



# **TECHNICAL INFORMATION (TDS 128)**

## **COMMAND 4061**

### **DESCRIPTION**

Command 4061, when compared to other Low Viscosity Cyanoacrylates, outperforms most products for cure speed, final cured strength and simply the wide range of difficult plastics and elastomers it can bond.

### **APPLICATIONS**

For example, Nitrile, Neoprene and natural rubbers can be bonded in 1-2 seconds and all the bonds are stronger than the material itself. Plastics such as ABS, soft PVC, Polyacetal, EPT and EVA all bond in 1-2 seconds and the bonds are stronger than the material being bonded. Metals such as Steel, Aluminium, Copper and Brass all bond in under 5 seconds and the bond strengths are superior to other manufacturers low viscosity products.

### **USEFUL HINTS/NOTES**

Slower cures of up to 12 seconds are found on Polymethyl Methacrylate (PMMA), Bakelite, Polycarbonate and Viton rubber. Polyolefins can be treated with special preparations. See PDS 25 on the use of a Primer which can give bonds of acceptable strength. Both processes giving excellent results on these Difficult Plastics.

### **PROPERTIES**

Speed:.....Plastics (most) <2 seconds  
Rubbers (most) <4 seconds  
Metals <5 seconds  
Strength:.....Plastics to substrate failure  
Rubbers to substrate failure  
Metals >30 N/mm(2)

### **INSTRUCTIONS FOR USE**

For best results, degrease/abrade and make sure the surfaces are clean and free from dirt, dust and contamination such as mould release agents. Apply a thin film or drop to one surface only and bring parts together holding firmly for a few seconds until the parts achieve a handling strength. Remember one drop bonds about 1sq. inch/25sq. mm and a 20g bottle has about 200 drops.

### **PROCEDURE FOR APPLICATION**

Product is normally hand applied from the bottle. For Polyolefins see PDS 25.

### **COMPATIBLE ACCELERATORS/PRIMERS**

Primers such as A021 or Double Strength A113 as accelerators for fillet cure for priming absorbent surfaces. A701 Primer is recommended

Polyolefin bonding is possible with our NRG® Primer.

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### **EXTREMELY STRONG, RAPID CURE SURFACE INSENSITIVE ADHESIVE**

### **TECHNICAL FEATURES**

Resin.....Modified Ethyl CA  
Colour.....Clear  
Cure Speed With Activator.....Instant  
Cure Speed Without Activator.....1-5 seconds  
Viscosity.....20cps  
Gap Fill.....0.1 mm  
Flash Point.....>85°C  
Shelf Life.....12 months @ 20C  
Specific Gravity.....1.06  
Max. Operating Temperature.....-60°C to + 90°C

### **CURED PERFORMANCE**

Full Cure Time:.....24 hours  
Tensile Strength.....25-30 N/mm(2)  
Tensile Shear Strength :.....15 N/mm(2)

### **STORAGE**

Store in a cool area out of direct sunlight  
Refrigeration to 5C gives optimum storage stability.

### **PRESENTATION**

Bottles:.....20g, 50g, 500g

### **HEALTH & SAFETY IN USE**

DANGER -Superglue bonds skin and eyes in seconds.

If accidental skin bonding happens wash with warm soapy water and prise skin apart using a blunt instrument (such as a teaspoon handle).

In case of eye contact, bathe immediately with water and seek immediate medical attention.

REV 21-09-99 HH