

Product Information: 3M™ Pronto™ Instant Adhesives

Product	Features	Base	Time ⁽¹⁾ To Handling Strength (Sec.)	Viscosity (CPS)	Average ⁽²⁾ T-Peel At 75°F (24°C)	Overlap Shear Strength ⁽³⁾ @ 75°F (24°C) (PSI)					
						Steel	Alumi- num	Nitrile Rubber	Neoprene Rubber	ABS	Rigid PVC
CA-4	Fast setting multi-purpose cyanoacrylate adhesive for bonding a variety of plastics and rubbers. Meets MIL-A-46050C Type II, Class 2.	ethyl	5-40	60-120	1-2	1500	1500	35*	55*	900*	1000*
CA-5	A higher viscosity, slower setting version of CA-4 Adhesive. Better adapted for filling gaps and uneven surfaces. Meets MIL-A-46050C Type II, Class 3.	ethyl	20-70	2000-3000	1-2	2000	1100	35*	55*	900*	1000*
CA-7	Very fast setting product with excellent adhesion to a variety of metals, plastics and rubbers. Meets MIL-A-46050C Type I, Class 1.	methyl	1-30	15-40	2-4	2500	2400	35*	55*	900*	1000*
CA-8	Fast setting with excellent adhesion to many metals, plastics and rubbers. Slower setting than CA-7. Meets MIL-A-46050C Type II, Class 2.	ethyl	5-40	70-120	2-4	2000	2100	35*	55*	900*	1000*
CA-9	Slower setting version of CA-8 for wire tacking and coil terminating used with surface activator. Meets MIL-A-46050C Type II, Class 3.	ethyl	20-70	1000-1700	2-4	2000	2440	35*	55*	900*	1000*
CA-40	Very fast setting adhesive with excellent adhesion to many substrates including flexible vinyl and EPDM rubber. Meets MIL-A-46050C Type II, Class 1.	ethyl	1-30	2-10	1-2	1400	1400	35*	55*	900*	1000*
CA-40H	A higher viscosity, slower setting version of CA-40 Adhesive, with better void filling capabilities. Meets MIL-A-46050C Type II, Class 3.	ethyl	5-40	400-600	1-2	1500	1500	35*	55*	900*	1000*
CA-50 Gel	A high-viscosity gel consistency CA for many applications needing non-sag properties. Less sensitive to acidic surfaces.	ethyl	60-120	45,000-85,000	1-2	2000	900	105*	130*	850*	690*
CA-100	Toughened material that provides high peel and impact strength, thermal shock resistance and improved heat resistance.	ethyl	20-70	2500-4500	15	2000	2900	95*	120*	600*	710*
Surface Activator	A clear, colorless organic-based liquid. Bottle comes with brush in lid and spray pump.	Helps speed curing and primes surfaces. Also used for wire tacking and coil terminating with CA-5, CA-9, CA-50, or CA-100.									

Note: The technical information and data above should be considered representative or typical only, and should not be used for specification purposes.

(1) The time it takes assembled parts to reach a strength where further handling and processing can take place. Times will depend on surface to be bonded, temperature and humidity.

(2) Tested per ASTM D 1876-61T.
(3) Tested per ASTM D 1002-64.
* Substrate failure.