

# SikaBond-® F40

Instant setting ethyl cyanoacrylate based,  
low viscosity, adhesive

Construction

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**Product Description** Low viscosity, ethyl cyanoacrylate based instant setting adhesive where very fast cure speed is required.

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**Uses**

- As an instant setting adhesive for small bonding jobs such as bonding most metals, plastics, rubber, leather, wood and other materials. It is especially suitable for bonding pieces with very smooth surfaces.
- Small repairs to glasses, shoe soles, picture frames, ceramics, toys and small electronic equipment, etc.

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**Characteristics / Advantages**

- One Component
- Easy to apply, low viscosity
- Very rapid, tenacious bond to numerous substrates, e.g., plastics, rubber, metals, wood, ceramics, leather
- Low consumption adhesive
- Versatile, allows adhesion between different materials
- Colourless
- Durable

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## Product Data

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**Form**

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**Colour** Clear

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**Packaging**

Bottle:	20 g
Bottle:	5 g
Bottle with Brush:	5 g

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**Storage**

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**Storage Conditions / Shelf-Life** 12 months from date of production if stored in unopened and undamaged, original sealed containers, in dry conditions and protected from direct sunlight at temperatures between +5°C and +25°C. Refrigeration to +5°C gives optimum storage stability.

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**Technical Data**

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<b>Chemical Base</b>	Ethyl cyanoacrylate
<b>Density</b>	~ 1.06 kg/l
<b>Curing Rate</b>	<i>Fixture Time:</i> Metal to Metal: < 25 secs. Plastic to Plastic: < 10 secs. Rubber to Rubber: < 5 secs.  <i>Full Cure:</i> 24 hours  Low temperatures will reduce cure speed.
<b>Viscosity</b>	~ 40 cps (at +20°C) (according ISO 3104 / 3105)
<b>Glue Line</b>	0.10 mm (max. gap fill)
<b>Service Temperature</b>	-50°C to +80°C

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**Mechanical / Physical Properties**

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<b>Tensile Strength</b>	> 20 N/mm <sup>2</sup> (according ISO 6922)
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**Resistance**

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<b>Chemical Resistance</b>	SikaBond-F40 exhibit good chemical resistance to most oils and solvents including motor oil, leaded petrol, ethanol, propanol and freon.
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**System Information**

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**Application Details**

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<b>Substrate Preparation</b>	<i>Surface Preparation:</i> All pieces / surfaces to be bonded must be clean, dry and free of oil and grease.
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**Application Conditions / Limitations**

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<b>Substrate Moisture Content</b>	SikaBond-F40 are not resistant to high levels of moisture or humidity over time.
<b>Relative Air Humidity</b>	SikaBond-F40 are not resistant to high levels of moisture or humidity over time.

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**Application Instructions**

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<b>Application Method / Tools</b>	Unscrew top and remove dispensing nozzle. Perforate the tip of the tube and screw on the dispensing nozzle. The tube is now ready for use.  Apply a small quantity of the adhesive over the contact surface, press the pieces together for a few seconds until bonded. Avoid contact with fingers. Clean the dispensing nozzle before closing the tube. Store opened tube in an upright position.
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**Value Base**

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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.

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## Health and Safety Information

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

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## Legal Notes

The information, and, in particular, the recommendations relating to the application and end-use of Sika 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 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 proprietary rights of third parties must be observed. All orders are accepted subject to our current terms of sale and delivery. Users should always refer to the most recent issue of the Product Data Sheet for the product concerned, copies of which will be supplied on request.

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