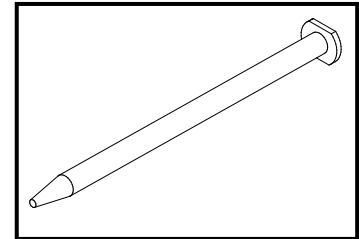
CB100-81 MANUAL DISPENSER



CB112 PNEUMATIC DISPENSER



CB106 MIXING TIP



DIRECTIONS FOR DISPENSING CB200 DUAL PACK 40 ml CARTRIDGES

1. Place cartridge into retaining lip on CB112 air powered tool or CB100-81 hand actuated tool.
2. Remove end cap by turning counterclockwise.
3. Activate the tool slightly to extrude a small amount of adhesive onto scrap material to insure adequate flow of both components.
4. Attach the mixing tip.
5. Dispense a small line of adhesive onto scrap material to insure adequate mixing.
6. Apply adhesive to part, joint surfaces, and hold under pressure for 30 minutes minimum at 75°F (24°C).
7. When not in use, remove and dispose of tip and replace endcap to preserve remaining adhesive.

IMPORTANT PRODUCT PERFORMANCE AND CAUTIONARY INFORMATION

Positive fresh air ventilation is necessary; otherwise use a NIOSH approved air purifying organic vapor respirator. Avoid prolonged breathing of vapors that may cause respiratory irritation. May cause skin irritation. Avoid contact with eyes and clothing. In case of contact, immediately flush skin or eyes with plenty of water for at least 15 minutes: for eyes, get medical attention. Wash clothing before reuse. Do not take internally. If swallowed, dilute with water and contact a physician or poison control center immediately. Do not induce vomiting. The CB200 Component A should not be allowed to remain in prolonged contact with the skin as it may cause irritation.

Keep away from heat, sparks, and open flame. In the case of CB200 Component A, procedures employed with handling chlorinated solvents (or other solvents) and organic peroxides should be used. Use adequate ventilation and avoid contact with open flames.

For industrial use only. For complete cautionary information refer to the Material Safety Data Sheet (MSDS). Copies are available from the Click Bond Customer Service Department upon request.

Values stated in this bulletin represent typical values as not all tests are run on each lot of material produced. For formalized product specification for specific product end uses, contact the Customer Service Department. Information provided herein is based upon tests believed to be reliable. Inasmuch as Click Bond has no control over the exact manner in which others may use this information, it does not guarantee the results to be obtained. Nor does Click Bond make any express or implied warranty of merchantability, or fitness for a particular purpose concerning the effects or results of such use.

ORDERING AND FURTHER TECHNICAL INFORMATION

Contact the Click Bond Customer Service Department:

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