

## PRODUCT DATA SHEET

# Casco<sup>®</sup> Express Gel

NON-RUNNING QUICK GLUE FOR SMALL, DIFFICULT REPAIRS.

### DESCRIPTION

Does not flow, ideally for quick gliding on vertical surfaces.

For bonding both porous and non-porous materials.

### USES

Especially intended for small objects of metal, stone, porcelain, ceramics, rubber, rigid plastics, wood, cork, leather e.g.

### CHARACTERISTICS / ADVANTAGES

- Gel consistency
- Slower fixturing speed allows ample time for long open applications and appl. requiring repositioning
- Specially formulated for applications involving vertical structures and overhead assembly
- Good choice when bonding between porous materials
- Good choice for small applications

### PRODUCT INFORMATION

Composition	Ethyl Cyanoacrylate
Packaging	3 g blistered tube
Colour	Slightly cloudy, colorless to yellowish gel.
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. Keep container tightly closed until ready for use.
Density	Approx. 1050 kg/m <sup>3</sup>
Solid content by weight	100 %
Volatile organic compound (VOC) content	None
Consistency	Low viscous, gel-like

**Tensile Strength****Tensile strength after 24h at 25 °C****Kg/cm<sup>2</sup>**

Steel	180 - 250
Stainless steel	250 - 450
Aluminium	110 - 190
Copper	130 - 170
ABS	50 - 150
Polycarbonate	45 - 150
Polystyrene	40 - 130
NBR	50 - 110
SBR	50 - 100

**Chemical Resistance**

The bond is moisture-resistant and withstands a short-term influence of water. A long-term influence of water should be avoided. The bond has a good resistance to solvents and normal household chemicals.

**Service Temperature**

-30 °C to +100 °C

**APPLICATION INFORMATION****Consumption**

One drop for 3-5 cm<sup>2</sup>

**Product Temperature**

+5 °C - +25 °C.

**Curing Time****Substrate****Curing speed in seconds**

Steel to Steel	50 - 100
Stainless steel to Stainless steel	60 - 120
Aluminium to Aluminium	10 - 30
Zink plated steel to Zink plated steel	40 - 90
ABS plastic to ABS plastic	10 - 60
Nitril rubber to Nitril rubber (NBR)	5 - 20
Polycarbonate to polycarbonate	40 - 80
ABS to Wood	15 - 25

There are many factors that can influence the rate of cure. These include: the types of substrate used, the condition of the surface to be bonded, the smoothness of the surface, the closeness of the surfaces, the atmospheric conditions etc.

**Open Time**

Approx. 15-90 sek

**APPLICATION INSTRUCTIONS****SUBSTRATE 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 or/and roughening of the surfaces with a fine abrasive paper is recommended. Remove the dust.

**APPLICATION METHOD / TOOLS**

Direct the tube away from you. Unscrew the whole plastic tightening. Release the red secure ring. Fasten the tightening. Take off the upper nozzle. Apply adhesive thin on one of the surfaces. Dispense a drop or drops to one surface only. Apply only enough to leave a thin film after compression. Too much adhesive will increase the hardening time and will also influence negatively on the final glue-line strength.

After application of adhesive press the surfaces together in right position and keep them so for 15-90 seconds depending on the materials. Maximum strength will be obtained within 24 hours. 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 ExpressLim condenses by polymerization, sometimes whitening will occur on the surface of the container

**LIMITATIONS**

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

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## CLEANING OF EQUIPMENT

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.

## 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.

## 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.

## 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.

## 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](http://www.casco.eu).

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