

Technical Data Sheet for AXIA 111

AXIA 111 is designed for the assembly of difficult-to-bond materials which require uniform stress distribution and strong tension and/or shear strength the product provides rapid bonding of a wide range of materials, including metals, plastics and elastomers. Product AXIA 111 is particularly suited for bonding porous or absorbent materials such as rubbers, and plastics.

1. Features

Chemical Type : Ethylcyanoacrylate
 Appearance : Colorless, transparent liquid
 Density(20 °C): 1.06
 Viscosity(25°C, 60% RH, cps): 3 ~ 5
 Solubility : Acetone soluble
 Flash Point : 85 °C
 Cure Speed : Moderate

2. AXIA 111

Adherends	Set time(sec)	Shear strength (Kgf/cm ²)
Steel	3~5	110
Aluminium	3~7	80
Stainless steel	3~5	110
Copper	3~7	140
ABS	2~4	60*
Acryl	4~5	60*
Rigid PVC	3~5	90*
Phenol	2~4	90*
Polycarbonate	5~7	90*
Chloroplen	3~4	5*
NBR	4~6	20*

* Represents the fracture of the adherend

3. Temperature Resistance

Thermal resistance is excellent from -30°C to 85°C. Heating causes the adhesive to soften but strength is regained on cooling, provided 85°C is not exceeded for prolonged periods.

4. Direction of Use

Surface should be clean, dry and grease free prior to bonding. MEK and similar solvent can be used to degrease surfaces. For difficult or porous surface, try using activator like AXIA Spray Primer 802. When bonding polypropylene, polyethylene, PTFE, silicone, we would recommend priming first using AXIA 1502 or AXIA 2702.

5. Storage

Store in a cool and out of direct sun light. Refrigeration to 5~10°C gives optimum storage stability.

6. Health & Safety in Use

Danger - It bonds skin and eyes in seconds. If accidental skin bonding happens, wash with warm soapy water, In case of eye contact, flush with plenty of water and seek for medical advice.