

**Product Description**

Kem Vibra-TITE 395 is a single component low viscosity cyanoacrylate adhesive. Suitable for general-purpose applications on metals rubbers and plastics.

**Physical Properties**

#	Parameter	Specifications
1	Base Compound	Ethyl Cyanoacrylate
2	Appearance	Colorless Liquid
3	Viscosity, cp @ 20°C	30
4	Specific Gravity	1.06
5	Flash Point (TCC)	85
6	Shelf Life @ 5°C (as Packed)	12 Months

**Military Specifications**

Mil-A-46050C  
Type II, Class 2

**Curing Properties**

Ambient surface moisture will initiate the hardening process. Handling strength is reached in a short period of time and varies depending on environmental conditions and substrates being bonded. Product will continue to cure for at least 24 hours before full strength and resistances are developed.

**Setting Properties (20°C, 85% RH)**

#	Material	
1	Steel	12 – 20 sec
2	Aluminum	10 – 18 Sec.
3	Neoprene	< 5 Sec.
4	ABS	5 – 10 sec
5	Polycarbonate	10 - 15 sec.
6	PVC	4 – 8 Sec.

**Curing Performance**

The gap of the bond line will affect set speed. Smaller gaps tend to increase the speed. Activators can be applied to improve set speed but may also impair overall adhesive performance.

**Polymer Cured**

Appearance	Colorless Solid
Service Temperature Range	-53 – 95°C
Softening Point	160°C
Refractive Index (ND 20)	1.49
Full Cure Time	24 Hours
Di-electric Strength (kv/mm)	11.6
Di-electric Constant (@ 1 kC)	5.4
COE (in./in./C)	0.000126
Tensile strength (Steel/Steel)	3200 Psi
Solubility	Nitromethane, Acetone, Dimethylformamide

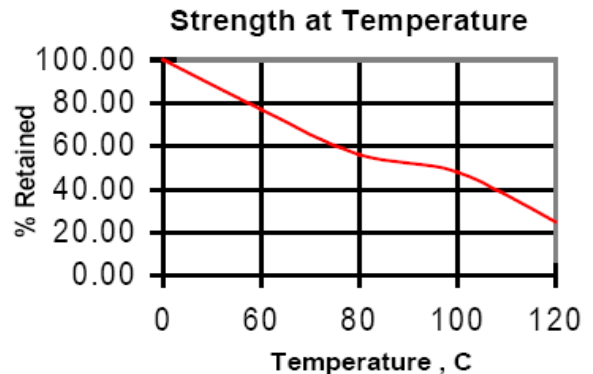
**Performance of Cured Material**

Tensile Shear strength after 48 hours at 20° to 25°C

Substrate	Range in N/mm <sup>2</sup>
Blasted Steel	17 – 25
Etched Aluminum	14 – 23
Neoprene	> 10
ABS	> 6
Polycarbonate	> 5
PVC	> 6

**Temperature Range**

Sheer Strength on steel after 1 week at 22 °C



**Chemical Resistance**

Sheer strength on steel after 12 months soak

	<b>% Strength Retained</b>
Motor Oil	100
Gasoline	100
Tri-chloroEthane	100
Freon TA	100
10% NaOH	0
10% HCl	0
Water	0

## **General Information**

Surfaces to be bonded should be clean and dry. Dispense a drop or drops to one surface only. Apply only enough to leave a thin film layer after compression. Press parts together and hold firmly for a few seconds. Good contact is essential. An adequate bond develops in less than one minute and maximum strength is attained in 24 hours. Wipe off excess adhesive from the top of the container and recap. Cyanoacrylate products if left uncapped may deteriorate by contamination from moisture in the air. Because Cyanoacrylate products cure by polymerization, whitening may appear on the surface of the container or the bonded materials. Should this happen, wipe surfaces well with acetone.

## **Storage**

Refrigeration at 5 °C provides optimum storage stability.

## **Note**

Prior to use, remove all surface contaminants such as oil or grease. Products like isopropyl alcohol can be used. Test compatibility of cleaner with substrate. Make sure surface is completely dry before bonding.

## **Health & Safety**

CAUTION: SuperGlues bond skin and eyes on contact. If accidental skin bonding occurs, wash area with warm soapy water and slowly pry skin apart using a blunt object (such as a teaspoon handle.) In case of eye contact, bathe immediately with water and seek immediate medical attention.

### **NOTE TO USER**

The information contained in this document while based on evidence and reliable methods can not be considered exhaustive. This information is current to the date of issuance of this data sheet.

The user, under its own responsibility, shall respect all the existing provisions on hygiene and safety and shall verify every time the features and the specific and appropriate way to use the product, cause the respect of the provisions is not under producer's direct control. The manufacturer does not guarantee nor assume any liability or responsibility for whatsoever harm that might result from a misuse of the product or for damages that have arisen after the product's distribution.

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