

Cyberbond®

TS16949, ISO9001 & ISO14001 Certified



1326™

GLASS / METAL ADHESIVE

TECHNICAL DATA SHEET

Cybercyl 1326 is a medium viscosity, fast curing adhesive system for bonding metals, magnets or ferrites, ceramics and glass. Cybercyl 1326 can be heat cured at temperatures of 93°C (200°F) in less than 30 minutes. Fixtures in 15 seconds with Cybercyl 1094 Activator. Recommended for glass, ferrite bonding, magnet materials and other ceramic type substrates to metals or to each other.

Monomer Form (Liquid)

Base Resin	Modified Acrylic
Percent Solids	100%
Colour	Amber
Viscosity @ 20°C	12,000 mPa·s
Specific Gravity	1.08 g/cm ³
Flash Point (COC)	>93°C
Shelf Life @ 20°C	6 months

Polymer Form (Solid)

Shore D Hardness	65-70
Tensile Shear Strength	24 N/mm ² (3500psi)
Temperature Range	-55 / +165°C
Solvent Resistance	Very Good
Elongation	25%

Electrical Properties

Volume Resistivity	>1 x 10 ¹⁴ ohm-cm
Surface Resistivity	>2 x 10 ¹³ ohm-cm
Dielectric Strength	>177 KV/cm

Typical Process Methods

Activator: Apply adhesive as a bead or in drops to ensure enough material is applied for filling the bond-line with a small amount of squeeze out. Apply Cybercyl 1094 Activator to the other mating surface in a thin film using an applicator brush or with another applicator. Assemble the parts and fixture with light clamp pressure for a minimum of 10 seconds where good contact of parts is evident. Larger gaps will take longer to fixture and reach full cure strength. For gaps over 0.50mm (0.020") use activator on both parts and apply adhesive over one activator primed surface, being careful not to touch adhesive applicator to the other primed surface. Load bearing strength is typically reached in 60 minutes.

Heat Cure: Cure at 93°C (200°F) for 30 minutes bond line temperature, higher temperatures will produce faster cures.

Storage

Product should be stored in a cool dry place out of direct sunlight. Shelf life of this product is six months in original sealed container. Shelf life can be extended by refrigeration. Do NOT freeze.

Note

The data contained herein is offered in good faith based upon information that is believed to be accurate and reliable, but no warranty, express or implied, regarding the accuracy of such information is made. The conditions or methods of handling, storage, use and disposal of this product are beyond our control and may be beyond our knowledge. For this and other reasons, we do not assume responsibility and expressly disclaim liability for loss, damage or expense arising out of or in any way connected with the handling, storage, use or disposal of this product. It is the responsibility of the user to determine the products suitability for their intended purpose.

For safe handling information please see Material Safety Data Sheet (MSDS).

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