

Advanced Technology Series
RX Range Extended Adhesives
Pacer® Technology (Distributed By DYMAX Corporation)

Pacer® RX Range Extended Instant Adhesives are a family of non-surface-sensitive adhesives for porous, acidic, contaminated, or hard-to-bond surfaces, such as certain plastics and plated surfaces. Viscosities range from water-thin to a non-running gel to fit a variety of application requirements.

PROPERTIES: LIQUID STATE

	RX-5	RX-50	RX-100	RX-500	RX-700	RX Gel
Chemical Type	----- Ethyl Hybrid -----					
Viscosity Range, cps	2 -- 5	30-70	80-120	400-600	600-800	45-85000
Specific Gravity (25/4Cel)	1.05	1.05	1.06	1.06	1.06	1.08
Flashpoint (-COC Fahr)	185	185	185	185	185	185
(-COC Cel)	85	85	85	85	85	85
Vapor Pressure @ 70Cel, mmHg	8	8	8	8	8	8
Soluble In:	---- Acetone, MEK, Nitromethane, Methylene Chloride ----					

PROPERTIES: CURED STATE

	RX-5	RX-50	RX-100	RX-500	RX-700	RXGel
Melting Point (Fahr)	365	365	365	365	365	368
Softening Point (Fahr)	310	305	305	305	305	303
Service Temp. Range	----- -65° to 180°F (-54° to 82°C) -----					
Refractive Index (n20Cel/D)	1.45	1.45	1.45	1.45	1.45	1.45
Hardness - Rockwell	M58	M58	M58	M58	M58	M73
Gap Fill, Typical, Inches	0.002	0.004	0.005	0.008	0.010	0.020
Outgassing @ 10(-6)mmHg(72F)	0	0	0	0	0	0
Elongation (%)	<2	<2	<2	<2	<2	<2
Impact Strength, steel/steel						
ASTM-950-7 (FT.LBS/IN(2))	3 -- 5	3 -- 5	3 -- 5	3 -- 5	3 -- 5	3 -- 5
Soluble In:	----- Pacer X-8 Debonder, Acetone, Nitromethane -----					

Note: Values are typical and should not be used as product specifications.

Shelf life of all RX adhesives is one year stored at 70°F. Optimum shelf life is obtained when stored unopened at 40°F.

RX-5 meets MIL-A-46050C, Type II, Class 1
RX-50 meets MIL-A-46050C, Type II, Class 1
RX-100 meets MIL-A-46050C, Type II, Class 2
RX-500 meets MIL-A-46050C, Type II, Class 3
RX-700 meets MIL-A-46050C, Type II, Class 3

Tensile Shear Strength (psi), ASTM-D-1002

	RX-5	RX-50	RX-100	RX-500	RX-700	RXGel
Steel	3467	4173	4000	5133	6800	6533
ABS	733*	872*	815*	453	700*	979*
Nylon	300	373	347	304	184	537
Phenolic	1120*	1551*	1293	1240	1513*	1407
Polycarbonate	1747*	1880*	1680*	1947*	1560*	1773*
Rigid PVC	1480*	1533*	1613*	1453*	1067*	1133*

*Substrate Failure

APPLICATION AND CURE CHARACTERISTICS

For best results, use a minimal amount of adhesive. In general, one free-falling drop covers one square inch of bond area. Fixture time and full cure rates are dependent upon temperature, relative humidity, bondline thickness, and substrates being bonded. Pacer[®] Accelerators can be used to promote quicker cures when necessary.

SAFETY AND HANDLING PRECAUTIONS

Cyanoacrylate adhesives bond skin in seconds. In case of skin contact, flush with water. If skin becomes bonded, peel (not pull) apart after immersion in warm, soapy water.

In case of eye or mouth contact, flush with water, get immediate medical attention.

Use with adequate ventilation. Vapors can irritate eyes and mucous membranes. Symptoms disappear after removal of individual from vapors.

For more information, refer to Material Safety Data Sheet available upon request. In case of emergency, call Pacer[®] Technology at 1-800-538-3091 (outside CA only), or 1-900-987-0550.

The data contained herein is furnished for descriptive purposes only and is believed to be reliable. Users of any products described in the data sheet have the responsibility to determine the suitability for their particular use thereof, and Pacer relies upon such users to adopt all necessary precautions to ensure the protection of property and persons against hazards involved in the use thereof.

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