



BCC PRODUCTS, INC.

BLEHM PLASTICS

FAST CAST – EPOXIES – ADHESIVES - POLYSULFIDES - URETHANES – POLYESTER PASTES – TOOLING BOARDS – RELEASE AGENTS – SILICONES

BC100 Thin

Cyanoacrylate Adhesive

BC100 Thin is a low viscosity material ideal for bonding larger areas. BC100 Thin has a 20 second fixture cure and able to fill gaps of .002” wide. BC100 Thin is perfectly designed for bonding plastic parts and other substrates like Stainless Steel, Neoprene and ABS and even Nitrile Rubber.

BONDING SCHEDULES

Stainless Steel: 10-20 seconds
Polycarbonate: 20-40 seconds
Neoprene: < 5 seconds
PVC: < 5 seconds

ABS: 10-20 seconds
PVC: 20-50 seconds
Phenolics: 10-20 seconds
Nitrile Rubber: 5 – 7 seconds

PHYSICAL PROPERTIES

Composition:	Ethyl Cyanoacrylate Adhesive
Appearance:	Colorless liquid
Viscosity@ 25°C (Brookfield LVF, Spindle 1-60 rpm):	2-5cps
Glass Transition Temperature, (ASTM E228, °C):	120
Dielectric Strength, (ASTM D149):	625 v/mil
Coefficient of thermal expansion, (ASTM D696): K ⁻¹	90 x 10 ⁻⁶
Coefficient of thermal conductivity, (ASTM C177, W.m ⁻¹ K ⁻¹):	0.1

Cured Adhesive

Gap Filling:	0.05 mm
Tensile Shear Strength:	15-26 n/mm ²
Service Temperature Range:	-60 to +80oC
Full Cure:	24 hours
Melting Point Temperature:	160 to 170oC

Shear Strength, ASTM D1002/DIN 53283

Grit Blasted Steel:	14 – 22 N/mm ²
Neoprene Rubber:	10 – 15 N/mm ²
PVC:	3 – 9 N/mm ²
Etched Aluminum:	10 – 15 N/mm ²
Polycarbonate:	5 – 10 N/mm ²

Application Instructions

- All surfaces must be clean, dry, dust and grease free. Best result will be achieved with surfaces that have been lightly abraded immediately prior to bonding.
- If using accelerator apply to one component surface only. Apply thin film of adhesive to the other surface and bring the pieces together immediately. Hold for few seconds without disturbing the joints.
- Thin bond lines favor high cure speed. Increasing the bond gap will slow down the rate of cure.

NOTE: The information contained herein is believed to be reliable. All recommendations are made without guarantee inasmuch as conditions and methods of commercial use are beyond our control. Properties given are typical values and are not intended for use in preparing specifications.

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