



# Technical Datasheet HOLDIT AC701

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## Description

HOLDIT AC701 is a new surface modifier overcoming the difficulties often experienced with exotic plastics, thermoplastics, elastomers, olefins and silicones.

HOLDIT AC701 combines the latest in surface tension modification with a hybrid high purity Cyanoacrylate, commander 4061.

Curing on demand, AC701 will overcome the most difficult non poval plastics and low energy surfaces. Giving very acceptable bond strengths. It is simple to apply and can be brushed or sprayed onto clean surfaces.

## Applications

- \* Silicone cord, sheet, profiles, moulded parts.
- \* Santoprene Cord, sheet, profiles, moulded parts.
- \* E.P.D.M Elastomers, Sheet, profiles.
- \* Exotic Plastics, suryn, etc.
- \* Polyolefins (teflons).
- \* Polypropylen/blends (PP).
- \* Polyethylene/blends (PE).
- \* Polytetrafuoryl Ethylene (acceptable).

## Instructions for Use

Strength achievement appears good in the first 5 minutes, however, only 20% of the ultimate strength will be found at this early stage. For best results, do not stress parts until after 24 hours to avoid failures.

Ensure both surfaces are free from contamination with an alcohol wipe before use.

NRG© Primer can be sprayed using the Atomiser supplied. Brushed or Dipped allowing the Solvent Evaporation to dry the parts. Good surface cleanliness is needed to obtain coverage of the Primer. Primer is used only on difficult to bond surfaces where combinations such as Polypropylene to Metal is in use, only prime the Polypropylene.

## Storage

Store in a cool area out of direct sunlight in a cool area @ a maximum of 20 C.

## Product Features

Solvent Base	Heptane or MCL
Colour	White
Form	Liquid Finger Pump
Viscosity @ 25°C	3-6 cps
Cure Speed	V Fast, usual <30 secs
Specific Gravity	0.87
Gap Fill	Thick Superglues
SG. @ 20°C	70 (MCL 1.2)
on part life	3-6 hours
Flash Point	-12°C
Drying Time	<30 secs (both)

## Cured Performance (Tensile Shear)

Strength - Command Cure Primer  
 0.5 mm Gap:.....3-10 N/mm(2)  
 Strength (Santoprene) Rubber  
 0.5 mm Gap: .....4-10 N/mm(2)

## Cured Performance (Peel)

This Primer/Adhesive combination is not suitable where High Peel resistance is needed.

Testing is @ RH 55% @ 20 C and parts are allowed to cure fully for 24 hours.

## Special Features

UV Fluorescence optional.

## Conversions

(°C x 1.8)+32 = °F  
 N/mm x 5.71 = lb/in  
 MPa x 145 = psi  
 N/mm<sup>2</sup> x 145 = psi  
 N x 0.225 = lb  
 N·m x 8.851 = lb·in  
 N·mm x 0.738 = lb·ft  
 mPa·s = cP

## Health & Safety in Use

Certain grades contain flammable solvents. Avoid contact with skin and eyes. Do not breathe vapours.