

## TECHNICAL DATASHEET

# STALOC 4S77

Instant adhesive, hi-temp

## PRODUCT DESCRIPTION

Transparent cyanoacrylate with very high impact, peel and temperature resistance. Excellent resistance against water and moisture. Temperature resistance up to 120°C.

## PHYSICAL PROPERTIES (WHEN LIQUID)

Values refer to reaching finger tight adhesion / final cure after 24 h

ATTRIBUTE	UNIT	SPECIFICATION
colour		transparent
viscosity at +25°C	mPas	100 – 200 mPas
density at +25°C	g/ml	1,06 g/ml DIN 51757
flashing point	°C	87°C DIN 55213
chemical basis		cyanoacrylate
shelf life at +25°C		1 year

## CURING TIMES

MATERIAL	UNIT	SPECIFICATION
Aluminium / Aluminium	sec	10 - 60 sec
SBR / SBR	sec	20 - 30 sec
EPDM / EPDM	sec	< 30 sec

## PHYSICAL PROPERTIES (WHEN CURED)

ATTRIBUTE	UNIT	SPECIFICATION
temperature resistance	°C	-50°C to +120°C
softening point	°C	165°C

## MECHANICAL RESISTANCE

ATTRIBUTE	UNIT	SPECIFICATION
tensile strength Aluminium / Aluminium	N/mm <sup>2</sup>	12 - 25
shear strength	N/mm <sup>2</sup>	15 - 25
elongation		~ 5%

## APPLICATION

Recommended application – further information can be found in the material safety data sheet

The parts to be bonded need to be cleaned and degreased. It is recommended to use STALOC technical cleaners, in order to ensure the best results in terms of adhesion. STALOC instant adhesives obtain excellent results even when used with minimum gaps.

Remove the residues of the glue with acetone-containing cleaners (e.g. STALOC Multi Power Cleaner) after pressing the parts together.

In case you need to accelerate the curing (e.g. when gaps are higher) use the STALOC activator for instant adhesives. For all materials with low surface tension which are difficult to bond (e.g. PE, PP, etc.) use the STALOC Primer for instant adhesives for surface preparation.



## STORAGE

Recommended storage for optimum shelf life

Store product at an optimum temperature between 5°C and 25°C. Keep cool and dry. Make sure that the content is not contaminated once the bottle has been opened, in order to ensure an optimum shelf life. In case you need any further information, please contact the STALOC team.

## SAFETY INFORMATION

Please send your request for the latest version of the material safety data sheet (MSDS).

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