

PRODUCT DATA SHEET

Casco[®] Express Lim

General Cyanoacrylate adhesive with fast setting, and good flow ability.

DESCRIPTION

Good adhesion to wood, porcelain, glass, ceramics, leather, metal, etc.

USES

When a thin layer of ExpressLim applied between two surfaces comes into contact with atmospheric moisture, a rapid polymerization occurs producing the ultimate bond.

CHARACTERISTICS / ADVANTAGES

- High initial strength
- Adheres directly
- Especially good adhesion to well mated, non-porous surfaces, such as rubber O-rings as well as other rubber and plastics parts
- Good choice when bonding between two tight materials
- Good choice for small applications
- Very good long term performance

PRODUCT INFORMATION

Composition	Ethyl Cyanoacrylate	
Packaging	5 gr Bottle with brush	
Colour	Transparent, colorless to yellowish liquid	
Shelf life	At least one year in closed packages in room temperature.	
Storage conditions	Keep products in the unopened container in a cool and dry location. Best when stored at 2 to 8 °C. Temperatures less than 2 °C can adversely affect product properties. Do Not Freeze.	
Density	Approx. 100 kg/m ³	(ISO 1183-1)
Volatile organic compound (VOC) content	None	
Consistency	Low viscous	
Service temperature	-30 °C to +100 °C	
Ambient air temperature	+5 °C - +25 °C	

BASIS OF PRODUCT DATA

All technical data stated in this Product Data Sheet are based on laboratory tests. Actual measured data may vary due to circumstances beyond our control.

FURTHER INFORMATION

LIMITATIONS

“Greasy” plastics like polyethylene, polypropylene and Teflon cannot be glued.

HANDLING AND CLEANING INSTRUCTIONS

When working with adhesive, cleanliness must be observed. Therefore always work carefully and systematically in order to avoid unnecessary spillage. Clean tools and dried adhesive spots with acetone, Casco Limtvätt or similar. Dried adhesives have to be removed mechanically. On skin, uncured adhesive is wiped off with a rag, then wash with soap and water.

ECOLOGY, HEALTH AND SAFETY

For information and advice on the safe handling, storage and disposal of chemical products, users shall refer to the most recent Safety Data Sheet (SDS) containing physical, ecological, toxicological and other safety-related data.

APPLICATION INSTRUCTIONS

SUBSTRATE PREPARATION

SURFACE PREPARATION

Joint interface must be clean, dry and free from oils, loose aggregates, laitance, release agents, waterproofing and other contaminants. Clean with Acetone if necessary.

SUBSTRATE/CURING SPEED

Steel to Steel 10–30 seconds
Stainless Steel 30–60 seconds
Aluminum 5–15 seconds
Zinc plated 30–90 seconds
ABS to ABS 5–20 seconds
ABS to NBR 3–5 seconds
ABS to Wood 5–10 seconds
NBR to NBR 5–10 seconds
Wood 60–75 seconds
Polycarbonate 20–60 seconds
Leather 30–60 seconds

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DIRECTIONS FOR USE

Dispense a drop or drops to one surface only. Apply only enough to leave a thin film after compression. Press parts together and hold firmly for a few seconds. Good contact is essential. An adequate bond develops in less than one minute. (Maximum strength is achieved in 24 to 48 hours). Wipe off excess adhesive from the top of the container and recap. If left uncapped, may deteriorate by contamination from moisture in the air. Because Casco® Express Lim condenses by polymerization, sometimes whitening will occur on the surface of the container.

LOCAL RESTRICTIONS

Please note that as a result of specific local regulations the declared data for this product may vary from country to country. Please consult the local Product Data Sheet for the exact product data.

LEGAL NOTES

The information, and, in particular, the recommendations relating to the application and end-use of Casco products, are given in good faith based on Sika's current knowledge and experience of the products when properly stored, handled and applied under normal conditions in accordance with Sika's recommendations. In practice, the differences in materials, substrates and actual site conditions are such that no warranty in respect of merchantability or of fitness for a particular purpose, nor any liability arising out of any legal relationship whatsoever, can be inferred either from this information, or from any written recommendations, or from any other advice offered. The user of the product must test the product's suitability for the intended application and purpose. Sika reserves the right to change the properties of its products. The proprietary rights of third parties must be observed. All orders are accepted subject to our current terms of sale and delivery. Users must always refer to the most recent issue of the local Product Data Sheet for the product concerned, copies of which will be supplied on request or on the website www.casco.eu.

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