**Technical Datasheet**

**Holdtite CA60**

**Product Description**

Holdtite CA60 is an advanced surface insensitive cyanoacrylate that is formulated to provide high tensile and shear strengths on a wide variety of substrates. This single component adhesive has an active cure mechanism, which when pressed into a thin film between two surfaces, will cure almost instantaneously to form a rigid thermoplastic. Due to the surface insensitive nature of CA60, this grade also maintains a rapid fixture time on acidic surfaces such as wood, leather and dichromated metals.

**Typical Applications**

Holdtite CA60 is used in a huge cross section of industrial applications. From OEM to MRO industries, this grade can be used on a variety of plastic, rubber and metal bonding applications including automotive, white goods and furniture manufacturing. Typical examples are shown below:

* Bonding centre consoles, dashboards and weather stripping
* Bonding identification tags to equipment
* Bonding rubber pads to equipment base or legs
* Bonding components in a speaker cone
* Bonding leather and rubber during shoe manufacture
* Bonding fabric on lampshades

**Instructions For Use**

1. For best results clean all surfaces with a cleaning solvent and allow to dry fully.
2. Apply adhesive to one of the mating parts and assemble carefully.
3. Allow to cure fully before applying load.
4. Excess adhesive can be carefully cleaned up with cleaning solvents such as acetone.

**Properties of Uncured Material**

|  |  |
| --- | --- |
| Resin | Ethyl Cyanoacrylate |
| Appearance | Colourless liquid |
| Viscosity  | 20cps |
| Cure System | Humidity |

**Performance of Cured Material**

|  |  |
| --- | --- |
| Fixture Speed  | < 5 seconds @ 20°C |
| Full Cure Time | 24 hours @ 20°C |
| Typical Strength | 5 to 28 N/mm2 |
| Gap Fill | 0.1mm |
| Temperature Range | -55°C to 82°C |

**Packaging**

Holdtite CA60 is available in 3g, 20g, 50g and 500g HDPE bottles. In addition, we can offer automated dispensing lines for bulk supply.

**Storage & Shelflife**

Holdtite CA60 should be stored unopened in a cool dry location, out of direct sunlight. Optimal storage is between 2°C to 80C , storage outside this range can adversly affect product properties. Stored correctly , this grade can offer a 12 month shelf life from manufacture.

**Health and Safety in Use**

**Holdtite CA60 is an ethyl cyanoacrylate, and can bond skin and eyelids in seconds. This grade should not be used without consulting the MSDS, which contains full information regarding the use of this product, including Transport, Disposal, Toxicological, Exposure Controls, Accidental Release and First Aid measures essential to the safe use of this product.**