



# RITE-LOK™ Cyanoacrylate Adhesive PR20

## Product Data Sheet

Updated : February 2007  
Supersedes : New

**Product Description** RITE-LOK PR20 is a low viscosity Ethyl Cyanoacrylate adhesive. PR20 is formulated for very high speed, high strength bonding of plastics and rubbers.

**Key Features** PR20 is specially formulated for the building of most plastics and rubbers, but will also bond other common substrates. Recommended for use on close-fitting parts and smooth, even surfaces. Can be post-applied to pre-assembled parts.

### Physical Properties

Base	Ethyl
Soluble In	Acetone, MEK
Viscosity (cps)	Range 17-22 Typical Value 20
Specific Gravity	1.06
Colour	Clear

### Performance Characteristics

Maximum Gap Fill (best results are obtained with very thin bond lines)	0.10mm
Fixture Time	2-20secs
Tensile Strength (ISO 6922)	20 N/mm <sup>2</sup>
Full Cure	24hrs
Speed of Cure	The speed of cure of cyanoacrylates varies according to the substrate to be bonded. Acidic surfaces such as paper and leather will have longer cure times than most plastics and rubbers.
Moisture Resistance	Low resistance to high levels of moisture and humidity over time.
Service Temperature Range	-50 to +80°C

### Additional Product Information

RITE-LOK Activators AC11 and AC12 may be used in conjunction with RITE-LOK cyanoacrylates where cure speed needs to be accelerated. Cure speeds of less than 2 seconds can be obtained with most RITE-LOK cyanoacrylates. The use of an activator can reduce the final bond strength by up to 30%

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<b>Application Techniques</b>	<p>Bond speed is very fast so ensure that parts are properly aligned before bonding. RITE-LOK Activators may be required if there are gaps or porous surfaces. Some plastics may require application of RITE-LOK AC77 Primer.</p> <p>Ensure parts are clean, dry and free from oil and grease. Product is normally hand applied from the bottle. Apply sparingly to one surface and press parts firmly together until handling strength is achieved.</p> <p>As a general rule, as little cyanoacrylate as possible should be used – over application will result in slow cure speed and lower bond strength.</p>
<b>Storage Conditions</b>	<p>Keep the adhesive in a cool, dry place away from direct sunlight. Under such conditions shelf life at room temperature will be 12 months.</p> <p>Refrigeration to 5°C gives optimum storage stability.</p>
<b>Shelf Life</b>	12 months from date of despatch by 3M when stored in the original carton at 21°C
<b>Precautionary Information</b>	Refer to product label and material Safety Data Sheet for health and safety information before using the product. For information please contact your local 3M Office. <a href="http://www.3M.com">www.3M.com</a>
<b>For Additional Information</b>	<p>To request additional information or to arrange for sales assistance, call 0870 6080050</p> <p>Address correspondence to: 3M United Kingdom PLC, 3M House, 28 Great Jackson Street, Manchester, M15 4PA</p> <p>For detailed information concerning certifications please refer to the Technical Service Bulletin: RITE-LOK Certifications TSB ENG GB 08.2007.</p>
<b>Product Use</b>	<p>All statements, technical information and recommendations contained in this document are based upon tests or experience that 3M believes are reliable. However, many factors beyond 3M's control can affect the use and performance of a 3M product in a particular application, including the conditions under which the product is used and the time and environmental conditions in which the product is expected to perform. Since these factors are uniquely within the user's knowledge and control, it is essential that the user evaluate the 3M product to determine whether it is fit for a particular purpose and suitable the user's method or application.</p>
<b>Note</b>	<p>Values presented have been determined by standard test methods and are average values not to be used for specification purposes.</p> <p>Our recommendations on the use of our products are based on tests believed to be reliable but we would ask that you conduct your own tests to determine their suitability for your applications. This is because 3M cannot accept any responsibility or liability direct or consequential for loss or damage caused as a result of our recommendation</p>

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Industrial Adhesives & Tapes Division

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