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NO – Low Odor Cyanoacrylate

Pacer Technology NO-150 Series cyanoacrylate adhesive is a medium viscosity, low blooming and low odor product. It assists in reducing frosting or chlorosis of exposed parts after application. It can be used for bonding a variety of plastics, metals and rubbers where appearance is critical. NO-150 has excellent strength characteristics.

PROPERTIES:

<u>LIQUID STATE</u>	NO-150 Adhesive
Chemical Base	Alkoxy-ethyl cyanoacrylate
Viscosity	100-200 cps
Color	Clear, transparent liquid
Vapor Pressure (@77 ⁰ F, mmHg)	<0.5mm
Specific Gravity (@77 ⁰ F)	1.08 - 1.10
Flashpoint TCC ⁰ F (⁰ C)	>178 F (>81 C)
Soluble In:	Acetone, MEK, Nitromethane

<u>CURED STATE</u>	NO-150 Adhesive
Typical Bond Thickness	.002"
Service Temperature Range	-65 to 175 ⁰ F (-54 to 79 ⁰ C)
Soluble In:	Pacer X-9 Debonder, Acetone, Nitromethane
Tensile Shear Strength, psi	
Steel	2400 (±10%)
Aluminum	>1400 (±10%)
Tensile Strength, psi	
Steel	>2200 (±10%)

STORAGE AND SHELF LIFE:

Refrigerate unopened cyanoacrylate @ 40F (4C) for optimum results. Allow adhesive to reach room temperature before opening. Once opened, store in a cool, dry location between 50 to 72F. Stored under these conditions, a one-year shelf life can be expected.



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APPLICATION AND CURE CHARACTERISTICS:

For best results, parts should be clean, free from oil and grease or other contaminants. Apply adhesive to one surface to be bonded and mate the other surface to it carefully and without delay. For best results, use a minimal amount of adhesive. In general, one free-falling drop covers one square inch of bond area. Avoid over-application, as excess adhesive is difficult to remove from unwanted areas. Fixture time occurs in 1-5 minutes with 80% of full strength developing in 15-30 minutes. Fixture time and full cure rates are dependent upon temperature, relative humidity, bondline thickness, and substrates being bonded. To speed full cure through larger gaps, Pacer accelerators for instant adhesives are compatible and can be used. Post application of accelerators to exposed adhesive may cause a white frosting (chlorosis) of the exposed adhesive onto parts, which can usually be removed using Pacer X-9 Debonder and a cotton swab. Overall cure strength can be decreased as a result of using accelerators. Testing on actual parts is recommended.

SAFETY AND HANDLING PRECAUTIONS:

Cyanoacrylate adhesives bond skin in seconds. In case of skin contact, flush with water. If skin becomes bonded, peel (not pull) apart after immersion in warm, soapy water. In case of eye or mouth contact, flush with water; get immediate medical attention. Use with adequate ventilation. Vapors can irritate eyes and mucous membranes. Symptoms disappear after removal of individual from vapors.

For more information, refer to Material Safety Data Sheet, available upon request. In case of emergency, call CHEMTREC at (800) 424-9300 or call Pacer Technology at (800) 538-3091 (outside CA only), or (909) 987-0550.

Part Number: FG04120 (20 g)
FG04123 (1 lb)

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