

CB250 ACRYLIC STRUCTURAL ADHESIVE

CLICK BOND

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PRODUCT DESCRIPTION

CB250 is a general purpose thixotropic paste adhesive for bonding ABS, PVC, acrylic, styrene, metals, wood, and ceramics. It features high shear, peel, and impact strength with a fast cure at room temperature. Bonds gaps from .003 - .125 inches.

PRODUCT FEATURES

AEROSPACE SPECIFICATIONS

Boeing – DPM6336

- Excellent tolerance to off ratio mixing.
 - Little or no surface preparation.
 - 100% Reactive – no solvents.
 - Excellent environmental resistance.
 - Non-sagging, rapid cure without heat.
 - Versatile – bonds most plastics, metals, and oily substrates.
- Room temperature cure.
 - Gap filling to .125 inch.

UNCURED PROPERTIES

Appearance: Part A: Off-white.
Part B: Yellow.

Mix Ratio: 1:1

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

Working time at 75°F: 5 minutes (small quantities).

CURED PROPERTIES

Shear Strength: (ASTM D1002)	Peel Strength: (ASTM D1876)	Impact Strength: (ASTM D950)	Service Temperature Range:
3500 psi	37 pli	21 ft-lb/in ²	-67°F to 250°F

STORAGE AND SHELF LIFE

CB250 should be stored in a cool (below 72°F), dry place when not used for a long period of time. CB250 has a minimum shelf life of 2 months when stored in the original package at 72°F. Shelf life may be extended to six months by refrigeration at between 35°F and 50°F.

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.

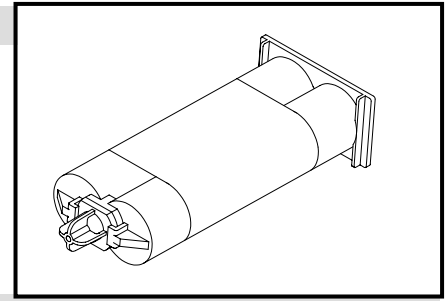
MIXING AND APPLYING ADHESIVE

Dispense equal parts of components A and B. 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 5 min. 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.

ADHESIVE PACKAGING – 50 ml CARTRIDGES

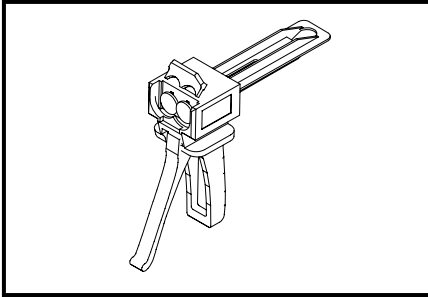
CB250-50

Standard 50 ml 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 CB250 adhesive.

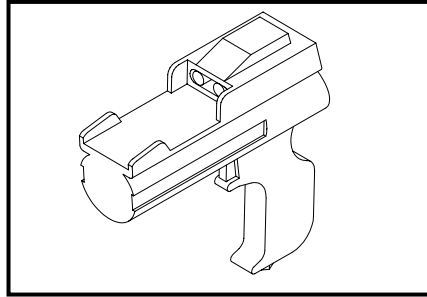


DISPENSING TOOLS AND MIXING TIPS FOR CB250 ADHESIVE

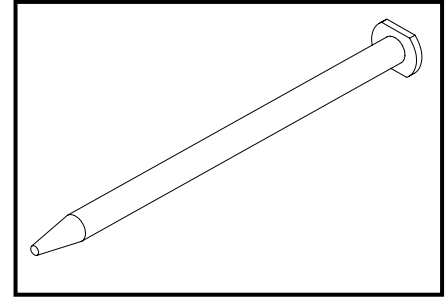
CB100-11 MANUAL DISPENSER



CB110 PNEUMATIC DISPENSER



CB106 MIXING TIP



DIRECTIONS FOR DISPENSING CB250 DUAL PACK 50 ml CARTRIDGES

1. Place cartridge into retaining lip on CB110 air powered tool or CB100-11 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.
7. When not in use, remove and dispose of tip and replace endcap to preserve remaining adhesive.

IMPORTANT PRODUCT PERFORMANCE AND CAUTIONARY INFORMATION

Click Bond CB250 adhesive (components A and B) are flammable. Contents include Methacrylate Ester. Keep containers closed after use. Avoid skin and eye contact. Wash with soap and water after skin contact. In case of eye contact, flush with water for 15 minutes and get medical attention. Harmful if swallowed. Keep out of reach of children. Keep away from heat, sparks, and open flames.

NOTE: Because of the rapid curing features of this product, large amounts of heat are generated when large amounts of material are mixed at one time (film thickness cures in excess of 1/8" should be avoided whenever possible). The heat generated by the exotherm resulting from the mixing of large amounts of adhesive can result in the release of entrapped air and volatile components as evidenced by gassing. To prevent this, use only enough material as needed for use within the working time for the product and confine gap thicknesses to no more than .125". Questions relative to this should be directed to the Click Bond Customer Service Department.

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 the Company 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:

PHONE (775) 885-8000 FAX (775) 883-0191

CB250 Data Sheet – Effective FEB99

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