



CA6910

Low Bloom, Medium-Viscosity, Cyanoacrylate Adhesive

Description

Lord® CA6910 adhesive is used to bond plastic and elastomeric materials where high resistance to chlorosis and blooming is important.

Features and Benefits

Product Purity - contains no measurable trace of moisture contamination. Provides exceptionally consistent bond performance. Prevents settling, sedimentation and precure during storage.

Excellent Resistance to Chlorosis and Bloom - allows parts which require a cosmetic finish to not "frost."

Easy to Use - requires minimal user training. Provides consistent results from part to part.

Surface Preparation

Remove oil, grease, mold release, or other contaminants by pretreating with acetone, alcohol, ethyl acetate, or similar degreasing chemicals. Do not use any preparations which would cause the surface to become acidic, as this can slow adhesive cure.

Prior to bonding, clean elastomers with acetone. Roughen metal and plastic surfaces with sandpaper or by sand blasting. Machining of plastics (i.e., milling, drilling, or grinding) will remove adhesive repellents such as mold lubricants. This will allow for better wetting of the parts with the adhesive.

Special surface treatments such as flame treating or sodium etching are necessary for plastics such as polyethylene, polypropylene, polytetrafluoroethylene, polyacetal, and other fluorinated hydrocarbons. In cases where pretreatment is impractical, try using the adhesive without pretreatment.

Table 1: Typical Properties* of Uncured Lord CA6910 Adhesive

Appearance	Colorless liquid
Base Compound	Isopropyl
Viscosity, cP at 25°C (77°F) ± 2°C	200 - 300
Density kg/m ³ lb/gal	1.03 - 1.07 8.56 - 8.89
Flash Point (TCC)	85°C (185°F)
Time to Handling Strength Plastic Rubber	6 - 8 seconds 10 seconds, maximum
Full Cure	24 hours
Shelf Life	6 months from date of shipment, @ 2°C - 7°C (35°F - 45°F), unopened container.

* Data is typical and not to be used for specification purposes.

Application

Apply Lord CA6910 adhesive by the drop. Maintain pressure while joining the parts.

Coverage is determined on the basis of the number of drops dispensed by a specific container. Use the information below as a general guideline:

Bottle Size	Drops/Bottle
14 gm	900
56 gm	3,600

Do not expose components to be bonded with Lord cyanoacrylate adhesive to aliphatic hydrocarbons and ester solvents. They will not resist alkalis and concentrated acids. Prolonged exposure to water or high humidity (>90% R.H.) will weaken the bond.

Curing

Actual setting times will be effected by factors such as temperature, humidity, glue line thickness and the mechanical and chemical nature of the surfaces to be bonded. Acidic surfaces retard polymerization, while alkaline surfaces accelerate polymerization.

Clean Up

Clean uncured adhesive with alcohol, acetone, or methyl ethyl ketone (MEK).

Packaging

- Bottles: 14-gram, 56-gram, 454-gram

Automatic dispensing equipment is available from outside vendors. Contact your Lord representative for recommended suppliers.

Storage

Store Lord CA6910 adhesive at 2°C - 7°C (35°F - 45°F). Bring to room temperature before using.

Cautionary Information

Before using this or any Lord product, refer to the Material Safety Data Sheet (MSDS) and label for safe use and handling instructions.

For industrial/commercial use only. Must be applied by trained personnel only. Not to be used in household applications. Not for consumer use.

Table 2: Typical Properties* of Cured Lord CA6910 Adhesive

Appearance	Colorless solid
Service Temperature Range	-53°C to 93°C (-65°F to 200°F)
Tensile Strength, Aluminum/Aluminum MPa (psi)	14.0 (2,030)

*Data is typical and not to be used for specification purposes.

Values stated in this bulletin represent typical values as not all tests are run on each lot of material produced. For formalized product specifications for specific product end uses, contact the Customer Service Department.

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