



# Technical Data Sheet

## RS 473-388 Industrial Cyanoacrylate – 5 x 5g Bottles

RS 473-388 is a low-medium viscosity (40cP) modified Ethyl Cyanoacrylate adhesive capable of bonding a very wide range of materials, including some porous ones, where a very fast cure rate is required. Typical materials include plastics, rubbers, wood, paper, leather, metals etc. Cure speed is less sensitive to relative humidity than standard superglues making it well suited to bonding close fitting parts and fairly smooth, even surfaces.

### Preparation:

Surfaces must be clean, dry and free from oil and grease. Isopropyl Alcohol (IPA) provides an effective quick drying degreasant, particularly in clean environments and is available from RS in various forms, from wipes to aerosols. Please search under IPA on the RS website. For difficult to bond materials such as polyethylene, polypropylene and polytetrafluoroethylene (PTFE) and thermoplastic rubber materials, RS 473-394 Polyolefin Primer is recommended, though not where a high peel strength is required.

### Application:

Superglues are best suited to close fitting joints with max gap 0.15mm for medium viscosities and should be thinly applied to ensure rapid polymerisation and a good strong bond. Over application and high bond gaps reduces both curing speed and potential bond strength. Curing is initiated by atmospheric moisture and continues after full functional strength has developed, requiring at least 24 hours for full chemical/solvent resistance to develop. Cure speeds increase with increased relative humidity and ambient temperatures. Ensure joints are properly aligned. Apply a very thin line direct from the bottle to one surface only. Press firmly together and hold till handling strength is achieved. Allow 24 hours to fully cure.

### Health & Safety:

Avoid contact to the skin. Should contact be made and bonding occur soak in warm water until separation occurs, which may take several hours. Please refer to Material Safety Data Sheet (MSDS). Most up to date versions are retained on the RS website: [www.rs-components.com](http://www.rs-components.com).

### Shelf Life:

12 months from date of receipt from RS if kept unopened and refrigerated at 5°C. (See MSDS, section 7)

### Typical Properties:

Chemical Type:	Ethyl
Appearance:	Clear
Specific Gravity:	1.06
Viscosity:	34-44 cP, 40 typical (ISO 3104/3105)
Tensile Strength:	21 N/mm <sup>2</sup> (ISO 6922)
Fixture time:	2-20 seconds at 21°C
Full cure:	24 hours at 21°C
Flash Point:	>85°C
Gap Fill:	0.10mm max
Operating Temperature:	-50°C to +80°C

### Typical Cure Speeds:

Steel/Steel:	<15 seconds
ABS/ABS:	<10 seconds
Rubber/Rubber:	<5 seconds
Balsa Wood:	<3 seconds

### RS Components

PO Box 99, Corby, NN17 9RS  
Switchboard: 0845 850 9900  
Technical Help: 0845 850 9922  
Technical.help@rswww.com

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Users must determine suitability, application methods and take adequate precautions to meet their requirements.  
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