



TECHNICAL DATA SHEET ergo.® 5370 **(consists out of ergo.® 5368 and ergo.® 5369)**

Universal repair – superglue and instant filler

Description

ergo.® 5370 is a gap filling instant adhesive/ repair product with excellent adhesion to a wide range of materials and surfaces. It cures within approximately 4 minutes and forms a hard and tough polymer within 8 minutes.

The product shows the following advanced properties:

- long working times (in-mixer) up to 10 minutes
- instant adhesion upon joining the parts
- total volumetric gap filling with minimal volumetric shrinkage
- excellent adhesion to most plastics, woods and metals including aluminium
- excellent curing on porous and irregular surfaces
- outstanding gap filling properties

These advantages make this product an ideal repair adhesive and fast curing filler. The thixotropic consistency enables application in any orientation whilst the static mixing nozzle ensures uniform and precise application for exceptional user convenience.

Properties of liquid product

Chemical Base	ethyl cyanoacrylate
Appearance of ergo.® 5368	clear gel
of ergo.® 5369	white gel
Viscosity @ 25°C acc. to Brookfield	
ergo.® 5368 @ 1.5 rpm	180.000 – 210.000 mPas
@ 20 rpm	14.000 – 18.000 mPas
ergo.® 5369 @ 1.5 rpm	60.000 – 65.000 mPas
@ 20 rpm	4.500 – 6.000 mPas
Density @ 25°C	
ergo.® 5368	1.09 g/cm ³
ergo.® 5369	1.17 g/cm ³
Mixed @ 25°C	
Open time	4 – 8 minutes
Working time in static mixer	5 – 10 minutes



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Flashpoint: > 87°C

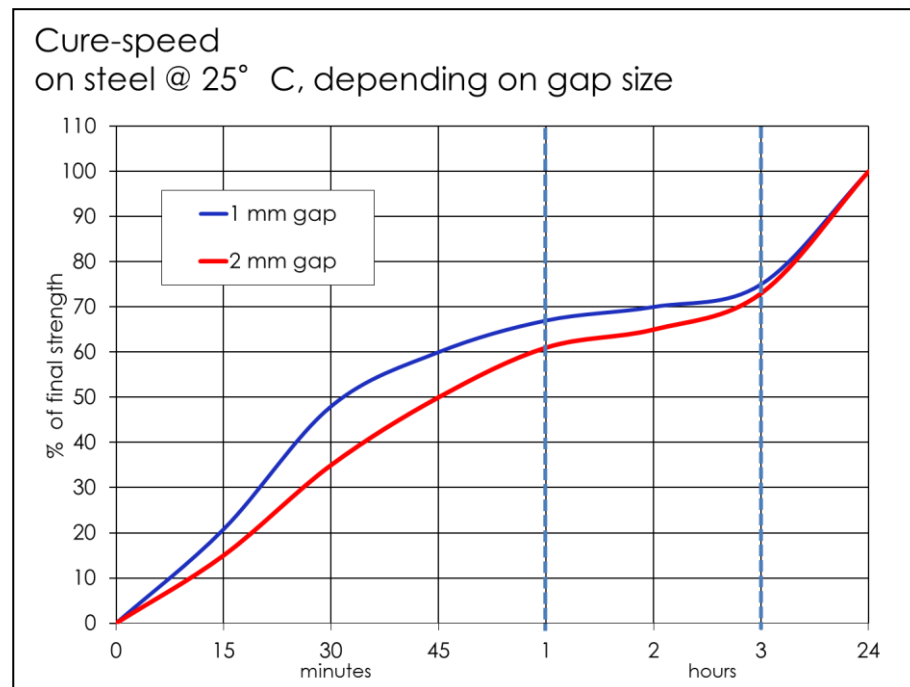
Shelf Life: 12 month at room temperature

Typical curing performance

Curing is initiated by mixing the ergo.® 5368 and ergo.® 5369 components. Handling strength is achieved rapidly; final strength after 24 hours.

Fixture Time on :

Aluminium, sandblasted	~ 10 seconds
Steel, sandblasted	~ 10 seconds
Stainless steel	~ 15 seconds
ABS	~ 30 seconds
Polycarbonate (PC)	~ 15 seconds
PMMA	~ 90 seconds
Pine wood	~ 45 seconds
Beech wood	~ 10 seconds





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Physical Properties (cured product)

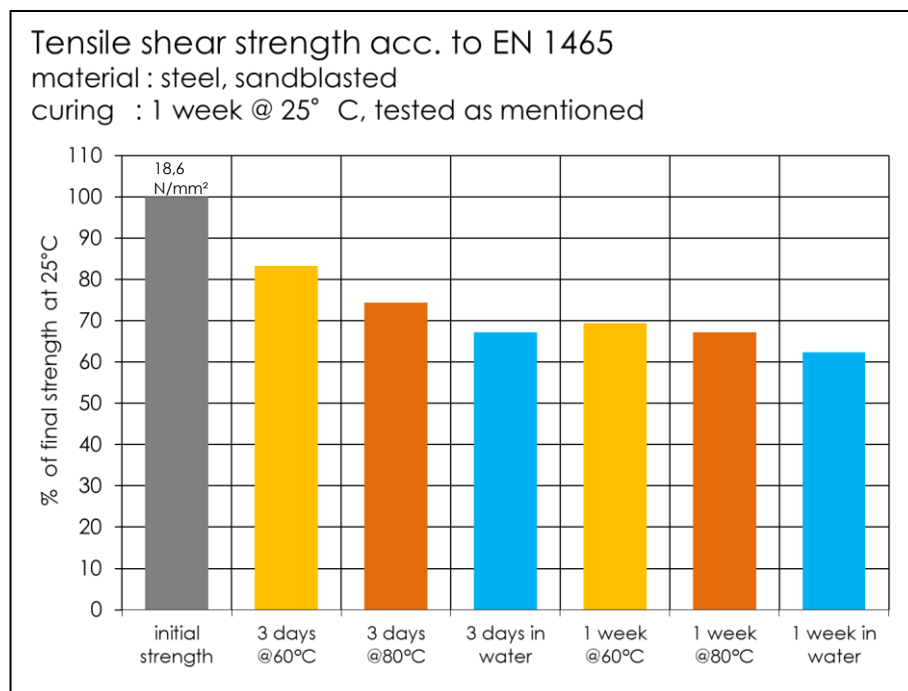
Glass transition temperature T_g 87° C

Shore D hardness 56

Tensile Shear Strength acc. to EN 1465 (final strength, 24hours @ 25°C)

Aluminium , sandblasted	> 3 N/mm ²
Steel	> 16 N/mm ²
Steel, sandblasted	> 18 N/mm ²
Stainless steel	> 15 N/mm ²
ABS	> 9 N/mm ² (*)
Polycarbonate (PC)	> 10 N/mm ² (*)
PVC	> 12 N/mm ² (*)
PMMA	> 10 N/mm ² (*)
Pine wood	> 12 N/mm ² (*)
Beech wood	> 14 N/mm ² (*)
Oak wood	> 12 N/mm ² (*)

(*) = substrate failure



Thermal Range: -55°C up to +80°C

General information:

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. For safe handling information on this product, consult the corresponding Material Safety Data Sheet (MSDS).



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Directions for use:

1. Before applying the glue, make sure the gluing surface is clean, dry and free of grease.
2. To assemble the syringe, first introduce the plunger, then exchange the cap with a mixer. Discard the first few drops.
3. Apply the material on one of the two surfaces and assemble the two parts within 1 minute.
4. After bringing the second surface into contact, there are 15-30 seconds for repositioning depending on the substrate. Then press the two parts together for around 30 seconds. After releasing the pressure, wait 5 minutes before loading and 24h for full cure.
5. Make use of the syringe or discard product at least every 2 minutes to avoid the product from polymerizing inside the mixer. Doing so, you do not need to replace the mixer.
6. After use, waste the mixer and close the cartridge with the original cap. Store the syringe in a cool (+2 up to +25°C) and dry environment.

WARRANTY INFORMATION - PLEASE READ CAREFULLY

The information contained herein is offered in good faith and is believed to be accurate. However, because conditions and methods of use of our products are beyond our control, this information should not be used in substitution for customer's tests to ensure that KISLING products are safe, effective, and fully satisfactory for the intended end use. KISLING sole warranty is that the product will meet the KISLING sales specifications in effect at the time of shipment. Your exclusive remedy for breach of such warranty is limited to refund of purchase price or replacement of any product shown to be other than as warranted. KISLING specifically disclaims any other express or implied warranty of fitness for a particular purpose or merchantability. Unless KISLING provides you with a specific, duly signed endorsement of fitness for use, KISLING disclaims liability for any incidental or consequential damages. Suggestions of uses should not be taken as inducements to infringe any particular patent.

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