

PRODUCT DATA SHEET

SikaFast®-2590

2-component universal Super Glue

TYPICAL PRODUCT DATA (FURTHER VALUES SEE SAFETY DATA SHEET)

Properties	Component A	Component B
Chemical base	Ethyl Cyanoacrylate	
Color (CQP001-1)	Clear	White
	Color mixed	Cream opaque
Cure mechanism	Polymerization	
Density	1.1 kg/l	
Mixing ratio	by volume 4 : 1	
Consistency	Thixotropic gel	
Application temperature	5 – 40 °C	
Open time (CQP526-2)	4 minutes ^A	
Handling time	on Aluminum	2 minutes ^{A,B}
	on Wood	4 minutes ^{A,B}
Tensile lap-shear strength (CQP046-6 / ISO 4587)	See table ^A	
Glass transition temperature (CQP509-1 / ISO 6721)	87 °C	
Shelf life	9 months ^C	

CQP = Corporate Quality Procedure

^{A)} 23 °C / 50 % r. h.^{B)} depends on several factors, see Cure Mechanism^{C)} Stored at temperature below 25 °C / not exposed to direct sun light

DESCRIPTION

SikaFast®-2590 is a fast curing and gap-filling two-component Universal "Super Glue", based on ethyl-cyanoacrylate technology. It offers a long open time combined with fast curing. Due to its viscosity SikaFast®-2590 is well suited for vertical and overhead applications.

PRODUCT BENEFITS

- Wide adhesion range
- Gap filling up to 5 mm
- Can be grinded and painted
- High strength and good shock absorbing properties
- Bonds porous materials (wood, cork, leather)
- Low blooming and low odor

AREAS OF APPLICATION

SikaFast®-2590 is designed for quick repairs or bonding of a broad variety of materials, even with irregular surfaces. Due to the good gap-filling properties SikaFast®-2590 can be used for re-construction of broken pieces as well as to fill cracks. Alternatively it can be used to strengthen weak parts or be used as chemical anchoring of e.g. small screws and hooks. Seek manufacturer's advice and perform tests on original substrates before using SikaFast®-2590 on materials prone to stress cracking. This product is suitable for experienced professional users only. Test with actual substrates and conditions have to be performed to ensure adhesion and material compatibility.

CURE MECHANISM

SikaFast®-2590 cures by polymerization when mixed.

The open and handling time are influenced by adhesive thickness, substrate surface and temperature, e.g. as higher the temperature as shorter the open and fixture time and vice versa.

CHEMICAL RESISTANCE

In the view of potential chemical or thermal exposure, it is required to conduct a project related testing.

ADHESION RESULTS

Due to the diversity of substrates, preliminary tests are mandatory. The following table summarizes lap-shear test results obtained with different standard substrates. Consider the results below as indications only.

Substrate	Strength	FM ^A
AlMg ³	5 MPa	C
Stainless steel	5 MPa	C
Beech wood	6 MPa	S
PC	4 MPa	A
PVC	4 MPa	S
PMMA	4 MPa	C
ABS	5 MPa	S

Table 1: According ISO 4587 (bond line thickness 0.5 mm)

^A Failure mode: Adhesion, Cohesive, Substrate

METHOD OF APPLICATION

Surface preparation

Surfaces must be clean, dry and free from grease, oil and dust. Remove all loose particles or residues by cleaning it thoroughly, for example with an IPA wipe.

Due to the diversity of materials, preliminary tests with original substrates are necessary.

Application

SikaFast®-2590 is applied with a mixing ratio of 4 : 1 by volume through a static mixer.

Consider that if applied in large masses, heat is generated by the exothermic reaction. The mixed adhesive has an open time of approx. 4 minutes and achieves handling strength in approx. 2 - 4 minutes after joining on thin layer applications. Optimum temperature for the bonding process is between 15 °C and 25 °C. The influence of the reactivity by temperature changes has to be respected.

After the open time has elapsed the bonded parts must not be moved against each other anymore. When the handling time is reached the parts can be moved if no additional stress is distributed to the bond line.

Removal

Uncured excess of SikaFast®-2590 can be removed easily before curing with a dry wipe, with Sika® Remover-208 or another suitable solvent. Once the adhesive is cured it can only be removed mechanically.

Hands and exposed skin shall be washed immediately using Sika® Cleaner-350H towels or a suitable industrial hand cleaner and water.

Do not use solvents on skin.

FURTHER INFORMATION

The information herein is offered for general guidance only. Advice on specific applications is available on request from the Technical Department of Sika Industry.

Copies of the following publications are available on request:

- Safety Data Sheets

PACKAGING INFORMATION

Syringe	10 ml
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BASIS OF PRODUCT DATA

All technical data stated in this document are based on laboratory tests. Actual measured data may vary due to circumstances beyond our control.

HEALTH AND SAFETY INFORMATION

For information and advice regarding transportation, handling, storage and disposal of chemical products, users shall refer to the actual Safety Data Sheets containing physical, ecological, toxicological and other safety-related data.

DISCLAIMER

Any information or suggestions for use concerning Sika's products, which we either in writing or orally have given buyers or end-users of the product, have been given in good faith based on our own experiences and based on approved praxis and the technological and scientific knowledge on the time of giving such suggestions and information, which are given without any type of guarantees, and which do not lead to any further responsibility from Sika Danmark A/S, besides what is stated in the sales agreement in question. The buyer or end-user should themselves investigate or otherwise make sure, that our products are suitable for the use in question and further make sure that the products are kept and used correct and in agreement with the published rules and considering the actual conditions in order to avoid damages or less satisfactory results. Any order is accepted and any deliverance is affected according to the general terms of sales and delivery from Sika Danmark A/S, which are considered known and accepted, and which could be handed out when asked for. Our catalogues are not up-dated automatically. The present product data sheet is only for use in Denmark. Values stated in the present product data sheet should be seen as recommended, unless stated otherwise.

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Version 02.01 (03 - 2023), en_DK
013205025903001000

