



HOLDIT[®]

Technical Datasheet

HOLDIT CA24

Revised Date: June 2011

Description

HOLDIT CA24 is an advanced cyanoacrylate that is formulated to provide high tensile and shear strengths on a wide variety of substrates. This single component adhesive has an active cure mechanism, which when pressed into a thin film between to surfaces, will cure almost instantaneously to form a rigid thermoplastic.

Applications

HOLDIT CA24 is used in a high cross section of industrial applications. From OEM to MRO industries, this grade can be used on a variety of plastic, rubber and metal bonding applications including automotive, white goods and furniture manufacturing.

Typical examples shown below:

Typical examples shown below:

- Bonding centre consoles, dashboards and weather stripping.
- Bonding identification tags to equipment.
- Bonding rubber pads to equipment base or legs.
- Bonding components in a speaker cone.
- Bonding leather and rubber during shoe manufacturing.
- Bonding fabric on lampshades.

Instructions for Use

1. For best results clean all surfaces with a cleaning solvent and allow to dry.
2. Apply adhesive to one of the mating parts and assemble carefully.
3. Allow to fully cure before applying load.
4. Excess adhesive can be carefully cleaned up with cleaning solvents such as acetone.

Properties of Uncured Material.

Resin	Ethyl Cyanoacrylate
Colour	Colourless Liquid
Viscosity	110cPs
Cure System	Humidity

Performance of Cured Material

Fixture Speed	<10 seconds @ 20°C
Full Cure Time	24 hours @ 20°C
Gap Fill	0.1mm
Temperature Range	-55°C to 90°C
Typical Strength	5 to 25 N/mm ²
Agency Approvals	MIL-S-A46050C
	ASTM D-53283

Compatible Primers

Primer such as HOLDIT A113 Accelerator and HOLDIT A701 Activator can be used to speed the fixture time of the adhesive. Fixtures times can improve by as much as 50%. The use of primers can result in lower strength and performance and should be tested after full cure.

ACTIVE & INACTIVE METAL TABLE

Super Active Very Fast Cure	Active Fast Cure	Inactive Slow Cure	Passive Primer Necessary
Brass, Copper, Magnesium	Iron, Steel, Nickel, Aluminium	Stainless Steel, Titanium, Zinc, Anodized Aluminium, Galvanised Steel	Ceramics, Glass, Plastics, Painted Finishes



HOLDIT®
Technical Datasheet
HOLDIT CA24
Revised Date: June 2011

Storage

HOLDIT CA24 should be stored in a dry cool area, out of direct sunlight. For best performance, please store product in a refrigerator.

This product has a 12 month shelf life from manufacture when stored correctly.

Presentation

HOLDIT CA24 is available in 25g bottle.

Conversions

- $(^{\circ}\text{C} \times 1.8) + 32 = ^{\circ}\text{F}$
- $\text{N/mm} \times 5.71 = \text{lb/in}$
- $\text{MPa} \times 145 = \text{psi}$
- $\text{N/mm}^2 \times 145 = \text{psi}$
- $\text{N} \times 0.225 = \text{lb}$
- $\text{N}\cdot\text{m} \times 8.851 = \text{lb}\cdot\text{in}$
- $\text{N}\cdot\text{mm} \times 0.738 = \text{lb}\cdot\text{ft}$
- $\text{mPa}\cdot\text{s} = \text{cP}$

Health & Safety in Use

HOLDIT CA24 is an ethyl Cyanoacrylate, and can bond skin and eyelids in seconds. This grade should not be used without consulting the MSDS, which contains full information regarding the use of this product, including transport, disposal, toxicological, exposure controls, accidental release and first aid measures essential to the safe use of this product.

ACTIVE & INACTIVE METAL TABLE

Super Active Very Fast Cure	Active Fast Cure	Inactive Slow Cure	Passive Primer Necessary
Brass, Copper, Magnesium	Iron, Steel, Nickel, Aluminium	Stainless Steel, Titanium, Zinc, Anodized Aluminium, Galvanised Steel	Ceramics, Glass, Plastics, Painted Finishes

The information contained herein is produced in good faith and is believed to be reliable but is for guidance only. Holdtite Australia and its agents cannot assume liability or responsibility for results obtained in the use of its products by persons whose methods are outside or beyond our control. It is the users responsibility to determine the suitability of any of the products and methods of use or preparation prior to use mentioned in our literature and furthermore the users responsibility to observe and adopt such precautions as may be advisable for the protection of personnel and property in the handling and use of any of our products.