



401 N. Raddant Rd.  
 Batavia, IL 60510  
 ph: 630-761-8900  
 fx: 630-761-8989



# Technical Data Sheet

## Apollo 2006

### Product Description

Apollo 2006 is a single component low viscosity cyanoacrylate adhesive. It is a fast setting adhesive specifically formulated for bonding rubber.

### Physical Properties

#### Monomer (Liquid)

Base Compound	Ethyl Cyanoacrylate
Appearance	Colorless Liquid
Viscosity (cP @ 68°F)	100 cP
Specific Gravity (g/cc)	1.06
Flash Point (TCC)	185°F
Shelf Life @40°F	1 year unopened

### Polymer (Cured)

Appearance	Colorless Solid
Service Temperature Range	-65°F to 200°F
Softening Point	329°F
Refractive Index (ND 20)	1.49
Full Cure Time	24 Hours
Dielectric Strength (KV/mm)	11.6
Dielectric Constant (@ 1Kc)	5.4
COE (in./in./F)	.000126
Tensile Strength (steel/steel)	3200 psi
Solubility	Nitromethane, Acetone, Dimethylformamide

### Military Specifications

Mil-A-46050C  
 Type II, Class 1

### Curing Properties

Ambient surface moisture will initiate the hardening process. Handling strength is reached in a short period of time and varies depending on environmental conditions and substrates being bonded. Product will continue to cure for at least 24 hours before full strength and resistances are developed.

### Setting Time (68°F, 65% R.H.)

Steel	5 to 10 seconds
Aluminum	7 to 14 seconds
Neoprene	< 5 seconds
ABS	3 to 5 seconds
Polycarbonate	5 to 10 seconds
PVC	3 to 5 seconds

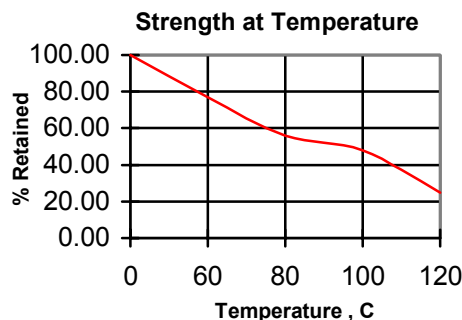
### Performance of Cured Materials

Tensile Shear strength after 48 hours at 20° to 25°C

Substrate	Range in N/mm2
Blasted Steel	19 to 25
Etched Aluminum	12 to 20
Neoprene	> 10
ABS	> 6
Polycarbonate	> 5
PVC	> 6

### Temperature Resistance

Sheer Strength on steel after 1 week at 22 °C



### Curing Performance

The gap of the bond line will affect set speed. Smaller gaps tend to increase the speed. Activators can be applied to improve set speed but may also impair overall adhesive performance.

NOT FOR PRODUCT SPECIFICATIONS. THE DATA CONTAINED HEREIN ARE INTENDED AS REFERENCE ONLY. PLEASE CONTACT CYBERBOND L.L.C. TECHNICAL DEPARTMENT FOR ASSISTANCE AND RECOMMENDATIONS. CYBERBOND L.L.C. BATAVIA, IL 60510 PHONE: 630-761-8900 FAX: 630-761-8989



401 N. Raddant Rd.  
 Batavia, IL 60510  
 ph: 630-761-8900  
 fx: 630-761-8989

**Apollo 2006**  
**Page 2 of 2**



**Chemical Resistance**

Sheer strength on steel after 12 month soak  
 % Strength Retained

Solvent	% Strength Retained
Motor Oil	100
Gasoline	100
Trichloroethane	100
Freon TA	100
10% NaOH	0
10% Hcl	0
Water	0

**General Instructions**

Surfaces to be bonded should be clean and dry. Dispense a drop or drops to one surface only. Apply only enough to leave a thin film layer after compression.

Press parts together and hold firmly for a few seconds. Good contact is essential. An adequate bond develops in less that one minute and maximum strength is attained in 24 hours.

Wipe off excess adhesive from the top of the container and recap. Apollo products if left uncapped may deteriorate by contamination from moisture in the air.

Because Apollo products cure by polymerization, whitening may appear on the surface of the container or the bonded materials. Should this happen, wipe surfaces well with acetone.

**Storage**

Products should be stored unopened in a cool, dry place out of direct sunlight. Products can be refrigerated for improved shelf life but should be brought back to room temperature before use.

**For safe handling information on this product, consult the Material Safety Data Sheet, (MSDS)**

**NOTE**

The data contained herein are furnished for information only and are believed to be reliable. Cyberbond L.L.C. cannot assume responsibility for the results obtained by others over whose method Cyberbond L.L.C. does not control. It is the user's responsibility to determine suitability for the product or of any production methods mentioned herein and to adopt such precautions as may be advisable for the protection of property and of persons against any hazards that may be involved in the handling and use thereof. In light of the foregoing, **Cyberbond L.L.C. specifically disclaims all warranties of merchantability or fitness for a particular purpose arising from sale or use of Cyberbond L.L.C. products. Cyberbond L.L.C. specifically disclaims any liability for consequential or incidental damages of any kind, including loss of profits.** The discussion herein of various processes or compositions is not to be interpreted as representation that they are free from domination of patents owned by others or as a license under any Cyberbond L.L.C. patents which may cover such processes or compositions. We recommend that each prospective user test the proposed application to determine its suitability for the purpose intended prior to incorporating any product or application in its manufacturing process using the data as a guide.