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SW 396

Cyanoacrylate medium viscosity instant adhesive - Italian Railway PN 667 376

DESCRIPTION

SW396 is a multipurpose, medium viscosity instant adhesive recommended to bond rubbers, plastics, metals and many other materials.

USE GUIDELINES

Clean and degrease properly the surfaces before applying **SW396** with our specific spray cleaner SW305.

CURING PERFORMANS

The final curing result and the time required to complete the adhesion depend on the surfaces materials, on the temperature and on the relative humidity level.

Material	Average adhesion time (seconds)
METALS	
Steel	5 - 20
Aluminium	2 - 10
Zinc	10 - 20
PLASTIC MATERIALS	
PVC	2 - 10
Phenolic plastics	2 - 10
ABS	2 - 10
VARIOUS MATERIALS	
Neoprene rubber/NBR	< 5
Nitrile rubber	< 5
Leather	5 - 15
Ceramics	5 - 30
Paper	1 - 10
WOOD	
Fir	45 - 90
Balsa wood	2 - 5
Teak	5 - 20
Mahogany	10 - 30
Pine	5 - 20
Oak	90 - 180
Chipboard	30 - 90

If curing should proceed too much slowly due to low temperature and/or low humidity level, a specific activator use is recommended (please, contact BB Technical Service for further detail). To bond polyethylene, silicone rubbers, PTFE or polypropylene, a specific primer must be used on the surfaces before applying the adhesive (please, contact BB Technical Service for further detail). Once cured, exceeding adhesive or its residues can be taken off only with the specific remover.

CURING PROPERTIES

Tensile strength ASTM D 2095 (N/mm²)	22 - 25
Shear strength ISO 4587 (N/mm²)	15 - 20
Impact strength ASTM D 950 (Nmm/ mm²)	15 - 20
Softening temperature range	160 °C - 170 °C (320°F – 338 °F)
Refraction index n ^{20}D	Similar to glass
Resistivity DIN 53482 (Ω mm)	$>10^{15}$
Dielectric strength ASTM D 149 (kV/mm)	25
Dielectric constant DIN 53483 (1MHz)	5,2

HANDLING AND STORAGE

Keep the product in a cool and dry place not over than +20°C (68°F). To have a better storage, keep the product in a refrigerator between +3°C and +8°C (37.4°F and 46.4°F). To avoid contaminations, do not refill the containers with liquid product residue remaining after use. For more information about the product applications, storage and handling, please contact BB Technical Service.

CHEMICAL RESISTANCE

Test performed after a 24 h polymerization at the reported temperature

CHEMICALS	°C (°F)	Resistance after 100 h	Resistance after 500 h	Resistance after 1000 h
Motor oil	40 (104)	Excellent	Excellent	Excellent
Alcohol	25 (77)	Excellent	Excellent	Excellent
Gasoline	25 (77)	Excellent	Excellent	Excellent
Relative Humidity 90%	40 (104)	Quite good	Poor	Poor
Refrigerant gas	25 (77)	Excellent	Excellent	Excellent

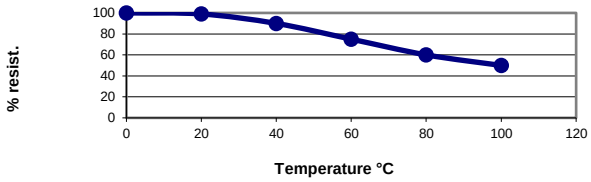
PHYSICAL PROPERTIES

Composition	Modified Ethyl cyanoacrylate
Color	clear
Viscosity (25°C - mPa s)	80 - 150
Specific gravity (g/ml)	1,06
Max joint thickness	10 - 150 micron
Flash point	87°C (188.6°F)
Shelf life	12 months at 20°C (68°F)
Temperature range	-50°C (-58°F) ↔ +80°C (176°F) up to +150°C (302°F) for short time

ENVIRONMENTAL RESISTANCE

The hereunder reported graph shows the product mechanical strength (expressed as percentage) vs temperature.

Specimen steel - ISO 4587



HANDLING AND STORAGE

Please, refer to the Material Safety Data Sheet before use.

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Quality Management System
UNI EN ISO 9001-2015
approved by RINA