

INSTANT ADHESIVE LIQUID • MULTI-PURPOSE BONDING

PART NO. CA30

DESCRIPTION

CA30 is a low viscosity, rapid curing, instant adhesive. It is designed to bond a wide range of similar and dissimilar materials. Handling strength in most applications is in 5 to 10 seconds. Can be post applied.

PHYSICAL PROPERTIES

| Technology / Base | Modified Ethyl | | | |
|--------------------|----------------|--|--|--|
| Type of Product | Cyanoacrylate | | | |
| Components | One Component | | | |
| Curing | Humidity | | | |
| Appearance / Color | Colorless | | | |
| Consistency | Liquid | | | |

TECHNICAL DATA

| I EVIIII VAE DAIA | | | | | | | | |
|--|----------------------------------|-----------------------------|--|--|--|--|--|--|
| Property | Value | Method/Condition | | | | | | |
| Rheology | | | | | | | | |
| Viscosity | 30 +/- 10 cPs | Brookfield SC4-27 @ 25°C | | | | | | |
| Density | | | | | | | | |
| Specific Gravity | 1.05 | N/A | | | | | | |
| Uncured Materials Characteristics | | | | | | | | |
| Flash Piont Set Time ABS (sec) EPDM (sec) Shelf Life | <10 | N/A N/A N/A N/A | | | | | | |
| Cured Materials Characteristics | | | | | | | | |
| Full Cure Time Cure Appearance Service Temperature | 24 hours Clear -55 to 95°C | N/A N/A N/A | | | | | | |
| Cured Mechanical Propert | ies | | | | | | | |
| See Graphs and Table | | | | | | | | |



INSTRUCTIONS

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 that one minute and maximum strength is attained in 24 hours. Wipe off excess adhesive from the top of the container and recap. Products, if left uncapped, may deteriorate by contamination from moisture in the air. Because products cure by polymerization, whitening may appear on the surface of the container or the bonded materials. This will not affect adhesive performance. Factors affecting cure speed include gap size and humidity. Thin bond line results in faster cure speed. Larger gaps will lengthen cure speed. Cure and fixture times can be influenced by the humidity conditions at the time of assembly. The higher the RH the faster cure and fixture times will be. Fixture time data based on our testing is conducted at 50% relative humidity.

CURING PERFORMANCE

Ambient surface moisture initiates the curing process. Handling strength is reached in a short time, and will vary based on environmental conditions, bond line gap, and other factors. Product will continue to cure for at least 24 hours before full strength and solvent resistance is developed.

STORAGE

Containers should be stored in a cool, dry, dark area. Storage temperature 15.5°C - 25°C (60°F - 77°F), without exposure to direct light or heat. Do not refrigerate.

SPECIFICATIONS AND APPROVALS

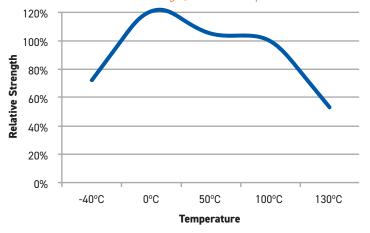
Mil-A-46050C, Type II Class 1, CID A-A-3097, Type II Class 1

SAFETY & DISPOSAL

For safe handling information and disposal instructions on this product, consult the Safety Data Sheet (SDS).



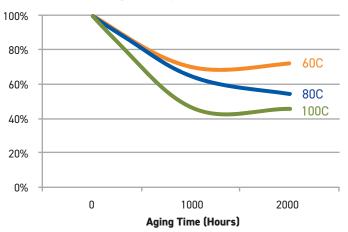
HOT STRENGTH %RT Strength, Tested at Temperature



SOLVENT RESISTANCE

| Solvent | Resistance |
|---------------------------------|----------------------------------|
| Alcohol | Excellent |
| Ester (aromatic) | Excellent |
| Ketone (aromatic) | Poor |
| Aliphatic hydrocarbon (alkanes) | Good |
| Aromatic hydrocarbons | Good |
| Halogenated hydrocarbons | Poor |
| Weak aqueous acid | Excellent (Poor if concentrated) |
| Weak aqueous base | Excellent (Poor if concentrated) |

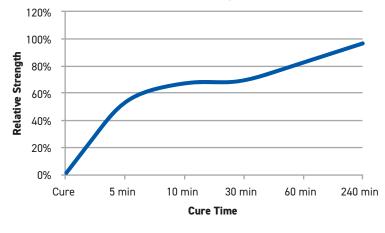
HEATING AGING Aged at Temperature Indicated & Tested at 22°C



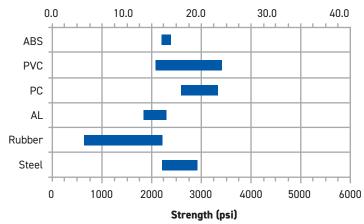
PERFORMANCE OF CURED ADHESIVE

| Substrate | N/mm² | | | PSI | | | | |
|---|-------|----|------|------|----|------|--|--|
| Steel | 15.2 | to | 20.1 | 2200 | to | 2920 | | |
| Rubber* | 4.3 | to | 15.2 | 630 | to | 2200 | | |
| AL | 12.6 | to | 15.8 | 1830 | to | 2290 | | |
| PC** | 17.9 | to | 22.9 | 2590 | to | 3320 | | |
| PVC** | 14.2 | to | 23.4 | 2065 | to | 3400 | | |
| ABS** | 15.1 | to | 16.4 | 2185 | to | 2375 | | |
| *Rubber figures given are typical. Your results may vary by specific rubber type. | | | | | | | | |

TIME UNTIL FULL CURE %RT Strength



PERFORMANCE RANGE BY SUBSTRATE (N/mm²)



DISCLAIMER

IMPORTANT: The information, specifications, procedures and recommendations herein (together "information") are based on our experience and we believe these to be accurate. No representation, guarantee or warranty is made as to the accuracy or completeness of the information or that the information will avoid losses or damages or give desired results. It is user's sole responsibility to test and determine the suitability of any product for the intended use. Tests should be repeated if materials or conditions change in any way. The user is advised to review the specific context of the intended use to determine whether the user's intended use violates any law or infringes upon any patent(s). No employee, distributor or agent has any right to change these facts and offer a guarantee of performance.

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TDS - Instant Adhesive - CA30 - Updated 11-10-2021



