

| Code  | Description              | Size | Colour |
|-------|--------------------------|------|--------|
| 09151 | Holdfast Ultrabonder 606 | 20gr | Clear  |

## 1. Description

Holdfast Ultrabonder 606 is a low viscosity, fast curing single component adhesive. It is specifically formulated for difficult to bond substrates, particularly suitable for bonding plastic or rubber parts.

## 2. Characteristics

- High strength
- Fast setting/fixing adhesive
- One component
- Solvent-free
- Does not require use of catalyst, heat or clamps

## 3. Technical Data

|  | Liquid State        | Cured State   |
|--|---------------------|---|
| <b>Base:</b>                               | Ethyl Cyanoacrylate |   |
| <b>Colour:</b>                             | Clear               | Clear   |
| <b>Specific Gravity (20°C):</b>            |                     | 1.05  |
| <b>Refractive Index (n<sub>20D</sub>):</b> | 1.439               | 1.490   |
| <b>Flash Point (°C):</b>                   | 95(203 F)           |   |
| <b>Boiling Point (°C):</b>                 | 65-6 mmHg           |   |
| <b>Viscosity (cps):</b>                    | 30-60               |   |
| <b>Softening Point (°C):</b>               |                     | 120 (248°F)   |
| <b>Dielectric Constant (at 10MHz):</b>     |                     | 2.75  |
| <b>Dielectric Loss (at 10MHz):</b>         |                     | 0.02  |
| <b>Soluble in:</b>                         |                     | Acetone, Dimethyl Formamide, Nitromethane, Dimethyl Sulfoxide |

## 4. Applications

- Ceramics/Tiles
- Hardwood
- Laminated plastics
- Metals
- Paper
- Foam plastics
- Some PVC
- Other non-porous surfaces (\*\* Test Dependant)

## 5. Packaging

20g

## 6. Shelf Life

12 months

## 7. Application Instructions

### Method:

1. Make sure the surfaces to be bonded are clean and dry (preferable to solvent wipe plastics, glass, and rubber, and to acid-treat metals).
2. Dispense a drop or drops to one surface only. Apply only enough to leave a thin film after compression.
3. Press parts together and hold firmly for a few seconds. Good contact is essential. An adequate bond develops in less than one minute. (Max strength is achieved in 24 to 48 hours).
4. Wipe off excess adhesive from the top of the container and recap. If left uncapped, may deteriorate by contamination from moisture in the air.
5. Because Gorilla Ultrabonder 606 condenses by polymerization, sometimes whitening will occur on the surface of the container or the bonded materials. Should this happen, wipe surfaces well with acetone.

### Bond Strength

(Tensile Shear Strength, Cured for 24 Hours at 20-25°C)

|                                  | KG/CM2 |                                    | KG/CM2  |
|----------------------------------|--------|------------------------------------|---------|
| Rigid PVC to Rigid PVC           | 40-60  | SBR to SBR                         | 5-10    |
| ABS to ABS                       | 50-70  | Steel to Steel                     | 190-210 |
| Polycarbonate to Polycarbonate   | 80-120 | Stainless Steel to Stainless Steel | 160-180 |
| Polystyrene to Polystyrene       | 30-45  | Aluminium to Aluminium             | 170-190 |
| Natural rubber to Natural rubber | 5-9    | Copper to Copper                   | 150-170 |
| *Neoprene to Neoprene            | 5-9    | Steel to Rigid PVC                 | 50-60   |
| NBR to NBR.....                  | 5-9    | Stainless Steel to Neoprene        | 5-10    |
| ABS to SBR.....                  | 5-10   |                                    |         |

### Cure Speed

|                        | Seconds |                                    | Seconds |
|------------------------|---------|------------------------------------|---------|
| ABS to ABS             | 4-6     | NBR to NBR                         | 3-5     |
| Wood to Wood           | >60     | Stainless Steel to Stainless Steel | 45-55   |
| ABS to Stainless Steel | 50-60   | ABS to NBR                         | 3-5     |
| NBR to Stainless Steel | > 60    | Wood to ABS                        | >60     |

### Precaution

- Use with proper ventilation. Avoid contact with skin and eyes.
- If contact with skin occurs, rinse with warm water or dissolve gradually with appropriate debonder. Do not try to remove forcibly.
- If adhesive gets into eye, keep eye open and rinse thoroughly. Seek medical attention immediately.
- Keep well out of reach of children.
- Keep adhesive in a cool, dry place 20-25°C. For long term storage, refrigeration (5°C) is recommended.

| Holdfast | Competitor |      | Properties  |
|----------|------------|------|---|
| 105      | 420        | 20g  | Low viscosity, general industrial grade cyanoacrylate adhesive. Penetrating Gorilla Super Glue Adhesive |
|          |            | 500g | Fast, strong bonds to a wide range of metal, plastic and rubber materials.                              |
| 108      | 420        | 20g  | Low viscosity, general industrial grade cyanoacrylate adhesive. Penetrating.                            |
|          |            | 500g | Fast, strong bonds to a wide range of metal, plastic and rubber materials. (Available upon request)     |
| 401      | *401       | 20g  | Medium viscosity fast curing cyanoacrylate adhesive.  |
|          |            | 500g | For rubber and plastic components (Available upon request)  |
| 403      | 414        | 20g  | Medium viscosity cyanoacrylate adhesive   |
|          |            | 500g | For Vinyl and other plastics (Available upon request)   |
| 407      | 444        | 20g  | Medium viscosity cyanoacrylate adhesive Gorilla Super Glue Adhesive                                     |
|          |            | 500g | Electronic applications   |

|           |      |      |  |
|-----------|------|------|--|
| 412       | 416  | 20g  | Higher viscosity cyanoacrylate adhesive  |
|           |      | 500g | Strong bonds to a wide range of metal, plastic and rubber materials. (Available upon request)                                      |
| 1417      | 417  | 20g  | Temporary bonding cyanoacrylate adhesive (Available upon request)  |
| 424       | 422  | 20g  | High viscosity, general industrial grade cyanoacrylate adhesive Gorilla Super Glue Adhesive.                                       |
|           |      | 500g | Bonding a wide range of metal, plastic and rubber materials.   |
| 909       | 409  | 20g  | Gel cyanoacrylate adhesive. Non-drip, nor-run applications Gorilla Super Glue Adhesive   |
|           |      | 500g |  |
| C681      |      | 20g  | Clear, high viscosity rubber toughened cyanoacrylate adhesive. Impact,   |
|           |      | 1kg  | & Peel resistance (Available upon request)   |
| C685      | 411  | 20g  | Clear, high viscosity rubber toughened cyanoacrylate adhesive. Impact,   |
|           |      | 1kg  | & Peel resistance (Available upon request)   |
| B680      | 480  | 20g  | Black, medium viscosity cyanoacrylate adhesive. Flexible.  |
|           |      | 500g | Good peel strength. Bonds metal, plastic & rubber. (Available upon request)  |
| B684      | 410  | 20g  | Black, rubber toughened cyanoacrylate adhesive. Peel & Impact resistant.   |
|           |      | 500g | Bonds metal, plastic & rubber. (Available upon request)  |
| B689(Gel) | 426  | 20g  | Black cyanoacrylate gel adhesive. Impact, peel & moisture resistant. (Available upon request)                                      |
| B299(Gel) | *455 | 20g  | Black gel, low odor, non-blooming cyanoacrylate adhesive. (Available upon request)   |
| 601       | 401  | 20g  | Med. viscosity, difficult surface industrial grade cyanoacrylate adhesive. Gorilla Super Glue .                                    |
|           |      | 500g | Fast, strong bonds to a wide range of metal, plastic and rubber materials.   |
| 606       | 406  | 20g  | Low viscosity, difficult surface industrial grade cyanoacrylate adhesive.  |
|           |      | 500g | Fast, strong bonds to a wide range of plastic and rubber & EPDM materials. (Available upon request)                                |
| 695       | 495  | 20g  | Med. viscosity, difficult surface industrial grade cyanoacrylate adhesive.   |
|           |      | 500g | Fast, strong bonds to a wide range of metal, plastic and rubber materials. (Available upon request)                                |
| 701       | 493  | 20g  | Low viscosity general industrial grade cyanoacrylate adhesive.   |
|           |      | 500g | For close fitting Metal bonding (Available upon request)   |
| 703       | 496  | 20g  | Medium viscosity, fast setting cyanoacrylate adhesive.   |
|           |      | 500g | For metal bonding (Available upon request)   |
| 724       | 415  | 20g  | General Industrial grade cyanoacrylate adhesive for metal bonding  |
|           |      | 500g | Realignment requirements, irregular surfaces, metal bonding (Available upon request)   |
| 201       | 408  | 20g  | Low viscosity, low odor, non-blooming cyanoacrylate adhesive. (Available upon request)   |
|           |      | 500g |  |
| 202       | 460  | 20g  | Low viscosity, low odor, non-blooming cyanoacrylate adhesive.  |
|           |      | 500g | Bonds a wide variety of materials for cosmetic applications. (Available upon request)  |
| 212       | 403  | 20g  | Medium viscosity, low odor cyanoacrylate adhesive.   |
|           |      | 500g | Bonds a wide variety of materials for low blooming applications. (Available upon request)  |
| 209       | 455  | 20g  | Low odor, low blooming gel cyanoacrylate adhesive. (Available upon request)  |
| TB601     | 4210 | 20g  | Black, low viscosity rubber toughened cyanoacrylate adhesive. Impact, Peel & Thermal resistance (Available upon request)           |
| T698      | 498  | 20g  | Medium viscosity cyanoacrylate adhesive – resists Thermal cycling to 250F (Available upon request)                                 |
| TB625     | 4211 | 20g  | Black, high viscosity rubber toughened cyanoacrylate adhesive. Impact, Peel Humidity & Thermal resistance (Available upon request) |

|                 |       |      |   |
|-----------------|-------|------|---|
| <b>TB909</b>    | *4205 | 20g  | Black, rubber toughened cyanoacrylate gel adhesive. Impact, Peel Humidity & Thermal resistance (Available upon request) |
| <b>MX-2100</b>  | 770   | 500g | PP. PE PRIMER (Available upon request)  |
| <b>MX-2001L</b> | 7452  | 500g | LIQUID ACCELERATOR (Available upon request)   |
| <b>MX-2201</b>  | 768   | 500g | DEBONDER (Available upon request)   |

## 8. Health and Safety Recommendation

- Apply the usual industrial hygiene.
- Wear gloves and safety goggles.

### Remark

*The directives and data contained in this documentation is provided in good faith and accurately reflect Soudal's knowledge when its products are properly stored, handled and applied under normal conditions in accordance with Soudal's recommendations. In practice, the diversity of the materials, substrates, environments, site conditions, product storage, handling and application are such that no warranty can be given in respect to the merchantability or fit for purpose, of any product. All users must determine the product suitability for their purposes through testing. This technical data sheet and product properties may change without notice so users, suppliers and retailers of Soudal products should always check that the data sheets they have are the latest. To the maximum extent permitted by law, Soudal disclaims all warranties in relation to either the manufacture, storage and end use of the product. All orders are accepted subject to our current terms of trade. **If any clarification is required, please contact Soudal Technical Services or email [sales@soudal.co.nz](mailto:sales@soudal.co.nz).***

**Last Updated:** 31 July 2019

|                           |                 |   |
|---------------------------|-----------------|---|
| Supplier contact details: | Soudal Ltd      | Freephone: 0800 70 10 80  |
|                           | 14 Avalon Drive | Phone: (07) 847 5540  |
|                           | Nawton          | Fax: (07) 847 0324  |
|                           | Hamilton 3200   | Email: <a href="mailto:sales@soudal.co.nz">sales@soudal.co.nz</a> |
|                           | New Zealand     | Website: <a href="http://www.soudal.co.nz">www.soudal.co.nz</a>   |