

# Ultra Gel

**LOW-ODOR, LOW-BLOOMING, INSTANT GEL ADHESIVE**

TECHNICAL DATA SHEET

Revised 11/01/2024

## PRODUCT DESCRIPTION

**Born2Bond™ Ultra Gel** is a low-odor, low-blooming, instant adhesive specially designed for bonding most substrates including plastics and rubbers. The formulation consistency has been designed for high bond strength, even in places that are subject to flexing. The gel consistency allows application in any orientation. Careful selection of the formulation ingredients ensures that the product does not stain areas close to the adhesive joint.



## APPLICATIONS

Typical applications for this product are leather and rubber bonding, shoe assembly, automotive aftermarket applications, sporting equipment, and toy assembly.

## STORAGE/SHELF LIFE

Optimal storage: 2°C to 8°C (35.6°F to 46.4°F). Storage below 2°C (35.6°F) or greater than 8°C (46.4°F) can adversely affect the product's properties. If stored properly, this product has a shelf life of 12 months from the packaging date.

## HEALTH/SAFETY

The Safety Data Sheet is available on the Bostik website and should be consulted for proper handling, cleanup and spill containment before use. Keep containers covered to minimize contamination.

## LIMITATIONS

This product is not recommended for use in pure oxygen and/or oxygen-rich systems and should not be selected as a sealant for chlorine or other strong oxidizing materials. Material removed from containers may be contaminated during use. Do not return product to the original container. Bostik will not assume responsibility for product that has been contaminated or stored under conditions other than those previously indicated. If additional information is required, please contact your local Technical Service Center or customer service representative.

## KEY FEATURES

- Fixture time: 5 seconds\*
- High bonding strength
- Bonds a large range of materials, including polystyrene\*\*
- Low odour, low blooming
- Long open time
- Peel resistance
- Gel consistency for precise application

## DIRECTIONS FOR USE

1. Before applying Born2Bond Ultra Gel, make sure the surface is clean, dry and grease-free.
2. Apply adhesive to one surface. Do not use items like tissues or a brush to spread the adhesive.
3. Assemble the parts within a few seconds. The parts should be accurately positioned, as the short fixture time leaves little opportunity for adjustment.
4. Bonds should be fixed or clamped until the adhesive has reached fixture.
  - The product should be allowed to develop to full strength before subjecting it to any service loads (typically 24 to 72 hours after assembly, depending on bond gap, materials and ambient conditions).

## PRODUCT CHARACTERISTICS

Base Technology	Methoxyethyl Cyanoacrylate
Components 1k - 2k	1k
Appearance/Color	Transparent
Temperature Use Range	-40°C to 80°C (-40°F to 176°F)
VOC Content (ISO 11890-2)	13 g/L

## UNCURED PHYSICAL PROPERTIES

Viscosity at 25°C (77°F)*	108,000 - 120,000 cP
Specific Gravity (ASTM D1875: 23°C / 73.4°F)	1.13 g/mL
Refractive Index, ABBE	1.50 - 1.51

\*based on Brookfield viscometer

## CURED PHYSICAL PROPERTIES

Glass Transition Temperature	55°C (131°F)
Water Absorption (after 24 hrs) (ASTM D542)	4.6%
Impact Resistance (after 24 hrs) (ISO 9653)	6.4 kJ/m <sup>2</sup>

### Electrical Properties of Resistivity IEC 60093

Surface resistivity DC 500 V (Ohm)	2.9·10 <sup>14</sup>
Volume resistivity DC 1kV (Ohm.m)	7.5·10 <sup>13</sup>

### Corrected Dissipation Factor, Dielectric Constant IEC 60250

D @ 1 kHz	0.0180
k' @ 1 kHz	2.33
D @ 1 MHz	0.0124
k' @ 1 MHz	2.18

## CONVERSIONS

(°C × 1.8) + 32 = °F
kV/mm × 25.4 = V/mil
mm / 25.4 = in
µm / 25.4 = mil
N × 0.225 = lb
N/mm × 5.71 = lb/in
N/mm <sup>2</sup> × 145 = psi
MPa × 145 = psi
N·m × 8.851 = lb·in
N·mm × 0.142 = oz·in
mPa·s = cP

## FIXTURE TIME

### Fixture Time\* (0.1N/mm<sup>2</sup>)

Stainless Steel (A316)	15 - 25 seconds
Steel (Mild Steel)	5 - 20 seconds
Aluminum (A5754)	15 - 40 seconds
Neoprene	10 - 20 seconds
EPDM	5 - 15 seconds
Rubber, nitrile	5 - 15 seconds
ABS	10 - 30 seconds
PVC	10 - 40 seconds
Polycarbonate	20 - 50 seconds
Phenolic	60 - 90 seconds
Wood (Oak)	60 - 90 seconds
Wood (Pine)	10 - 30 seconds
Chipboard	10 - 15 seconds
Leather	5 - 10 seconds
PC/ABS	25 - 50 seconds
Paper	5 - 10 seconds

\*if stored in proper conditions

## BONDING PERFORMANCE

### Lap shear strength (ISO 4587) @ 23°C (73.4°F) (MPa)

#### After 24h Curing at RT

Grit-Blasted Mild Steel (GBMS)	13	+/- 1	
Aluminum (A5754)	4	+/- 1	
ABS	6	+/- 1	SF*
PVC	2	+/- 1	
Phenolic	4	+/- 2	
Polycarbonate	1	+/- 1	

\*Substrate failure

#### @ 100mm/min after 24h Curing at RT

Nitrile	0.5	+/- 0.1
Neoprene	0.3	+/- 0.1

#### After 1 Week Curing at RT

Grit-Blasted Mild Steel (GBMS)	13	+/- 1
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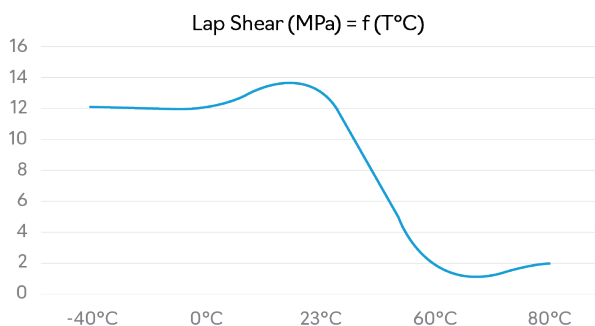
### T-Peel Strength @ 23°C (73.4°F) (N/mm)

#### @100mm/min after 1 week curing @ RT

EPDM	1.7	+/- 0.4
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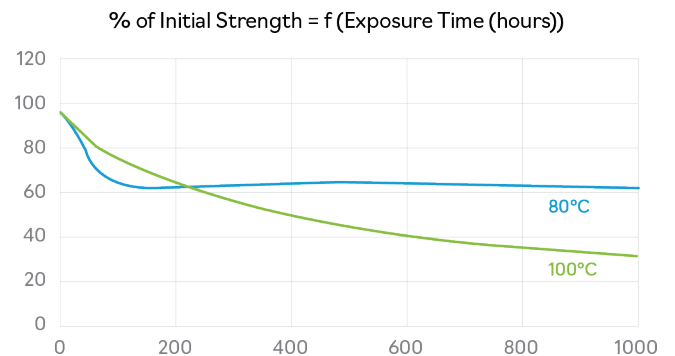
## HOT STRENGTH

The graph below shows the adhesive performance on grit-blasted, mild steel (GBMS) at various temperatures. The adhesive was cured for one week at 22°C (71.6°F). The lap shear strength was tested according to ISO 4587. The strength test was performed in a climatic chamber that was set up for 30 minutes before testing at the indicated temperatures.



## HEAT AGING

The graph below shows the heat aging results. The adhesive was aged at the temperature indicated, tested at 22°C (71.6°F) and cured for one week. The lap shear strength was tested according to ISO 4587 on grit-blasted, mild steel (GBMS).



## CHEMICAL/SOLVENT RESISTANCE

Aged under conditions indicated and tested on GBMS.

% of Initial Strength vs. Exposure Time (hours) and vs. Type of Contaminant				
Testing on GBMS		% of Initial Strength		
ENVIRONMENT	TEMP	100 H	500 H	1000 H
Motor Oil	40°C (104°F)	86	100	88
Water	23°C (73.4°F)	69	43	32

## HEAT/HUMIDITY RESISTANCE

Aged under conditions indicated and tested @ 23°C (73,4°F).

% of Initial Strength vs. Exposure Time (hours)			
ENVIRONMENT - 95% RH & 40°C (104°F)	% of Initial Strength		
	100 H	500 H	1000 H
GBMS	50	1	0
Polycarbonate	89	90	92

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