



TECHNICAL DATA SHEET ergo.® 5380 **(consists out of ergo.® 5378 and ergo.® 5379)**

Universal and flexible two-component super glue

Description

ergo.® 5380 is a flexible, elastic and odourless instant adhesive with exceptional adhesion to a wide range of materials. The product has an open time (working time in mixer) of approximately 6 minutes and cures within 10 minutes to a polymer with more than 200% of elongation at break.

It shows excellent volumetric gap-filling properties and good adhesion to most plastics, wood, metals including aluminium and to porous and irregular surfaces. The gel 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	methoxyethyl cyanoacrylate
Appearance	clear gel
Viscosity @ 25°C acc. to Brookfield	
ergo.® 5378 @ 1.5 rpm	140.000 – 180.000 mPas
@ 20 rpm	6.000 – 8.000 mPas
ergo.® 5379 @ 1.5 rpm	10.000 – 15.000 mPas
@ 20 rpm	1.300 – 2.100 mPas
Density @ 25°C	
ergo.® 5378	1.18 g/cm ³
ergo.® 5379	1.23 g/cm ³
Mixed @ 25°C	
Open time	6 – 9 minutes
Working time in static mixer	5 – 6 minutes
Flashpoint:	> 87°C
Shelf Life:	12 month at room temperature

Typical curing performance

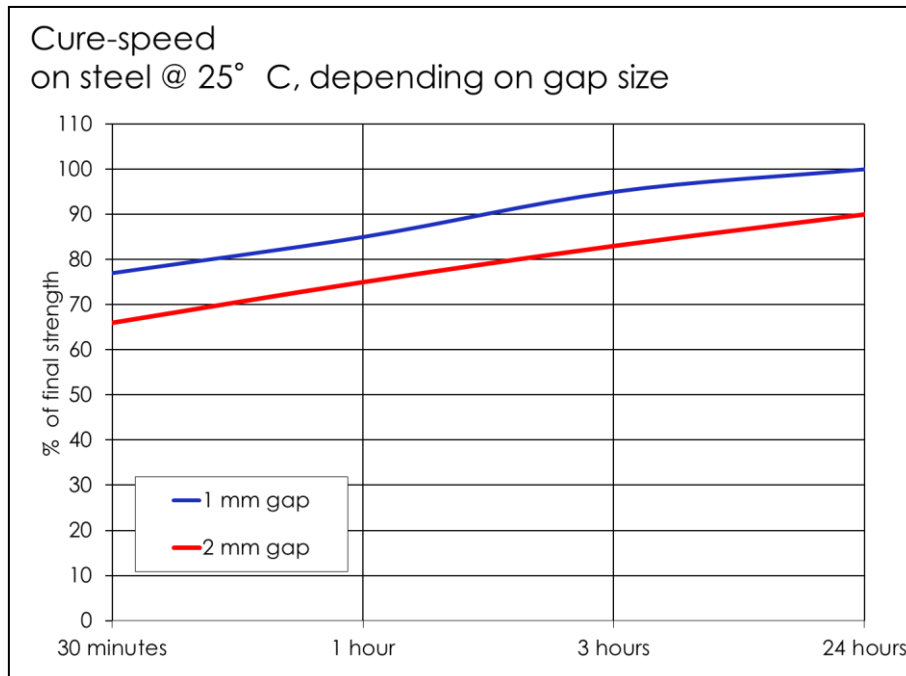
Curing is initiated by mixing the ergo.® 5378 and ergo.® 5379 components. Handling strength is achieved rapidly; final strength after 24 hours.



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Fixture Time on :

Aluminium, sandblasted	~ 90 seconds
Steel, sandblasted	~ 60 seconds
Stainless steel	~ 60 seconds
ABS	~ 45 seconds
Polycarbonate (PC)	~ 60 seconds
PMMA	~ 60 seconds
Pine wood	~ 180 seconds
Beech wood	~ 110 seconds



Physical Properties (cured product)

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

Aluminium , sandblasted	> 3 N/mm ²
Steel	> 4 N/mm ²
Steel, sandblasted	> 7 N/mm ²
Stainless steel	> 5 N/mm ²
ABS	~ 6 N/mm ²
Polycarbonate (PC)	> 5 N/mm ²
PVC	~ 3 N/mm ²
Polyamide	~ 3 N/mm ²

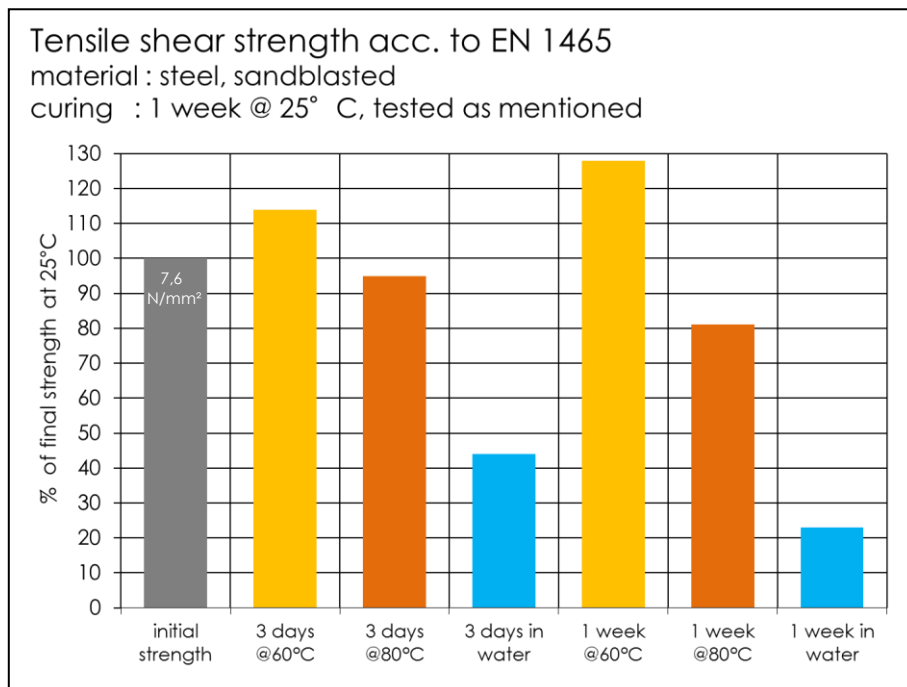


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Peel strength (final strength, 24 hours @ 25°C)

on leather ~ 2,5 N/mm
on EPDM rubber ~ 1,0 N/mm

Elongation at break > 200 %
Mechanical load at break > 150 N



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 30 – 45 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, if you do not want to replace the mixer.
6. After use, throw away the mixer and replace the 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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5380e/LK/ 22.01.2015