



ADHESIVES Technical Data Bulletin

CYANOACRYLATES

MAXI-CURE: General Purpose—Thick, 10-25 second CA is best for most plastics and is the best choice for model assembly. When used with INSTA-SET it will fill most voids. It can be carved with a knife or blade and sanded to form a finish indistinguishable from plastic. Its thickness makes MAXI-CURE easier to work with for most applications. Set Up: 5-15 seconds.

INSTA CURE: CA adhesive with *water-thin* viscosity that will wick deep into joints by capillary action and cures within a few seconds. Surfaces to be bonded need to be tight fitting. Good for high porosity surfaces, will wick into substrate quickly. Great for coating 3D printed part, like Z-Corp printed parts.

INSTA CURE+: Thicker for Gap Filling applications—Higher viscosity CA for loose fitting joints in which the adhesive must bridge gaps. Normally, the thicker CA is applied to surface and then the parts are held tightly together for about 5 to 15 seconds. For large surface areas, including those with close fitting joints such as laminations, INSTA CURE+ should also be used. To prevent premature curing, don't spread the glue into a thin film. Lay down a serpentine bead with about 1" separations on one surface, and then assemble the parts, letting the pressure spread the CA out.

INSTA-SET: Accelerator that allows CA's to quickly cure in thick layers by enhancing the alkaline conditions during polymerization. Applying an additional bead of MAXI-CURE along the seam and then curing it with INSTA-SET significantly enhances a joint's strength. For difficult to bond materials, INSTA-SET can be applied to one surface and CA to the opposite surface. When brought together, they will bond instantly. INSTA-SET is 100% foam safe and can be used on clear plastics.

IC 2000: A rubber toughened cyanoacrylate that forms shock resistant bonds on non-porous surfaces. It has added flexibility for the bonding of metals, fiberglass, rubber and carbon fiber. Setup time is 20-40 seconds and can be accelerated with INSTA-SET.

EPOXIES

QUIK-CURE 5min: Two-Part (50/50 Mix Ratio) epoxy which sets in 5 minutes and can be handled in 15 minutes. For full bond strength wait 1-2 hours. This material is compatible with most surfaces and can be sanded to finish.

SILICONES

RTV 4500: One-part, translucent Acetoxysilane cure silicone adhesive for bonding and repairing silicone rubber. Great for bonding surfaces where heat resistance is needed and for repairing RTV molds. Apply under 1/4" inch thick. 10min Gel/ 24hr Cure.

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