Uncommon Conglomerates INC.

A cyberbond LLC Company

Technical Data Sheet

Frame Fast®

# 290

Adhesive

## Product Description

***Frame Fast® 290 Adhesive*** is a high viscosity engineering grade adhesive developed for coarse mesh counts of 260 or greater. ***Frame Fast® 290 Adhesive*** can be used on aluminum, steel, and wood or plastic insert strips used in self tensioning frames. This product exhibits extraordinary strength with a tensile strength of 3500 psi.

## Physical Properties

### Monomer (Liquid)

| | |
|---|---|
| Base Compound | Ethyl Cyanoacrylate |
| Appearance | Colorless Liquid |
| Viscosity (cP @ 68°F) | 1500 cP |
| Specific Gravity (g/cc) | 1.06 |
| Flash Point (TCC) | 185°F |
| Shelf Life @40°F | 1 year unopened |

### Military Specifications

Mil-A-46050C
Type II, Class 3

### Curing Properties

Ambient surface moisture will initiate the hardening process. Handling strength is reached in a short period of time and varies depending on environmental conditions and substrates being bonded. Product will continue to cure for at least 24 hours before full strength and resistances are developed.

### Setting Time (68°F, 65% R.H.)

| | |
|---|---|
| Steel | 20 to 40 seconds |
| Aluminum | 10 to 30 seconds |
| Neoprene | < 10 seconds |
| ABS | 15 to 40 seconds |
| Polycarbonate | 25 to 50 seconds |
| PVC | 20 to 40 seconds |

### Curing Performance

The gap of the bond line will affect set speed. Smaller gaps tend to increase the speed. Activators can be applied to improve set speed but may also impair overall adhesive performance.

### Polymer (Cured)

| | |
|---|---|
| Appearance | Colorless Solid |
| Service Temperature Range | -65°F to 200°F |
| Softening Point | 329°F |
| Refractive Index (ND 20) | 1.49 |
| Full Cure Time | 24 Hours |
| Dielectric Strength (KV/mm) | 11.6 |
| Dielectric Constant (@ 1Kc) | 5.4 |
| COE (in./in./F) | .000126 |
| Tensile Strength (steel/steel) | 3500 psi |
| Solubility | Nitromethane, Acetone, Dimethylformamide |

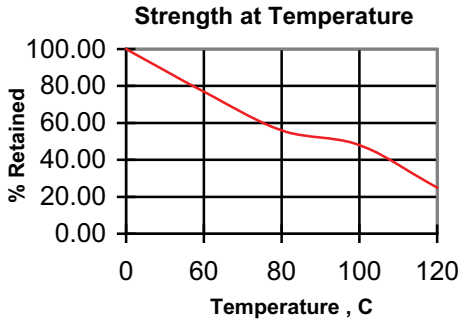
### Performance of Cured Materials

Tensile Shear strength after 48 hours at 20° to 25°C

| Substrate | Range in N/mm2 |
|---|---|
| Blasted Steel | 19 to 25 |
| Etched Aluminum | 12 to 20 |
| Neoprene | > 10 |
| ABS | > 6 |
| Polycarbonate | > 5 |
| PVC | > 6 |

### Temperature Resistance

Sheer Strength on steel after 1 week at 22 °C





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## Chemical Resistance

Sheer strength on steel after 12 month soak

| Solvent | % Strength Retained |
|---|---|
| Motor Oil | 100 |
| Gasoline | 100 |
| Tricloroethane | 100 |
| Freon TA | 100 |
| 10% NaOH | 0 |
| 10% Hcl | 0 |
| Water | 0 |

## General Instructions

1. Apply a single uninterrupted bead of ***Frame Fast® 290 Adhesive*** to the face of the frame.
2. Be sure the frame and fabric/mesh are in contact.
3. Spread the adhesive immediately with any flat-edged tool.
4. Spray any ***Frame Fast® Activator*** lightly but thoroughly from about 14 inches away from the frames. The adhesive will harden instantly.
5. Trim excess fabric/mesh. Screened frame is now ready to use. Maximum strength is achieved in 24 hours.

## Storage

Products should be stored unopened in a cool, dry place out of direct sunlight. Products can be refrigerated for improved shelf life but should be brought back to room temperature before use

## For safe handling information on this product, consult the Material Safety Data Sheet, (MSDS)

**NOTE**

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