

# BORN<sup>2</sup> BOND™



Instant Adhesives

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## OUR VISION

Collaborate and innovate to create smart adhesives that are safer, more flexible, efficient and responsive to the dynamic challenges of our environment.

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## 'A global leader in smart adhesives'

For over a century, we have developed smart adhesive solutions that touch and improve people's daily lives. Customers worldwide use our bonding systems in countless applications and across diverse sectors, including industrial manufacturing, construction, electronics, automotive, medical and packaging.

Our products are often invisible to the end-user, but every day they make a significant contribution to the creation of a safer, more efficient and sustainable world.

We are committed to innovation and continually invest in technological advances in our drive to develop ever more capable and adaptable 'smart' adhesives. This commitment is supported by our parent company, Arkema, a globally renowned manufacturer of specialty chemicals and advanced materials.

Through Arkema, we have access to a worldwide infrastructure and full supply chain, including innovative raw materials, sustainable sourcing and energy-efficient production capabilities.

### GLOBAL FOOTPRINT

Bostik is one of the world's largest adhesive and sealant companies.



**€2bn**  
worldwide sales

**6,000**  
employees



**55**  
countries



**4**  
R&D centers

**ARKEMA**  
INNOVATIVE CHEMISTRY

Bostik, an Arkema company



## NEW ENGINEERING ADHESIVES

As engineering adhesive applications develop, they raise new challenges. These include questions of how to apply adhesives to ever-smaller and more complex items, how to accelerate curing processes and how to reduce waste, all while complying with environmental and health and safety regulations.

In response, we have developed a portfolio of ground-breaking engineering adhesives that focus on **'by-the-dot'** bonding applications. These products sit under the **Born2Bond™** brand – this name reflects our purpose and the collaborative bond we have with our customers.

### OUR VALUES



INNOVATION



COLLABORATION



SAFETY &  
SUSTAINABILITY

### DESIGNED FOR USE IN MULTIPLE INDUSTRIES



AUTOMOTIVE



ELECTRONICS



LUXURY  
PACKAGING



MEDICAL  
DEVICES



MRO



# Instant Adhesives

The first wave of **Born2Bond™** products is a collection of instant engineering adhesives.

To date, instant engineering adhesive performance and applications have been constrained by the limitations of existing cyanoacrylate technologies. Through a unique process, Bostik will unlock the potential of these technologies and develop a range of instant adhesives to deliver the high-performance, user-friendly properties engineers need.



LOW ODOR



LOW BLOOM



HIGH PERFORMANCE

## PUSHING THE BOUNDARIES OF CYANOACRYLATE TECHNOLOGIES

**BORN<sup>2</sup>  
BOND™**



	Standard <b>ETHYL CA</b> Products	Standard <b>METHOXYETHYL CA</b> Products	New <b>BOSTIK</b> Products
Reactivity: Fast Fixture Time	■	■	■
Flexibility	■	■	■
Gap Filling	■	■	■
Stability	■	■	■
Tensile Strength	■	■	■
Odor	■	■	■
Blooming	■	■	■

- Poor
- Moderate
- Excellent

## INSTANT ADHESIVES RANGE

Available in a range of advanced formulations, our pioneering **Born2Bond™** Instant Adhesives overcome many of the performance and application limitations of existing solutions. Inspired by collaboration with our customers, these products address the challenges presented by today's ever-smaller, more complex products and demand for a high quality finish. They also facilitate faster, smarter production processes while prioritizing user safety and sustainability.



1K

### 1K PRODUCT RANGE

**Born2Bond™** one-component products are available in varying viscosities and multiple sizes and formats ranging from 20g and 50g bottles designed for manual dispensing, to 500g bottles intended for use with automatic dispensing equipment. They are also available in gel form (5g and 20g aluminium tubes) to facilitate precision manual dispensing.



20g & 50g bottles for **ULTRA LV, MV & HV**

500g bottles for **ULTRA LV, MV & HV**

5g & 20g alu tubes for **ULTRA Gel**



2K

2K PRODUCT RANGE

**Born2Bond™** two-component products are available in 10g syringes designed for manual dispensing and 50g syringes intended for use with dispensing guns. Both are compatible with disposable static mixers.



10g syringes for **FLEX, REPAIR & STRUCTURAL**

50g syringes for **FLEX, REPAIR & STRUCTURAL**

DUAL CURE

DUAL CURE PRODUCT RANGE

**Born2Bond™** dual-cure (contact and light) products are available in medium-viscosity, high-viscosity and gel forms (5g and 20g aluminium tubes) to facilitate precision manual dispensing and 500g bottles intended for use with automatic dispensing equipment.



5g alu tubes for **LIGHT LOCK MV, HV & Gel**

20g alu tubes for **LIGHT LOCK MV, HV & Gel**

500g bottles for **LIGHT LOCK MV & HV**

## PRODUCT SELECTOR

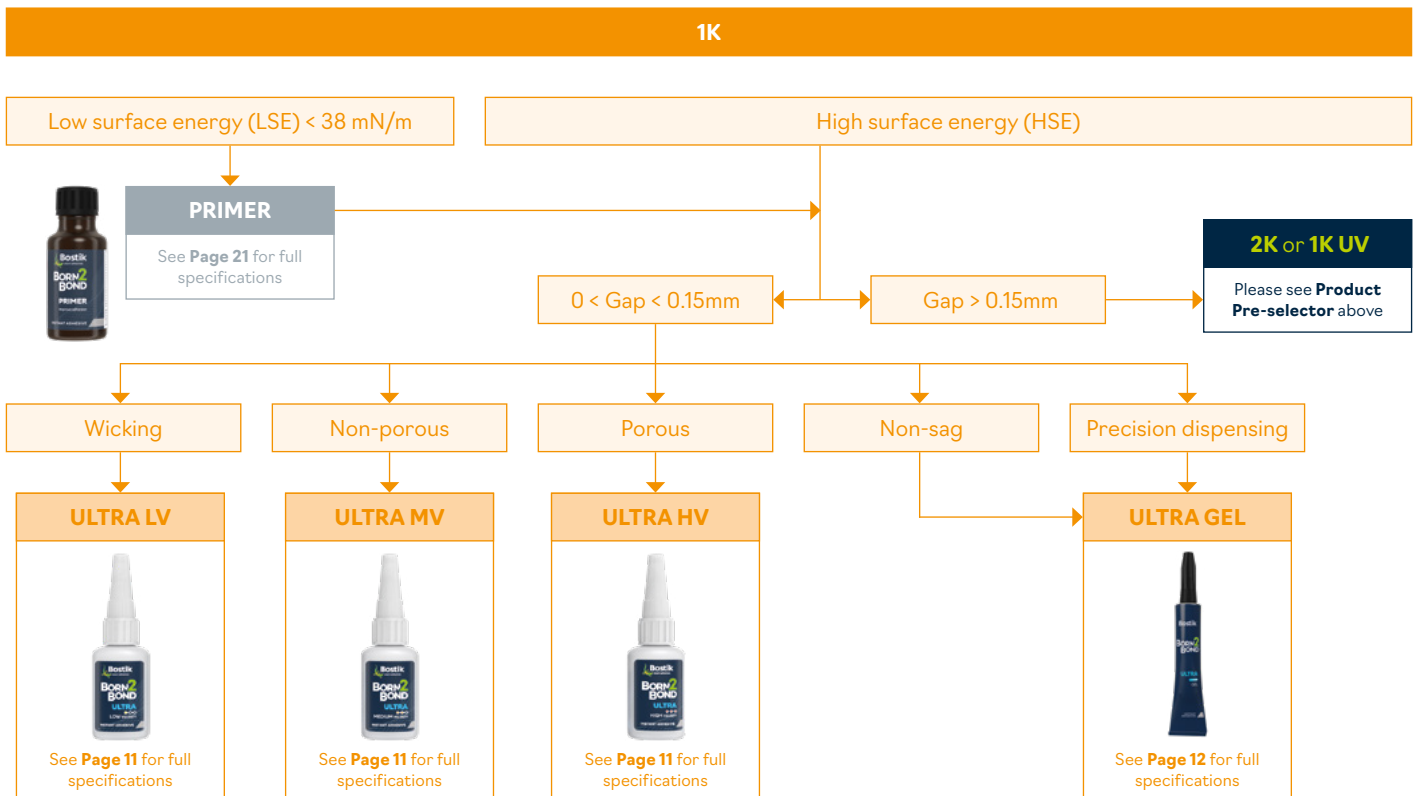
Please use the **Product Selector** below to identify the right solutions for your bonding requirements.

	PRODUCT PRE-SELECTOR		
	1K	2K	DUAL CURE
<b>GAP FILLING</b>	< 0.15mm	Up to centimeters	< 10mm*
<b>FIXTURE TIME</b>	5 - 15 sec	> 15 sec	< 5 sec*
<b>OPEN TIME</b>	+++	++	++
<b>IMPACT RESISTANCE</b>	+	+++	++

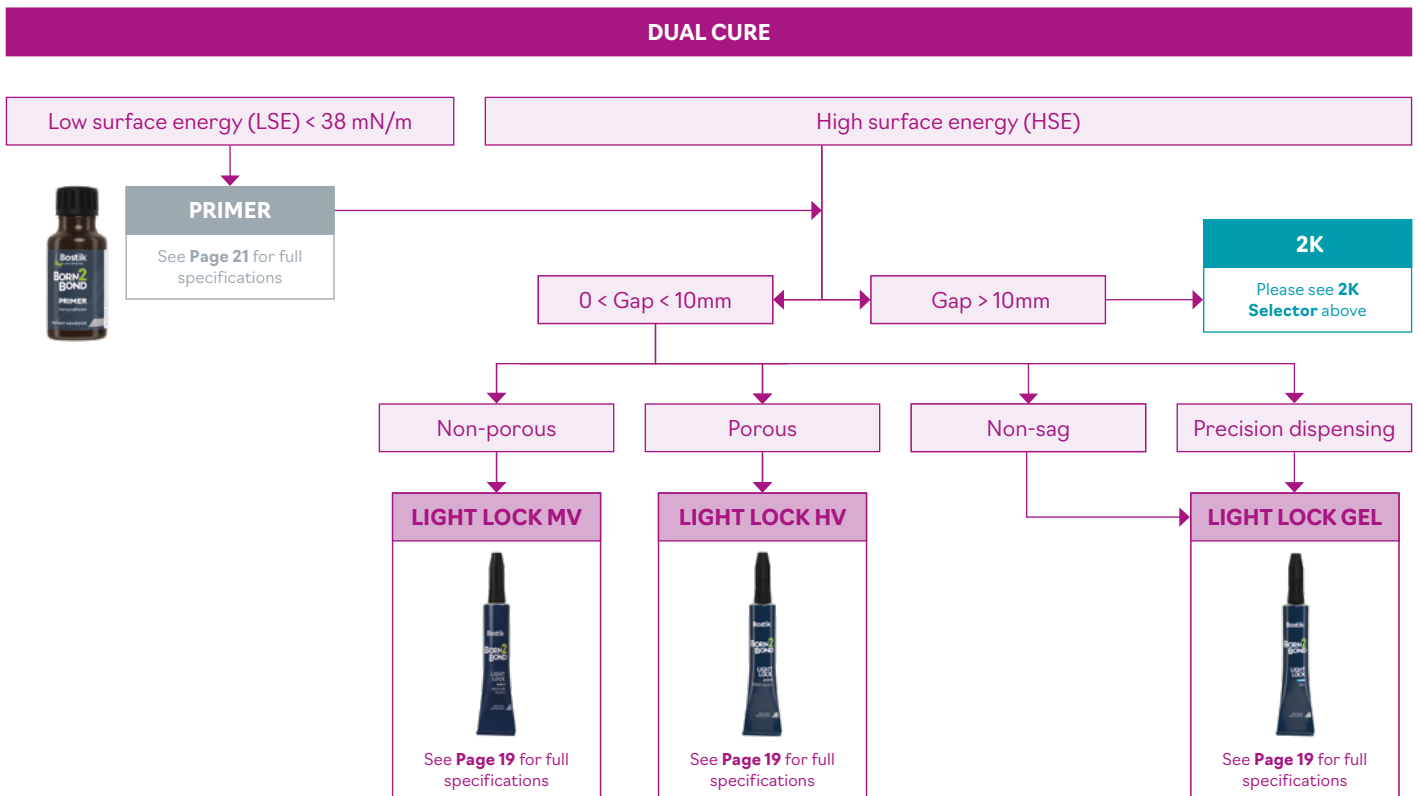
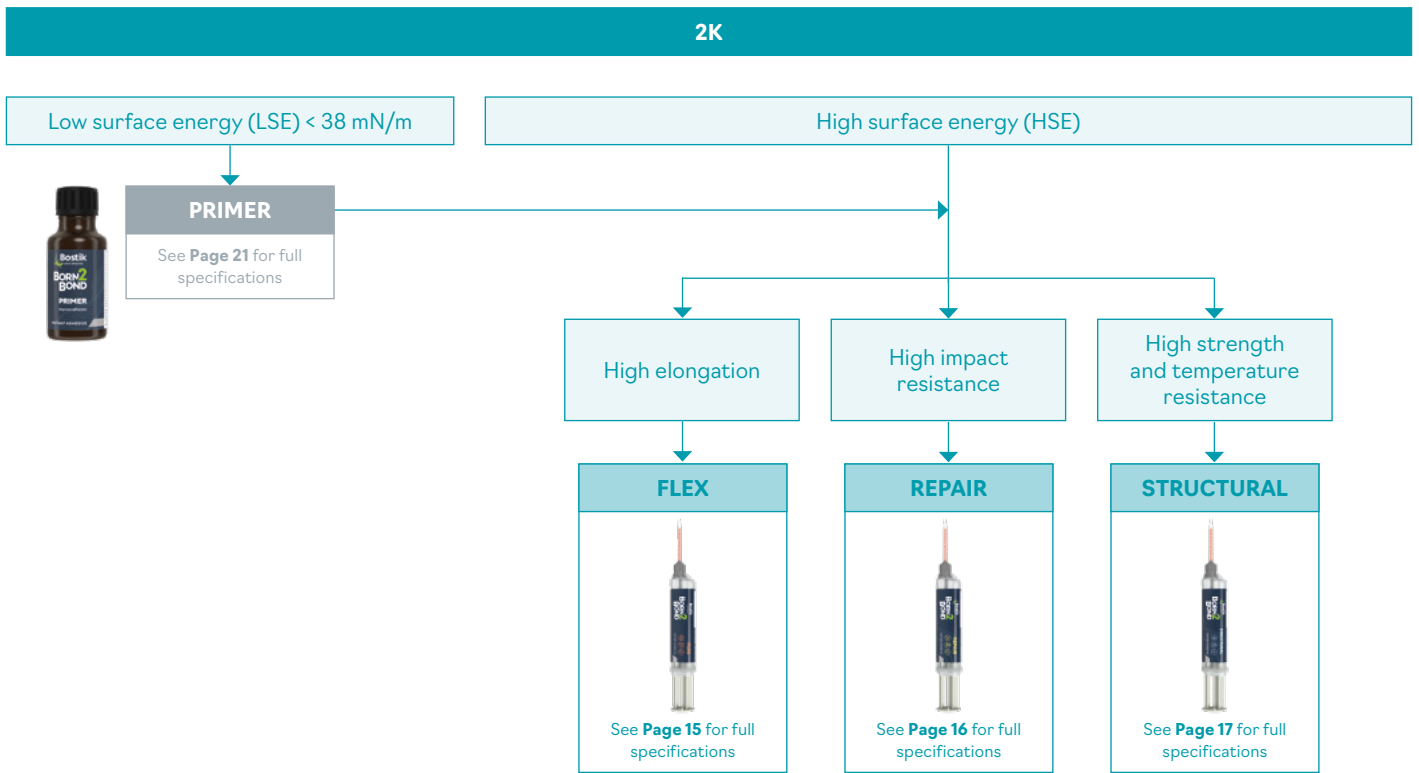
\* For light curing

+ Moderate ++ Good +++ Excellent

DEFINITIONS	
<b>GAP FILLING</b>	Dispensing or injecting a one or two-component curing system, resulting in a soft or structural form-in-place elastomer or polymer, used as an adhesive, sealant or to fill a void.
<b>FIXTURE TIME</b>	Time taken to obtain a level of performance sufficient to hold a load with 1kg weight for 10 seconds.
<b>OPEN TIME</b>	Time during which one can assemble the two parts of an assembly and obtain the maximum properties.
<b>IMPACT RESISTANCE</b>	Ability to withstand intense force or shock applied to it over a short period of time. Impact resistance is an important consideration for fall protection equipment.







# BORN<sup>2</sup> BOND™

1K Products



### ULTRA



Multi-substrate Adhesion



Fast Bonding



Low-odor Technology

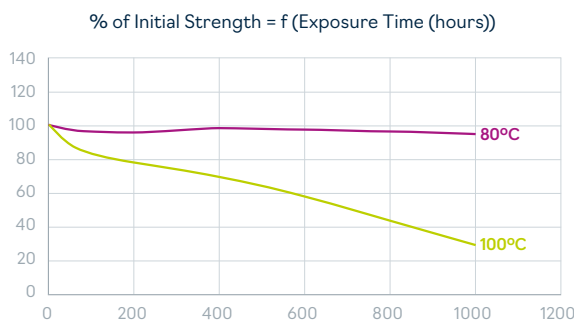
**Born2Bond™ Ultra** adhesives are low-odor, low-blooming, instant adhesives with a range of viscosities, specially designed for bonding most substrates including plastics, rubbers and metals. The formulation consistency has been designed for high bond strength, even in places that are subject to flexing. Careful selection of the formulation ingredients ensures that the product does not leave a white stain (blooming).

#### FEATURES

- Fixture time: 10 seconds\*
- High bonding strength
- Long open time
- Low odor, low blooming
- Less brittle than conventional instant adhesives
- Bonds a large range of materials\*\* including polystyrene
- Transparent and easy to use

#### TYPICAL APPLICATIONS

- Leather and rubber bonding
- Shoe assembly
- Automotive aftermarket applications
- Speaker assembly



	ULTRA LV	ULTRA MV	ULTRA HV
<b>BASE</b>	Methoxyethyl Cyanoacrylate		
<b>VISCOSITY (cP)</b>	20 - 50 cP	120 - 170 cP	700 - 1,000 cP
<b>FIXTURE TIME*</b>	5-10 seconds	10 seconds	15 seconds
<b>BOND STRENGTH</b>	Grit-Blasted Mild Steel 14 MPa	Grit-Blasted Mild Steel 13 MPa	Grit-Blasted Mild Steel 11 MPa
<b>APPEARANCE</b>	Transparent		
<b>TEMPERATURE RANGE</b>	-40°C up to +80°C		
<b>AVAILABLE IN</b>	Bottles: 20g, 50g and 500g		

Choose the right solution using our **Product Selector on Page 8**

TDS and SDS available on request

### ULTRA GEL



High Strength



Low-odor Technology



Flexible



Precision

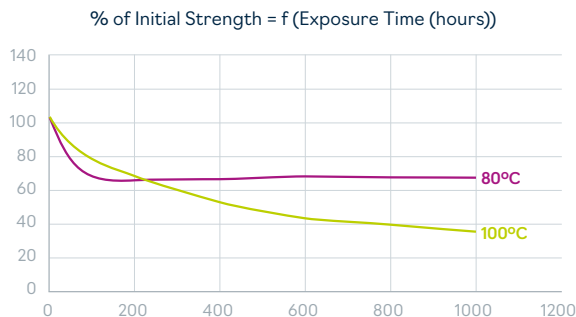
**Born2Bond™ Ultra Gel** is a low-odor, low-blooming, instant adhesive specially designed for bonding most substrates including plastics, rubbers and metals. The formulation consistency has been designed for high bond strength, even in places that are subject to flexing. The gel consistency allows application in any orientation. Careful selection of the formulation ingredients ensures that the product does not leave a white stain (blooming).

#### FEATURES

- Fixture time: 5 seconds\*
- High bonding strength
- Long open time
- Low odor, low blooming
- Peel resistance
- Bonds a large range of materials\*\* including polystyrene
- Gel consistency for precise application

#### TYPICAL APPLICATIONS

- Leather and rubber bonding
- Shoe assembly
- Automotive aftermarket applications
- Sporting equipment
- Toy assembly
- Bonding glass to metal for jewelry



	ULTRA GEL
<b>BASE</b>	Methoxyethyl Cyanoacrylate
<b>VISCOSITY (cP)</b>	105,000 - 120,000 cP
<b>FIXTURE TIME*</b>	5 seconds
<b>BOND STRENGTH</b>	Grit-Blasted Mild Steel - 13 MPa
<b>APPEARANCE</b>	Transparent
<b>TEMPERATURE RANGE</b>	-40°C up to +80°C
<b>AVAILABLE IN</b>	Tubes: 5g, 20g

Choose the right solution using our **Product Selector on Page 8**

TDS and SDS available on request



## Respect for the world and workplace

We are committed to developing sustainable adhesives and production methods and to protecting the wellbeing of our customers' workforces.

- Low-energy production processes
- Safer products
- Increased user comfort



## 2K Products



### FLEX



Flexible & Elastic



Multi-substrate Adhesion



Low-odor Technology



Gap Filling



Precision



Impact Resistant

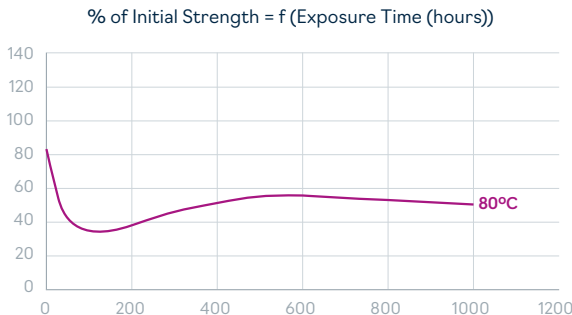
**Born2Bond™ Flex** is a patent-pending, flexible, elastic and low-odor instant adhesive with exceptional adhesion to a very broad range of materials and surfaces. It becomes a polymer (hardens) with more than 200% elongation with a working time (in mixer) of up to six minutes. It can be used for high-volumetric gap filling, achieving instant adhesion to most plastics, woods and metals as well as to porous and irregular surfaces.

#### FEATURES

- Fixture time in 60 seconds\*
- Hardens in 5-10 minutes\*
- Elongation > 200%
- Absorbs impacts and vibrations
- High peel strength
- Bonds a large range of materials\*\* including glass
- Transparent, low odor, low blooming
- Gel consistency for precise application
- Non-sagging for vertical applications

#### TYPICAL APPLICATIONS

- Leather bonding for luxury clothing
- Sealing repair
- Elastic seam and joint sealing
- Flooring and panel bonding
- Vibration dampening
- Glass to rubber bonding



Choose the right solution using our **Product Selector on Page 8**

TDS and SDS available on request

	FLEX
<b>BASE</b>	Methoxyethyl Cyanoacrylate
<b>VISCOSITY (cP)</b>	Part A: 120,000 - 170,000 Part B: 70,000 - 130,000
<b>OPEN TIME</b>	6-10 minutes
<b>FIXTURE TIME*</b>	60 seconds
<b>BOND STRENGTH</b>	Grit-Blasted Mild Steel - 10 MPa
<b>APPEARANCE</b>	Transparent
<b>TEMPERATURE RANGE</b>	-40°C up to +60°C
<b>GAP FILLING CAPABILITY</b>	1cm
<b>AVAILABLE IN</b>	Syringes: 10g, 50g

### REPAIR



Impact Resistant



Drillable & Sandable



Gap Filling



Multi-substrate Adhesion



Precision



High Strength

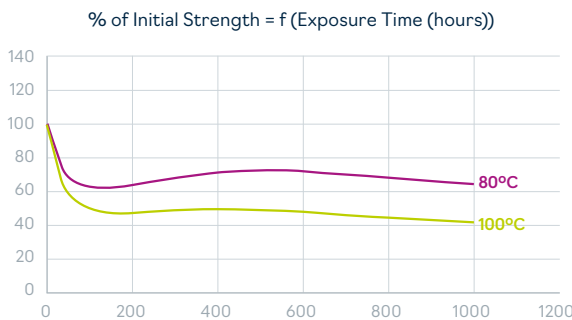
**Born2Bond™ Repair** is a patented<sup>†</sup>, gap-filling, instant adhesive and repair product with excellent adhesion to a very broad range of materials and surfaces. Repair is ideal for instant bonding and repairing, because it combines the strength of a structural adhesive with the speed of an instant adhesive. A tough polymer is achieved within a hardening time of under 10 minutes, and the gel consistency enables application in any orientation.

#### FEATURES

- Fixture time in 60 seconds\*
- Hardens in 5-10 minutes\*
- Instant adhesion with high bonding strength
- Low volume shrinkage: 4.3%
- Fills gaps of large volumes
- Bonds a large range of materials\*\*
- Machinable, sandable and paintable once hardened
- Impact resistant
- Gel consistency for precise application
- Non-sagging for vertical applications

#### TYPICAL APPLICATIONS

- Automotive aftermarket applications
- Wood repair and reconstruction
- Rubber door bonding
- Automotive joint bonding
- Plastic defect repairing



Choose the right solution using our **Product Selector on Page 8**



TDS and SDS available on request

	REPAIR
<b>BASE</b>	Ethyl Cyanoacrylate
<b>VISCOSITY (cP)</b>	Part A: 130,000 - 180,000 Part B: 70,000 - 130,000
<b>OPEN TIME</b>	4-10 minutes
<b>FIXTURE TIME*</b>	15-60 seconds
<b>BOND STRENGTH</b>	Grit-Blasted Mild Steel - 14 MPa
<b>APPEARANCE</b>	Whitish
<b>TEMPERATURE RANGE</b>	-40°C up to +80°C
<b>GAP FILLING CAPABILITY</b>	Centimeters
<b>AVAILABLE IN</b>	Syringes: 10g, 50g

<sup>†</sup> Patented in multiple countries.



### STRUCTURAL



Long Open Time



High Strength



Gap Filling



Repositionable



Precision



Multi-substrate Adhesion



Impact Resistant

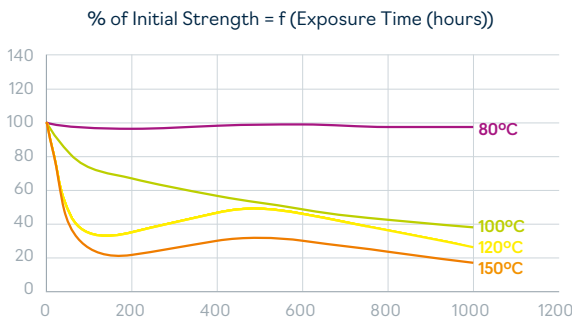
**Born2Bond™ Structural** is a patent-pending, high-strength hybrid adhesive that provides a fast fixture time at room temperature while maintaining good processability and bond gaps up to 5mm. This product offers excellent bonding characteristics to a large variety of closed substrates, such as aluminum, steel, plastics and elastomers as well as porous substrates, such as woods, chipboard and leather. **Born2Bond™ Structural** is formulated for applications that require mechanical and in-use environmental resistance.

#### FEATURES

- Fixture time in 30 seconds\*
- High adhesion strength: > 6 MPa after 5 minutes
- Open time of 25 minutes
- Fills gaps up to 5mm
- Excellent adhesion to many different substrates\*\*
- Transparent when cured
- Temperature and humidity resistance
- Gel consistency for precise application

#### TYPICAL APPLICATIONS

- Structural bonding
- Magnet bonding
- Bathroom accessory bonding (plastic to metal)
- Bonding glass to leather



Choose the right solution using our **Product Selector on Page 8**

TDS and SDS available on request

	STRUCTURAL
<b>BASE</b>	Hybrid CA & Acrylate
<b>VISCOSITY (cP)</b>	Part A: 100,000 - 150,000 Part B: 40,000 - 80,000
<b>OPEN TIME</b>	25 minutes
<b>FIXTURE TIME*</b>	30 to 90 seconds
<b>BOND STRENGTH</b>	Grit-Blasted Mild Steel - 14 MPa
<b>APPEARANCE</b>	Transparent
<b>TEMPERATURE RANGE</b>	-40°C up to +120°C
<b>GAP FILLING CAPABILITY</b>	5mm
<b>AVAILABLE IN</b>	Syringes: 10g, 50g

## Dual Cure Products



### LIGHT LOCK



Light & Surface (Dual) Cure



Repositionable



Gap Filling



Low-odor Technology



Fast Bonding



Multi-substrate Adhesion

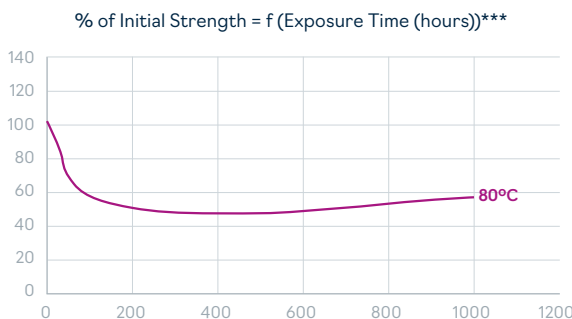
**Born2Bond™ Light Lock HV and Gel** are patented<sup>†</sup>, low-odor, low-blooming, dual-curing (contact and light curing) cyanoacrylate adhesives. They are designed for bonding applications that require fast fixturing, coating or surface cure. The UV and visible-light cure sensitivity allow rapid bonding through transparent parts and quick curing of light-exposed bulk or surface-coated areas. Further, the product's instant bonding capability ensures cure between opaque substrates (contact cure).

#### FEATURES

- Dual cure formulation: instant and photo-cure
- Fixture time in 60 seconds without light exposure, and 5 seconds with light curing
- Can be cured with visible and UV-LED light
- Long open time without activation
- Dry to touch, tack free surface cure
- Cure-on-demand of excess material released from bondlines
- Bonds, fills, reconstructs and coats
- Low odor, low blooming
- Available in a range of viscosities: MV, HV and GEL

#### TYPICAL APPLICATIONS

- Conformal coating
- Encapsulation
- Electronics assembly
- Plastic to metal bonding for medical devices
- Glass to metal bonding for jewelry, watches, perfume and liquor bottles



\*\*\*Information in graph above is for Light Lock Gel only.

Choose the right solution using our **Product Selector on Page 8**



TDS and SDS available on request



	MV	HV	GEL
<b>BASE</b>	Light Curing Methoxyethyl Cyanoacrylate		
<b>VISCOSITY (cP)</b>	180 - 220	600 - 900	30,000 - 45,000
<b>BOND STRENGTH</b>	Grit-Blasted Mild Steel - 2 MPa	Grit-Blasted Mild Steel - 6 MPa	Grit-Blasted Mild Steel - 5 MPa
<b>APPEARANCE</b>	Transparent after cure		
<b>TEMPERATURE RANGE</b>	-40°C up to +80°C		
<b>AVAILABLE IN</b>	Tubes: 5g, 20g and Bottle: 500g (MV and HV only)		

<sup>†</sup> Patented in multiple countries.





## Surface Preparation





### SURFACE PREPARATION

**Born2Bond™ Booster** is a surface preparation product that accelerates cyanoacrylate curing and is specially designed for curing on wood and plastic surfaces. Its long open time and short drying time makes it an ideal choice for professionals. Unlike other accelerators, **Born2Bond™ Booster** is particularly suitable for promoting quick adhesion when joining parts that are immediately subjected to high stress, like edge coating or shoe soles.

#### FEATURES

- Increases curing speed of cyanoacrylate adhesives on acidic woods and porous substrates
- Dries in seconds
- Open time: 24 hours
- Transparent
- Easy to use

#### TYPICAL APPLICATIONS

- Preparation of surfaces
- Acceleration of bonding for wood, leather and vertical surfaces



Choose the right solution using our [Product Selector](#) on [Page 8](#)

TDS and SDS available on request

**Born2Bond™ Primer** is used to make polyolefin and other low surface energy substrates suitable for bonding with cyanoacrylate adhesives. It is only recommended for difficult-to-bond substrates, which include polyethylene, polypropylene, polytetrafluoroethylene (PTFE) and thermoplastic rubber materials. **Born2Bond™ Primer** is not recommended in assemblies where high peel strength is required.

#### FEATURES

- Improves adhesion to difficult-to-bond substrates
- Specially formulated for adhesion of polyolefins
- Suitable for use with other cyanoacrylates
- Dries in seconds
- Increases adhesion strength

#### TYPICAL APPLICATIONS

- Preparation of surfaces
- Bonding of difficult-to-bond plastics and polyolefins



Choose the right solution using our [Product Selector](#) on [Page 8](#)

TDS and SDS available on request

### SUPPORTING PRODUCTS

In conjunction with our **Born2Bond™** adhesives, we offer a variety of products to help you optimize substrate preparation and application processes.

**Bostik Cleaner\*** is a powerful preparation agent that is highly suitable for cleaning and degreasing substrates before applying **Born2Bond™** products.

#### FEATURES

- Elevated evaporation rates
- 'No stress-cracking' on plastic
- Easily diluted for use
- High efficiency for degreasing

#### TYPICAL APPLICATIONS

- Cleaning and degreasing of a variety of substrates



Choose from a complete range of **dispenser guns** and **disposable static mixers**.



#### DISPENSER GUNS

- Minimum trigger pressure for effortless use
- Ergonomic design for comfort and minimum fatigue



#### DISPOSABLE STATIC MIXERS

- Ensures optimal mixing of two-component adhesives
- Variants available for both 10g and 50g syringes

## SUBSTRATE TABLE

To help you select the best **Born2Bond™** product for your needs, this table shows the bonding compatibility between different substrate types and adhesives within the **Born2Bond™** range.

	ULTRA LV	ULTRA MV	ULTRA HV	ULTRA GEL	REPAIR	STRUCTURAL	FLEX	LIGHT LOCK MV	LIGHT LOCK HV	LIGHT LOCK GEL
<b>ABS</b> Acrylonitrile-butadiene-styrene	***	***	***	***	***	***	***	***	***	***
<b>PC</b> Polycarbonate	***	***	***	**	***	***	***	***	***	***
<b>PC/ABS</b> Blend of PC and ABS	***	***	***	**	***	***	***	***	***	***
<b>PE</b> Polyethylene	** (with Primer)	** (with Primer)	** (with Primer)	** (with Primer)	** (with Primer)	** (with Primer)	** (with Primer)	** (with Primer)	** (with Primer)	** (with Primer)
<b>PMMA</b> Poly(methyl methacrylate)	***	***	***	***	***	***	***	***	***	***
<b>PP</b> Polypropylene	** (with Primer)	** (with Primer)	** (with Primer)	** (with Primer)	** (with Primer)	** (with Primer)	** (with Primer)	** (with Primer)	** (with Primer)	** (with Primer)
<b>PPO</b> Poly(phenylene oxide)	** (with Primer)	** (with Primer)	** (with Primer)	** (with Primer)	** (with Primer)	** (with Primer)	** (with Primer)	** (with Primer)	** (with Primer)	** (with Primer)
<b>PS</b> Polystyrene	**	**	**	**	*	**	**	**	**	**
<b>PS</b> Polystyrene (with Primer)	*** (with Primer)	*** (with Primer)	*** (with Primer)	*** (with Primer)	*** (with Primer)	*** (with Primer)	*** (with Primer)	*** (with Primer)	*** (with Primer)	*** (with Primer)
<b>PU</b> Polyurethane	** (with Primer)	** (with Primer)	** (with Primer)	** (with Primer)	** (with Primer)	** (with Primer)	** (with Primer)	** (with Primer)	** (with Primer)	** (with Primer)
<b>PVC</b> Polyvinyl chloride	***	***	***	***	***	***	***	***	***	***
<b>TPU</b> Thermoplastic polyurethane	** (with Primer)	** (with Primer)	** (with Primer)	** (with Primer)	** (with Primer)	** (with Primer)	** (with Primer)	** (with Primer)	** (with Primer)	** (with Primer)
<b>AL</b> Aluminum	**	**	**	**	**	***	**	**	**	**
<b>Coated AL</b> Powder coated or anodized aluminum	**	**	**	**	**	***	**	**	**	**
<b>GL</b> Glass	**	**	**	**	**	***	**	*	*	**
<b>Si</b> Silicone	** (with Primer)	** (with Primer)	** (with Primer)	** (with Primer)	** (with Primer)	** (with Primer)	** (with Primer)	** (with Primer)	** (with Primer)	** (with Primer)
<b>SUS</b> Stainless steel	***	***	***	***	***	***	***	***	***	***
<b>Mild Steel</b>	***	***	***	***	***	***	***	***	***	***
<b>GBMS</b> Grit blasted mild steel	***	***	***	***	***	***	***	***	***	***

**Compatibility:** \* Moderate \*\* Good \*\*\* Excellent



### BEST PRACTICE BONDING

## Substrate and Surface Preparation

The nature of the substrate and its surface impacts the bondline performance.

- The surface must be cleaned with the appropriate cleaner to eliminate surface contaminants and increase wettability before applying the adhesives. We recommend **Bostik Cleaner**, or, as a minimum, an alcohol wipe.
- Mechanical pretreatment (sanding, grinding, laser etching, etc.) will eliminate surface contaminants and increase surface roughness to enhance bonding performance.
- Bonding performance can vary depending on the surface energy of the substrate. Applying **Born2Bond™ Primer** will improve adhesion on low surface energy substrates (< 38 mN/m) (e.g. plastics, PPE).
- Fixture time varies with different types of substrates. Applying **Born2Bond™ Booster** will accelerate fixture time on acidic and porous substrates.



## Service Conditions

The performance of the adhesive is driven by the service conditions and stress that the bondline will be exposed to:

- **Load:** cyclical or steady
- **Temperature:** cyclical or steady
- **Chemicals:** motor oil, solvents, etc.
- **Humidity:** constant or accidental

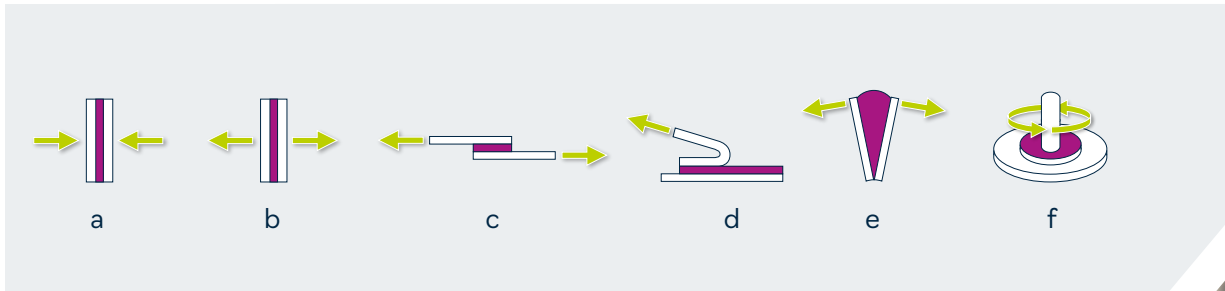
Please refer to our product selector and technical data to choose the right product.

## Designing with Adhesives

There are five major types of stress that affect the bondline (see diagram below).

### Types of Stresses

- a: Compression
- b: Tension
- c: Shear
- d: Peel
- e: Cleavage
- f: Torsional

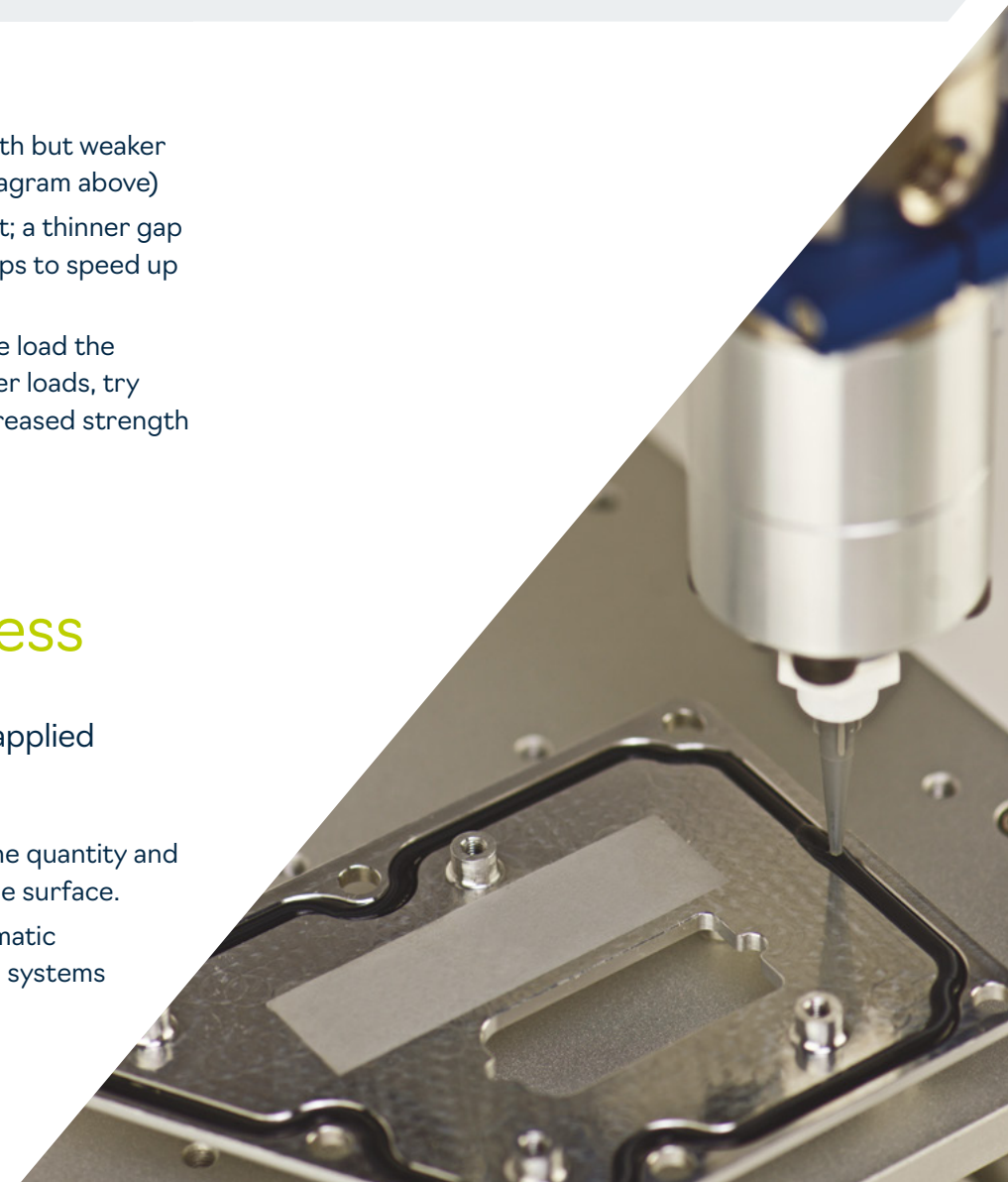


- Adhesives are strong in shear strength but weaker in peel and cleavage strength (see diagram above)
- Consideration of the gap is important; a thinner gap provides a stronger bondline and helps to speed up curing time
- Joints must be designed based on the load the bondline will be exposed to. For higher loads, try to maximize the bonding area for increased strength

## Application Process

The method in which adhesive is applied impacts bondline performance.

- Bondline performance depends on the quantity and consistency of adhesive applied to the surface.
- Adhesives can be applied using automatic dispensing equipment and/or manual systems (e.g. syringes, guns, bottles).
- Fully automated systems will improve the control and speed of dispensing.



## PRODUCT FEATURES

The list of features in this table will help you identify which products best match your needs.

	ULTRA LV	ULTRA MV	ULTRA HV	ULTRA GEL	REPAIR (4:1)	STRUCTURAL (4:1)	FLEX (4:1)	LIGHT LOCK MV	LIGHT LOCK HV	LIGHT LOCK GEL
<b>CHEMISTRY</b>	MECA	MECA	MECA	MECA	ECA (A) Plasticizer (B)	Blend MECA-ECA	MECA (A) Plasticizer (B)	MECA	MECA	MECA
<b>APPEARANCE</b>	Transparent	Transparent	Transparent	Transparent	Whitish	Transparent	Transparent	Transparent greenish	Transparent yellowish	Transparent yellowish
<b>VISCOSITY (cP) 25°C (77°F)</b>	20 - 50	120 - 170	700 - 1,000	105,000 - 120,000	Part A: 130,000 - 180,000 Part B: 70,000 - 130,000	Part A: 100,000 - 150,000 Part B: 40,000 - 80,000	Part A: 120,000 - 170,000 Part B: 70,000 - 130,000	180 - 220	600 - 900	30,000 - 45,000
<b>OPEN TIME</b>	N/A	N/A	N/A	N/A	4 - 10 min	25 min	6 - 10 min	N/A	N/A	N/A
<b>TEMPERATURE USE RANGE</b>	-40°C up to +80°C	-40°C up to +80°C	-40°C up to +80°C	-40°C up to +80°C	-40°C up to +80°C	-40°C up to +120°C	-40°C up to +60°C	-40°C up to +80°C	-40°C up to +80°C	-40°C up to +80°C
<b>FIXTURE TIME (S) - MILD STEEL</b>	5	5	5	5	5	15	30	10	10	10
<b>FIXTURE TIME (S) - ABS</b>	10	10	10	10	30	35	45	10	20	20
<b>FIXTURE TIME (S) - PC</b>	15	20	25	20	30	40	60	15	30	40
<b>TENSILE STRENGTH (MPA) (GBMS)</b>	14	13	11	13	14	14	10	8	6	5
<b>ELONGATION AT BREAK (%)</b>	N/A	N/A	N/A	N/A	12	16	259	N/A	N/A	N/A
<b>IMPACT RESISTANCE (AFTER 24H) (KJ/M<sup>2</sup>) ISO 9653</b>	9.4	9.5	9	6.4	15	27	21	14.1	13	16.3

ECA: ethoxyethyl cyanoacrylate MECA: methoxyethyl cyanoacrylate



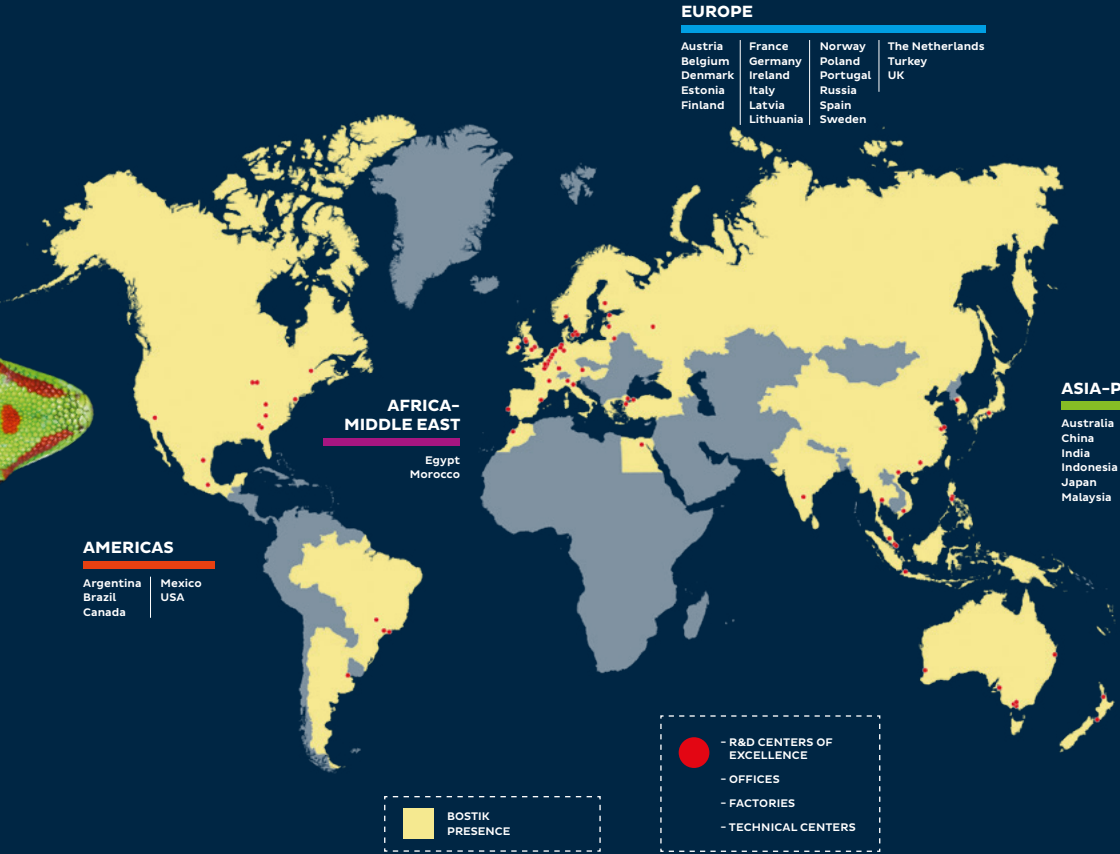
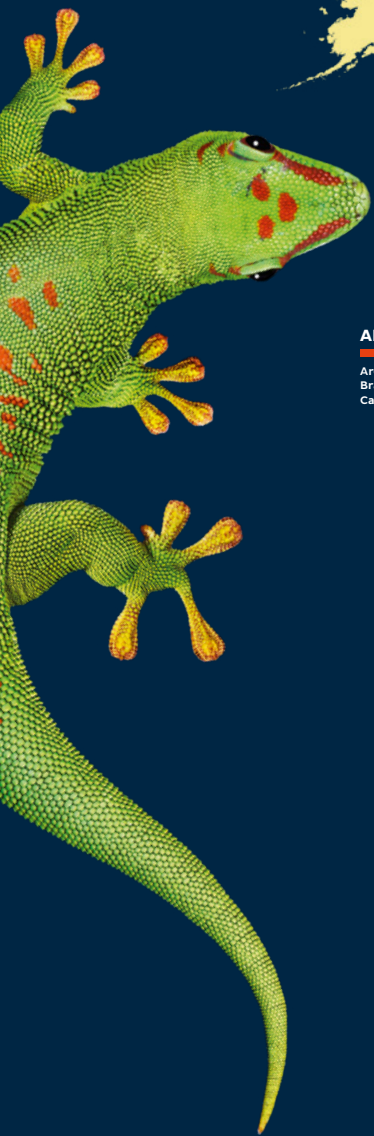
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