

SikaBond® -F Gel

Instant setting ethyl cyanoacrylate based,
gel consistency, adhesive

Construction

Product Description	Gel consistency, ethyl cyanoacrylate based instant setting adhesive where very fast cure speed is required.
Uses	<ul style="list-style-type: none">■ As an instant setting adhesive for small bonding jobs such as bonding most metals, plastics, rubber, fabrics, wood, paper and other materials■ Can be used on porous substrates such as porcelain and china■ Small repairs to glasses, bonded shoe soles, picture frames, ceramics, toys and small electronic equipment, etc.■ Surfaces with small irregularities max. 0.5 mm■ On vertical surfaces
Characteristics / Advantages	<ul style="list-style-type: none">■ One Component■ Easy to apply, non-sag, gel consistency■ Very rapid, tenacious bond to numerous substrates, e.g., plastics, rubber, metals, wood, ceramics, paper, card■ Low consumption adhesive■ Versatile, allows adhesion between different materials■ Colourless■ Durable
Product Data	
Form	
Colour	Clear
Packaging	Tube, 3 g
Storage	
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 ability.



Technical Data

Chemical Base	Ethyl cyanoacrylate
Density	~ 1.10 kg/l
Curing Rate	<i>Fixture Time:</i> Metal to Metal: 15 - 30 secs. Plastic to Plastic: 10 - 15 secs. Rubber to Rubber: ~ 3 secs. Wood: ~ 3 secs. <i>Full cure:</i> 24 hours Low temperatures will reduce cure speed.
Viscosity	~ 60 cps (at 2.5 rpm / +20°C) (according Brookfield RVT, "T-Spindle" C)
Glue Line	0.5 mm (max. gap fill)
Service Temperature	-50°C - 80°C

Mechanical / Physical Properties

Tensile Strength	> 20 N/mm ² (according ISO 6922)
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Resistance

Chemical Resistance	Sikabond®-F Gel exhibit good chemical resistance to most oils and solvents including motor oil, leaded petrol, ethanol, propanol and freon.
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System Information

Application Details

Substrate Preparation	<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

Substrate Moisture Content	Sikabond®-F Gel are not resistant to high levels of moisture or humidity over time.
Relative Air Humidity	Sikabond®-F Gel are not resistant to high levels of moisture or humidity over time.

Application Instructions

Application Method / Tools	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

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.

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.

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.

