

PRODUCT DATA SHEET

SikaFast®-2590

2-COMPONENT UNIVERSAL SUPER GLUE

TYPICAL PRODUCT DATA (FURTHER VALUES SEE SAFETY DATA SHEET)

Properties	Component A	Component B
Chemical base	Ethyl Cyanoacrylate	
Colour (CQP001-1)	Clear	White
	Color mixed Cream opaque	
Cure mechanism	Polymerization	
Density	1.1 kg/l	
Mixing ratio	by volume	4 : 1
Consistency	Thixotropic gel	
Application temperature	5 – 40 °C	
Open time (CQP526-2)	4 minutes ^A	
Handling time	on Aluminum	2 minutes ^{A,B}
	on Wood	4 minutes ^{A,B}
Tensile lap-shear strength (CQP046-6 / ISO 4587)	See table ^A	
Glass transition temperature (CQP509-1 / ISO 6721)	87 °C	
Shelf life (CQP016-1)	9 months ^C	

CQP = Corporate Quality Procedure

^{A)} 23 °C / 50 % r. h.^{B)} depends on several factors, see Cure Mechanism^{C)} Stored at temperature below 25 °C / not exposed to direct sun light**DESCRIPTION**

SikaFast®-2590 is a fast curing and gap-filling two-component Universal "Super Glue", based on ethyl-cyanoacrylate technology. It offers a long open time combined with fast curing. Due to its viscosity SikaFast®-2590 is well suited for vertical and overhead applications.

PRODUCT BENEFITS

- Wide adhesion range
- Gap filling up to 5 mm
- Can be grinded and painted
- High strength and good shock absorbing properties
- Bonds porous materials (wood, cork, leather)
- Low blooming and low odor

AREAS OF APPLICATION

SikaFast®-2590 is designed for quick repairs or bonding of a broad variety of materials, even with irregular surfaces. Due to the good gap-filling properties SikaFast®-2590 can be used for re-construction of broken pieces as well as to fill cracks. Alternatively it can be used to strengthen weak parts or be used as chemical anchoring of e.g. small screws and hooks. Seek manufacturer's advice and perform tests on original substrates before using SikaFast®-2590 on materials prone to stress cracking. This product is suitable for experienced professional users only. Test with actual substrates and conditions have to be performed to ensure adhesion and material compatibility.

CURE MECHANISM

SikaFast®-2590 cures by polymerization when mixed.

The open and handling time are influenced by adhesive thickness, substrate surface and temperature, e.g. as higher the temperature as shorter the open and fixture time and vice versa.

CHEMICAL RESISTANCE

In the view of potential chemical or thermal exposure, it is required to conduct a project related testing.

ADHESION RESULTS

Due to the diversity of substrates, preliminary tests are mandatory. The following table summarizes lap-shear test results obtained with different standard substrates. Consider the results below as indications only.

Substrate	Strength	FM ^A
AlMg ³	5 MPa	C
Stainless steel	5 MPa	C
Beech wood	6 MPa	S
PC	4 MPa	A
PVC	4 MPa	S
PMMA	4 MPa	C
ABS	5 MPa	S

Table 1: According ISO 4587 (bond line thickness 0.5 mm)

^A Failure mode: Adhesion, Cohesive, Substrate

METHOD OF APPLICATION

Surface Preparation

Surfaces must be clean, dry and free from grease, oil and dust. Remove all loose particles or residues by cleaning it thoroughly, for example with an IPA wipe.

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Application

SikaFast®-2590 is applied with a mixing ratio of 4 : 1 by volume through a static mixer.

Consider that if applied in large masses, heat is generated by the exothermic reaction. The mixed adhesive has an open time of approx. 4 minutes and achieves handling strength in approx. 2 - 4 minutes after joining on thin layer applications. Optimum temperature for the bonding process is between 15 °C and 25 °C. The influence of the reactivity by temperature changes has to be respected.

After the open time has elapsed the bonded parts must not be moved against each other anymore. When the handling time is reached the parts can be moved if no additional stress is distributed to the bond line.

Removal

Uncured excess of SikaFast®-2590 can be removed easily before curing with a dry wipe, with Sika® Remover-208 or another suitable solvent. Once the adhesive is cured it can only be removed mechanically.

Hands and exposed skin shall be washed immediately using Sika® Cleaner-350H towels or a suitable industrial hand cleaner and water.

Do not use solvents on skin.

FURTHER INFORMATION

The information herein is offered for general guidance only. Advice on specific applications is available on request from the Technical Department of Sika Industry.

Copies of the following publications are available on request:

- Safety Data Sheets

PACKAGING INFORMATION

Syringe	10 ml
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BASIS OF PRODUCT DATA

All technical data stated in this Product Data Sheet are based on laboratory tests. Actual measured data may vary due to circumstances beyond our control.

HEALTH AND SAFETY INFORMATION

For information and advice regarding transportation, handling, storage and disposal of chemical products, users shall refer to the actual Material Safety Data Sheets containing physical, ecological, toxicological and other safety-related data.

DISCLAIMER

The information, and, in particular, the recommendations relating to the application and enduse of Sika products, are given in good faith based on Sika's current knowledge and experience of the products when properly stored, handled and applied under normal conditions in accordance with Sika's recommendations. In practice, the differences in materials, substrates and actual site conditions are such that no warranty in respect of merchantability or of fitness for a particular purpose, nor any liability arising out of any legal relationship whatsoever, can be inferred either from this information, or from any written recommendations, or from any other advice offered. The user of the product must test the product's suitability for the intended application and purpose. Sika reserves the right to change the properties of its products. The proprietary rights of third parties must be observed. All orders are accepted subject to our current terms of sale and delivery. Users must always refer to the most recent issue of the local Product Data Sheet for the product concerned, copies of which will be supplied on request.

PRODUCT DATA SHEET

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