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**TECHNICAL DATA SHEETS**  
**RP GEL**

**Description:**

The **ADVANCED PERFORMANCE SERIES** or the APS family of products have been specifically designed to meet rigorous demands of today's product assembly requirements. These products are single component, solvent free systems. They cure at room temperature and are rapid setting materials normally curing in just a matter of seconds. They are available in various viscosities and setting times to meet your specific applications needs. The **ADVANCED PERFORMANCE SERIES** has been formulated to bond a wide range of similar and dissimilar materials.

**RP GEL** is a fast setting, Cyanoacrylate adhesive gel.

**Properties:**

CHEMICAL TYPE: Ethyl Cyanoacrylate  
APPEARANCE: Clear liquid  
SPECIFIC GRAVITY: 1.05 @ 25°C  
VISCOSITY: GEL  
FLASH POINT: > 176°F (80°C)  
GAP FILLING: up to 0.05 inches

**Typical Environmental Resistance:**

CURE PROCEDURE: One week at 22°C  
SUBSTRATE: Grit Blasted Mild Steel  
PROCEDURE: ASTM D1002/DIN 53283

CHEMICAL / SOLVENT RESISTENCE SOLVENT	AGED TEMP.	(Tested @ 22° C ) % INITIAL STRENGTH RETAINED		
		100 HRS.	500 HRS.	1000HRS
MOTOR OIL	40 ° C	85	85	75
LEADED PETROL	22 ° C	100	100	100
ETHANOL	22 ° C	100	100	100
ISOPROPANOL	22 ° C	100	100	100
FREON TA	22 ° C	100	100	100
HUMIDITY 95% RH	40° C	65	55	50
HUMIDITY 95% RH (Polycarbonate)	40° C	100	100	100

The RP GEL cure speed will be dependent upon the substrate used. The table below shows the fixture time achieved on different substrates at 22° C with 50% relative humidity

TIME TO DEVELOP SHEAR STRENGTH OF 0.1 N/MM<sup>2</sup> (14.5 psi)

SUBSTRATE	FIXTURE TIME (sec)
STEEL	4 to 19
PHENOLIC MATERIAL	2 to 9
POLYCARBONATE	9 to 39
P V C	2 to 9
ABS	2 to 9
NITRILE RUBBER	< 4
NEOPRENE	< 4
ZINC DICHROMATE	9 to 19
ALUMINIUM	2 to 9

**TYPICAL PROPERTIES OF CURED MATERIAL Physical Properties**

Coefficient of thermal expansion: ASTM C696,  $K^{-1}$   $80 \times 10^{-6}$   
Coefficient of thermal conductivity: ASTM C177,  $W, m^{-1} K^{-1}$  0.1  
Glass Transition temperature: ASTM E228 25°C 120

**Engineering Excellence**

For technical information  
and support call **1-800-552-0299** or visit our website at

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