

**TURBO FUSE SERIES 440
(GEL)**

Palm Lab's Cyanoacrylate is a one component rapid bonding adhesive. TURBO FUSE 440 SERIES GEL advanced thixotropic formula is designed to polymerize instantly by absorbing surface moisture. The product's performance has been tested with a variety of materials, and is recommended for a multitude of applications. The fast curing qualities make it especially desirable in high speed industrial production. TURBO FUSE SERIES 440 GEL is ideal for use in applications that require a gel like, viscous adhesive. It is also ideal for applications on vertical, angled or overhead surfaces. For extreme gap fill, the use of an accelerator is highly recommended.

PHYSICAL PROPERTIES (Liquid State)

Base compound (Resin)	Ethyl Cyanoacrylate
Appearance	Clear white gel
Viscosity cP	Not applicable – thixotropic gel
Specific Gravity	1.05
Flash Point	170° F - 200° F (Tagliabue closed cup)
Shelf Life	1 Year
Soluble in Acetone, MEK, Amide, Methylene Chloride	

PHYSICAL PROPERTIES (Cured State)

Appearance	Clear-Hard
Softening Temperature (Fahrenheit)	300°F.
Service Temperature (Fahrenheit)	-65° to 180°F.
Hardness Barcol	65
Dielectric Constant at 1 MHz.	3.33
Specific Resistance	8.6 X 10 ² ohm/cm
Strength psi-Tensile Shear	2,500
Gap Fill	0.010 "

MATERIAL SET UP TIME

Aluminum to Aluminum	20 to 30 seconds
Steel to Steel	50 to 100 seconds
Phenolic to Phenolic	< 90 seconds
Polycarbonate to Polycarbonate	50 to 70 seconds
Rubber to Rubber	10 to 25 seconds

Because of the thick gel consistency, it works especially well in poor fitting applications such as rough metal or ceramic repair, unfinished metal to metal bonding, and metal to rubber.

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