

Overview of cyanoacrylate



Drei Bond	Colour	Viscosity [mPa.s/25°C]	max. thread diameter / gap filling [mm]	Fixture time [min] or [sec]	Full cure time [h]	Temperature range [°C]	Shear strength [N/mm ²]	Tensile strength [N/mm ²]	Application Properties
4034	Colourless	20 - 40	10 - 100 µm	See page 2 „CA fixture time“	24 h	-50 to +80°C	13 - 18 (ISO 4587)	12 - 25 (ISO 6922)	Very quick initial curing. Low viscosity. Developed for quick bonding of EPDM and foam rubber. Not suitable for rubber and soft plastics. Activator 4007 is recommended for bonding PE, PP, silicone and PTFE.
4061	Colourless	10 - 20	10 - 40 µm	See page 2 „CA fixture time“	24 h	-50 to +80°C	14 - 22 (ISO 4587)	10 - 20 (ISO 6922)	Odourless and alkoxy-ethyl cyanoacrylate based. No labelling necessary. Does not irritate mucous membranes. No „blooming effect“. Slightly reduced strength. Particularly suitable for non-ventilated or enclosed work areas.
4043	Colourless	80 - 150	10 - 150 µm	See page 2 „CA fixture time“	24 h	-50 to +80°C	15 - 20 (ISO 4587)	22 - 25 (ISO 6922)	Non-sensitive, universal surface. Quick initial curing even with low humidity, for porous and acidic surfaces that are difficult to bond such as leather, wood, fabric, non-woven paper, non-woven cardboard, metal and foam, etc. Use activator 4009 to speed up. Activator 4007 is always recommended for bonding PE, PP, silicone and PTFE.
4041	Colourless	5 - 10	10 - 40 µm	See page 2 „CA fixture time“	24 h	-50 to +80°C	13 - 18 (ISO 4587)	18 - 25 (ISO 6922)	Non-sensitive surface. Low viscosity. Quick initial curing even with low humidity, for porous and acidic surfaces that are difficult to bond such as leather, wood, paper, cardboard, foam and EPDM, etc. Use activator 4009 to speed up. Activator 4007 is always recommended for bonding PE, PP, silicone and PTFE.
4027	Colourless	1200 - 2000	10 - 200 µm	See page 2 „CA fixture time“	24 h	-50 to +80°C	13 - 18 (ISO 4587)	18 - 25 (ISO 6922)	High viscosity for bonding plastic, rubber, metal and ceramics. Very good gap filling capacity. Similar properties to 4025 type. Slightly delayed initial curing enables mounting corrections. Particularly suitable for rough, absorbent and porous surfaces due to its high viscosity.
4032	Colourless	5 - 10	10 - 40 µm	See page 2 „CA fixture time“	24 h	-50 to +80°C	13 - 18 (ISO 4587)	12 - 25 (ISO 6922)	Very quick initial curing. Low viscosity. Developed for quick bonding of EPDM and foam rubber. Not suitable for rubber and soft plastics.
4014	Colourless	80 - 150	10 - 100 µm	See page 2 „CA fixture time“	24 h	-50 to +80°C	20 - 25 (ISO 4587)	25 - 30 (ISO 6922)	Methyl-based, medium viscosity and high strength. Particularly suitable for rigid material combinations such as rubber/metal or metal/plastic. Slightly delayed initial curing enables mounting corrections. Use activator 4009 to speed up. Activator 4007 is always recommended for bonding PE, PP, silicone and PTFE.
4025	Colourless	350 - 450	10 - 150 µm	See page 2 „CA fixture time“	24 h	-50 to +80°C	13 - 20 (ISO 4587)	15 - 23 (ISO 6922)	Medium to high viscosity, very good gap filling capacity. Developed for bonding plastic, rubber, metal and ceramics, etc. Similar properties to 4027 type. Medium speed initial curing.

CA fixture time



Drei Bond	Fixture time [sec]																				
	Plastic			Metal			Wood							Other materials							
	PVC	Phenolic resin	ABS	Steel	Aluminium	Zinc	Fir	Balsa	Teak	Laurel	Pine	Oak	Chip-board	Neopren / NBR	Foam	EPDM	Rubber	Fabric	Leather	Paper	Ceramics
4034	2 - 10	5 - 15	2 - 10	15 - 30	2 - 10	30 - 90								< 5	2 - 5	< 5					
4061	10 - 30	10 - 30	10 - 30	15 - 30	10 - 20	20 - 60								< 5							
4043	2 - 10	2 - 10	2 - 10	5 - 20	2 - 10	10 - 20	45 - 90	2 - 5	5 - 20	10 - 30	5 - 20	90 - 180	30 - 90	< 5				2 - 20	5 - 15	1 - 10	5 - 30
4027	20 - 50	10 - 40	15 - 40	20 - 50	10 - 30	40 - 100								< 5							
4032	2 - 10	5 - 15	2 - 10	10 - 20	2 - 10	30 - 90								< 2		< 5	2 - 5				
4041	2 - 10	2 - 10	2 - 10	5 - 20	2 - 10	10 - 20	30 - 60	2 - 5	5 - 20	10 - 30	5 - 20	30 - 60	30 - 60	< 2				2 - 20	5 - 10	5 - 10	
4014	30 - 70	10 - 30	10 - 30	20 - 40	30 - 60	30 - 60								< 10							
4025	3 - 10	5 - 20	10 - 30	10 - 30	5 - 15	30 - 90								< 5							