



# CA Gel

## General Purpose, High-Viscosity, Non-Stringing, Non-Migrating, Gel Cyanoacrylate Adhesive

### Description

Lord® CA Gel adhesive is used to bond assemblies which have wide tolerances or large gaps. It is especially useful on overhead or vertical surface.

Lord CA Gel adhesive is used for bonding all metals, rubber, and most plastics. This gel qualifies for Mil-A-46050C Type II, Class 5 and CID A-A 3097, Type II, Class 5 approval.

### Features and Benefits

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

**Fast Cure** - sets in 20 - 25 seconds when bonding plastic or rubber; sets in 30 - 50 seconds when bonding metal.

**High Viscosity** - prevents adhesive drip or run when used on an overhead or vertical surface.

**Non-Stringing, Non-Migrating** - allows for exact adhesive placement on part. Will not migrate; reduces clean-up time and increases production speed.

### 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

**Table 1: Typical Properties\* of Uncured Lord CA Gel Adhesive**

Appearance	Colorless liquid
Base Compound	Ethyl Cyanoacrylate
Viscosity, cP at 25°C (77°F)	Thixotropic
Density kg/L	1.07 ± 3%
lb/gal	8.89 ± 3%
Flash Point (TCC)	85°C (185°F)
Time to Handling Strength	
Plastic	20 - 25 seconds
Rubber	20 - 25 seconds
Metal	30 - 50 seconds
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. The viscosity of Lord CA Gel adhesive exceeds the viscosity range on current cyanoacrylate military specifications.

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.

### Application

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

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

- Tubes: 20-gram
- Bottles: 454-gram

The 20-gram tube is equipped with a dispenser tip to facilitate application. The 454-gram bottle is intended to be used with automatic dispensing equipment.

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

### Storage

Store Lord CA Gel 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.*

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**Table 2: Typical Properties\* of Cured Lord CA Gel Adhesive**

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Appearance	Clear plastic
Service Temperature Range	-60°C to 85°C (-76°F to 183°F)

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\*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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