PERMABOND®CSA-NF

Cyanoacrylate Activator

Preliminary Technical Data Sheet

Ref #: 041808CSA-NF

TYPICAL APPLICATIONS

Porous Parts
Poorly Mated Parts
Wire Tacking
Reduction of Stress Cracking on Plastic Parts

FEATURES & BENEFITS

- Contains no ozone depleting agent
- Non-flammable
- Rapid setting on closely mated parts
- Faster cure through gaps
- Enables cyanoacrylates to bond to porous surfaces
- Will not stress crack plastic surfaces
- No discoloration of part surfaces
- Reduces frosting or fogging of the adhesive
- Allows cyanoacrylates to cure on strongly passivated metals, aged PVC or acidic surfaces such as wood

GENERAL DESCRIPTION

The PERMABOND CSA-NF accelerates the cure of cyanoacrylate adhesives to provide a shorter set time. It can be used in a variety of applications but is especially useful when bonding porous or poorly mated parts. PERMABOND CSA-NF cures the adhesive before it soaks into a porous surface or runs out from between parts with sizable gaps.

It can be used to accelerate cure on sensitive plastic surfaces such as polycarbonate without causing stress cracking. No discoloration of the part surface is observed when using PERMABOND CSA-NF. The activator can be sprayed on the surface of the cyanoacrylate to accelerate curing in wire tacking or similar bonding applications.

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PERMABOND CSA-NF contains a specially chosen initiator in a non-halogenated solvent that is not ozone depleting. This solvent evaporates quickly to leave a thin film of the initiator on the surface to be bonded.

PHYSICAL PROPERTIES OF THE UNCURED ACTIVATOR

Color	Colorless
Flash Point °C (°F)	100 (212)
Specific Gravity	1.3
Shelf Life at 5°C-27°C (41°F-77°F), months	12

SET TIMES, seconds (no induced gap)[1]

Steel[2]	5 (5 mil gap: 40-60 seconds)
Buna-N	10
Phenolic	5

Lap Shear Strength at 25°C, (77°F) psi (no induced gap)[1]

Steel, 5 minutes	1400
24 hours	2400

[1)]Tests conducted with a 100 cP ethyl-2-cyanoacrylate adhesive. CSA-NF was applied to a single surface.
[2)]Without CSA-NF, set time was 10-15 seconds.

APPLICATION & DISPENSING

Post assembly application

1) Parts should be clean, dry and grease-free prior to bonding.
2) Apply CSA-NF to the exposed cyanoacrylate.
3) Apply activator over all the exposed cyanoacrylate either by drop or spraying the activator.

Suraface activation

1) Parts should be clean, dry and grease-free prior to bonding.
2) Apply one coating to one of the surfaces to be bonded by spraying, dipping or wiping the activator
3) Allow the activator to evaporate until the surface is completely dry (approximately 30 seconds)
4) Imidiately apply Permabond cyanoacrylate to the untreated surface and mate the paarts.

Do not put the adhesive on the treated surface as the adhesive could cure before the parts can be properly mated. Only if the gap is extremely large (>20 mil) should activator be put on both surfaces.

STORAGE & HANDLING

Permabond CSA-NF is formulated to maximize performance and minimize attack on certain plastics and coatings. It is recommended to check the compatibility of CSA-NF on all surfaces before before using in production.

For safe handling of CSA-NF refer to the material safety data sheet (MSDS).

Do not mix Permabond CSA-NF directly with liquid cyanoacrylates.

Store and use only in a well ventilated area . CSA-NF has a shelf life of one year when stored in the unopened container between 5°C-27°C (41°F-77°F).

FOR INDUSTRIAL USE ONLY. KEEP OUT OF REACH OF CHILDREN.