

# APOLLO CYANOACRYLATE ADHESIVES

| STANDARD FORMULAS                 |              | ESTER BASE  | GENERAL DESCRIPTION | VISCOSITY | SET TIME*<br>COLOR | STEEL:STEEL<br>METAL-RUBBER-<br>PLASTIC | TENSILE SHEAR  | TEMPERATURE<br>RANGE |
|-----------------------------------|--------------|---|---------------------|-----------|--------------------|---|----------------|----------------------|
| 2000                              | Ethyl        | Ultra Fast Wicking Grade  | 2                   | Clear     | 5 - 2 - 3          | 3200                                    | -65° to 200° F |                      |
| 2002                              | Ethyl        | General Purpose Wicking Grade                                     | 3                   | Clear     | 8 - 3 - 4          | 3200                                    | -65° to 200° F |                      |
| 2003                              | Ethyl        | General Purpose   | 50                  | Clear     | 20 - 5 - 7         | 3200                                    | -65° to 200° F |                      |
| 2004                              | Ethyl        | General Purpose   | 7                   | Clear     | 5 - 3 - 2          | 3200                                    | -65° to 200° F |                      |
| 2010                              | Ethyl        | Plastic Bonder  | 100                 | Clear     | 20 - 5 - 7         | 3200                                    | -65° to 200° F |                      |
| 2025                              | Ethyl        | General Purpose   | 250                 | Clear     | 12 - 7 - 8         | 3200                                    | -65° to 200° F |                      |
| 2075                              | Ethyl        | General Purpose   | 800                 | Clear     | 20 - 10 - 8        | 3200                                    | -65° to 200° F |                      |
| 2150                              | Ethyl        | General Purpose   | 1500                | Clear     | 20 - 10 - 15       | 3400                                    | -65° to 200° F |                      |
| 2400                              | Ethyl        | General Purpose   | 4000                | Clear     | 48 - 13 - 18       | 3200                                    | -65° to 280° F |                      |
| 2999                              | Ethyl        | General Purpose   | Gel                 | Clear     | 50 - 15 - 25       | 3500                                    | -65° to 200° F |                      |
| 2999B                             | Ethyl        | Black Gel   | Gel                 | Black     | 50 - 15 - 25       | 3500                                    | -65° to 200° F |                      |
| STRENGTH XTRA-FLEX                |              | ESTER BASE  | GENERAL DESCRIPTION | VISCOSITY | SET TIME*<br>COLOR | STEEL:STEEL<br>METAL-RUBBER-<br>PLASTIC | TENSILE SHEAR  | TEMPERATURE<br>RANGE |
| 2240-05                           | Ethyl        | Flexible  | 500                 | Clear     | 35 - 15 - 10       | 3400                                    | -65° to 240° F |                      |
| 2241-05                           | Ethyl        | Black Flexible  | 500                 | Black     | 35 - 15 - 10       | 3400                                    | -65° to 240° F |                      |
| 2240                              | Ethyl        | Flexible  | 2400                | Clear     | 55 - 30 - 30       | 3700                                    | -65° to 280° F |                      |
| 2241                              | Ethyl        | Black Flexible  | 2400                | Black     | 55 - 30 - 30       | 3700                                    | -65° to 280° F |                      |
| STRENGTH RUBBER BONDING           |              | ESTER BASE  | GENERAL DESCRIPTION | VISCOSITY | SET TIME*<br>COLOR | STEEL:STEEL<br>METAL-RUBBER-<br>PLASTIC | TENSILE SHEAR  | TEMPERATURE<br>RANGE |
| 2006                              | Ethyl        | Rubber Bonder   | 100                 | Clear     | 5 - 2 - 2          | 3200                                    | -65° to 200° F |                      |
| 2008                              | Ethyl        | Rubber Bonder   | 15                  | Clear     | 5 - 2 - 3          | 3200                                    | -65° to 200° F |                      |
| 2014                              | Ethyl        | Rubber Bonder   | 40                  | Clear     | 16 - 6 - 4         | 3200                                    | -65° to 200° F |                      |
| 2028                              | Ethyl        | Rubber Bonder   | 180                 | Clear     | 12 - 5 - 8         | 3200                                    | -65° to 200° F |                      |
| 2077                              | Ethyl        | Rubber Bonder   | 800                 | Clear     | 25 - 10 - 10       | 3200                                    | -65° to 200° F |                      |
| STRENGTH ESTER H-SERIES           |              | ESTER BASE  | GENERAL DESCRIPTION | VISCOSITY | SET TIME*<br>COLOR | STEEL:STEEL<br>METAL-RUBBER-<br>PLASTIC | TENSILE SHEAR  | TEMPERATURE<br>RANGE |
| H1                                | Neomer Ethyl | Surface Insensitive   | 3                   | Clear     | 5 - 4 - 3          | 3200                                    | -65° to 200° F |                      |
| H2                                | Neomer Ethyl | Surface Insensitive   | 30                  | Clear     | 6 - 2 - 3          | 3200                                    | -65° to 200° F |                      |
| H3                                | Neomer Ethyl | Surface Insensitive   | 60                  | Clear     | 7 - 5 - 4          | 3200                                    | -65° to 200° F |                      |
| H4                                | Neomer Ethyl | Surface Insensitive   | 100                 | Clear     | 15 - 5 - 7         | 3200                                    | -65° to 200° F |                      |
| H7                                | Neomer Ethyl | Surface Insensitive   | 650                 | Clear     | 15 - 10 - 10       | 3200                                    | -65° to 200° F |                      |
| STRENGTH SPECIALTY CYANOACRYLATES |              | ESTER BASE  | GENERAL DESCRIPTION | VISCOSITY | SET TIME*<br>COLOR | STEEL:STEEL<br>METAL-RUBBER-<br>PLASTIC | TENSILE SHEAR  | TEMPERATURE<br>RANGE |
| 5005                              | Ethoxyethyl  | Low Bloom, Low Odor   | 5                   | Clear     | 15 - 5 - 10        | 2600                                    | -65° to 180° F |                      |
| 5008                              | Ethoxyethyl  | Low Bloom, Low Odor   | 80                  | Clear     | 40 - 10 - 15       | 2600                                    | -65° to 180° F |                      |
| 5100                              | Ethoxyethyl  | Low Bloom, Low Odor   | 1000                | Clear     | 60 - 20 - 20       | 2600                                    | -65° to 180° F |                      |
| Z-396                             | Ethyl        | Surface Insensitive. Formulated for metal where oil is present on | 125                 | Clear     | 41 - 10 - 15       | 2600                                    | -65° to 185° F |                      |
| Z-574                             | Ethyl        | Surfaces Specially Formulated for TPO Bonding                     | 125                 | Clear     | 61 - 20 - 20       | 2600                                    | -65° to 185° F |                      |

\* Set Time is Approximate. Results will vary with temperature, climate, and relative humidity.