



**Product Description**

**Frame Fast® 295 Adhesive** is a rubber fortified cyanoacrylate adhesive developed for vigorous bonding applications and for difficult to bond substrates. Unlike standard cyanoacrylates, **Frame Fast® 295 Adhesive** remains flexible after curing making it ideal for screen printing. Excellent for fine mesh counts, high mesh tensions, and minimal profile frame surfaces. Provides superior temperature and humidity resistance.

**Physical Properties**

**Monomer (Liquid)**

Base Compound	Ethyl Cyanoacrylate
Appearance	Black Liquid
Viscosity (cP @ 68°F)	175-350 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 2

**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	10 to 20 seconds
Aluminum	7 to 15 seconds
Neoprene	< 5 seconds
ABS	5 to 10 seconds
Polycarbonate	10 to 20 seconds
PVC	10 to 20 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	Black 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)	3200 psi
Solubility	Nitromethane, Acetone, Dimethylformamide

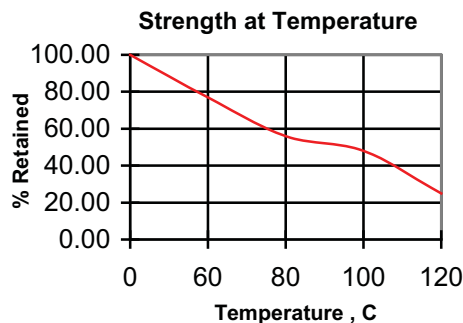
**Performance of Cured Materials**

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

<b>Substrate</b>	<b>Range in N/mm2</b>
Blasted Steel	19 to 26
Etched Aluminum	14 to 21
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

<b>Solvent</b>	<b>% Strength Retained</b>
Motor Oil	100
Gasoline	100
Trichloroethane	100
Freon TA	100
10% NaOH	0
10% Hcl	0
Water	0

### General Instructions

1. Apply a single uninterrupted bead of **Frame Fast® 295 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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