

[METRIC]
A-A-3097
May 6, 1997
Superseding
MIL-A-46050C
December 18, 1979

COMMERCIAL ITEM DESCRIPTION

ADHESIVES, CYANOACRYLATE, RAPID ROOM TEMPERATURE-CURING,
SOLVENTLESS

The General Services Administration has authorized the use of this commercial item description by all federal agencies.

1. SCOPE. This commercial item description covers two types of solventless, room-temperature curing, cyanoacrylate adhesives for use with or without an activator when speed of curing is a primary consideration. It also covers the activator which may be used to provide even faster curing and to enable the adhesives to bond to otherwise inhibiting surfaces. These adhesives are used for non-structural applications requiring one-component bonding of small, well-mated surfaces where heat and/or pressure cannot be applied.

2. CLASSIFICATION. The adhesives and activators shall be of the following types and classes as specified.

2.1 Adhesive types and classes.

Type I - methyl-2-cyanoacrylate

Type II - ethyl-2-cyanoacrylate

Class 1 - low viscosity, 0.001-0.07 Pa-s (1-70 centipoises)

Class 2 - medium viscosity, 0.07-0.40 Pa-s (70-400 centipoises)

Beneficial comments, recommendations, additions, deletions, clarifications, etc and any other data which may improve this document should be sent to: General Services Administration, GSA Center (10FTE), Auburn, Washington 98001.

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Class 3 - medium-high viscosity, 400-4000 centipoises
(0.40-4.0 Pa-s)

Class 4 - high viscosity, 4000-10,000 centipoises (4.0-10.0
Pa-s)

Class 5 - thixotropic gel

2.2 Activators. Activator/accelerators supplied for use with these adhesives shall be usable for both types I and II.

3. SALIENT CHARACTERISTICS.

3.1 Tensile shear. The tensile lap shear values on steel panels conforming to ASTM A 109 with number 2 edge and number 2 finish shall be a minimum of 14 N/sq mm (2000 psi) when tested in accordance with ASTM D 1002.

3.2 Tensile strength. The tensile strength on steel conforming to ASTM A 109 shall be a minimum of 20 N/sq mm (3000 psi) when tested in accordance with ASTM D 2095.

4. REGULATORY REQUIREMENTS.

4.1 The offeror/contractor is encouraged to use recovered materials to the maximum extent practicable in accordance with paragraph 23.403 of the Federal Acquisition regulation.

5. QUALITY ASSURANCE PROVISIONS.

5.1 Product conformance. The products provided shall meet the salient characteristics of this commercial item description, conform to the producer's own drawings, specifications, standards, and quality assurance practices and be the same product offered for sale in the commercial marketplace. The government reserves the right to require proof of such conformance.

6. PACKAGING. Packaging, preservation, packing, and marking shall be as specified in the contract or purchase order.

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7. NOTES.

7.1 Copies of ASTM standards are available from the American Society for Testing and Materials, 100 Barr Harbor Drive, West Conshohocken, PA 19428-2959.

7.2 Steel conforming to ASTM A 109 is equivalent to alloy 1010 cold-rolled, low carbon steel.

Preparing Activity:
GSA-FSS