

# SICOMET<sup>®</sup>

## Sicomet<sup>®</sup> 9020

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### PRODUCT DESCRIPTION

Sicomet<sup>®</sup> 9020 provides the following product characteristics:

<b>Technology</b>	Cyanoacrylate
<b>Chemical Type</b>	Ethyl cyanoacrylate
<b>Appearance</b>	Clear, Colorless
<b>Components</b>	One part - requires no mixing
<b>Cure</b>	Humidity
<b>Application</b>	Bonding
<b>Key Substrates</b>	Plastics, Rubbers and Metals

Sicomet<sup>®</sup> 9020 is a low odor and low blooming instant adhesive based on Methoxyethyl-2-cyanoacrylate with a high viscosity. The product is designed for the fast bonding of a diverse range of plastics where good visual appearance is important as it cures with almost no white blooming typical of normal instant adhesives. The high viscosity allows gap bridging up to 0.2 mm. Sicomet<sup>®</sup> 9020 is particularly suited for bonding porous or absorbent materials such as paper, leather and fabrics. The product can be used up to +70 °C operation temperature and at short-term load up to +80 °C.

### TYPICAL PROPERTIES OF UNCURED MATERIAL

Density, ISO 12185, g/cm <sup>3</sup>	1.05 to 1.1
Viscosity @ 20 °C, mPa·s (cP)	
Cone & Plate Rheometer	900 to 1,700
Viscosity, Brookfield, 20 °C, mPa·s (cP):	
Spindle 3, speed 100 rpm	900 to 1,800
Flash Point - See MSDS	

### TYPICAL CURING PERFORMANCE

Under normal conditions, the atmospheric moisture initiates the curing process. Although full functional strength is developed in a relatively short time, curing continues for at least 24 hours before full chemical/solvent resistance is developed.

#### Cure Speed vs. Substrate

The rate of cure will depend on the substrate used. The table below shows the fixture time achieved on different materials at 22 °C / 50 % relative humidity. This is defined as the time to develop a shear strength of 0.1 N/mm<sup>2</sup>.

Fixture Time, seconds:	
Aluminum	30 to 100
EPDM	8 to 20
Rubber, nitrile	5 to 20
ABS	5 to 10
Polycarbonate	10 to 70

### TYPICAL PERFORMANCE OF CURED MATERIAL

After 72 hours @ 22 °C

Lap Shear Strength, ISO 4587:

Steel (grit blasted)	N/mm <sup>2</sup> 14 to 22 (psi) (2,030 to 3,190)
Aluminum (grit blasted)	N/mm <sup>2</sup> 9 to 18 (psi) (1,300 to 2,610)

Zinc dichromate	N/mm <sup>2</sup> 3 to 9 (psi) (430 to 1,300)
PVC	N/mm <sup>2</sup> 5 to 8 (psi) (720 to 1,160)
Polycarbonate	N/mm <sup>2</sup> 4 to 12 (psi) (580 to 1,740)
Polyamide (6.6)	N/mm <sup>2</sup> 2 to 8 (psi) (290 to 1,160)

Tensile Strength, ISO 6922:

Nitrile	N/mm <sup>2</sup> >5 (psi) (720)
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After 24 hours @ 22 °C

Tensile Strength, ISO 6922:

EPDM	N/mm <sup>2</sup> 1.8 to 2.2 (psi) (260 to 320)
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After 7 days @ 70 °C

Tensile Strength, ISO 6922:

EPDM	N/mm <sup>2</sup> 0.4 to 1.0 (psi) (60 to 145)
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After 10 seconds @ 22 °C

Tensile Strength, ISO 6922:

Nitrile	N/mm <sup>2</sup> ≥4 (psi) (580)
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### GENERAL INFORMATION

**This product is not recommended for use in pure oxygen and/or oxygen rich systems and should not be selected as a sealant for chlorine or other strong oxidizing materials**

**For safe handling information on this product, consult the Material Safety Data Sheet (MSDS).**

#### Directions for use:

1. For best performance bond surfaces should be clean and free from grease.
2. This product performs best in bond gaps up to 0.2 mm.
3. Excess adhesive can be wiped away with organic solvent.

#### Not for product specifications

The technical data contained herein are intended as reference only. Please contact your local quality department for assistance and recommendations on specifications for this product.

**Storage**

Store product in the unopened container in a dry location. Storage information may be indicated on the product container labeling.

**Optimal Storage: 2 °C to 8 °C. Storage below 2 °C or greater than 8 °C can adversely affect product properties.**

Material removed from containers may be contaminated during use. Do not return product to the original container. Henkel Corporation cannot assume responsibility for product which has been contaminated or stored under conditions other than those previously indicated. If additional information is required, please contact your local Technical Service Center or Customer Service Representative.

**Conversions**

$(^{\circ}\text{C} \times 1.8) + 32 = ^{\circ}\text{F}$

$\text{kV/mm} \times 25.4 = \text{V/mil}$

$\text{mm} / 25.4 = \text{inches}$

$\mu\text{m} / 25.4 = \text{mil}$

$\text{N} \times 0.225 = \text{lb}$

$\text{N/mm} \times 5.71 = \text{lb/in}$

$\text{N/mm}^2 \times 145 = \text{psi}$

$\text{MPa} \times 145 = \text{psi}$

$\text{N}\cdot\text{m} \times 8.851 = \text{lb}\cdot\text{in}$

$\text{N}\cdot\text{m} \times 0.738 = \text{lb}\cdot\text{ft}$

$\text{N}\cdot\text{mm} \times 0.142 = \text{oz}\cdot\text{in}$

$\text{mPa}\cdot\text{s} = \text{cP}$

**Note**

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Reference 0.1