

GENERAL INFORMATION:

SAF-T-LOK cyanoacrylate adhesives are a specialized series of single component, solvent free liquids that are individually formulated for instant bonding of mated metal, plastic or rubber parts and assemblies.

Instant Bonder adhesives cure at room temperature without pressure, to provide exceedingly high bond strengths. Cure is catalyzed by weak alkaline materials including, trace amounts of moisture on the surface of parts to be bonded. Shrinkage is negligible because **Instant Bonder** adhesives contain 100% reactive materials.

PRODUCT DESCRIPTION:

SAF-T-LOK Methyl Series Instant Bonders are offered in three **Instant Bonder** grades, which were developed to provide a choice of bonding engineered substrates. This methyl series of cyanoacrylate products are used particularly for metal or rubber where they provide slightly higher bond strength and faster cure in most applications. The choice of viscosity permits selection of a product thickness to accommodate the bonding gap of specified assemblies.

PHYSICAL PROPERTIES:**State: Liquid**

Product	IBM 5	IBM 45	IBM 100
Viscosity (cps)	5	45	100
Vapor Pressure, mm Hg @77°F	<1	<1	<1
Specific Gravity, @77°F	1.04	1.05	1.07
Flashpoint TCC F	>178F° (81°C)	>178F° (81°C)	>178F° (81°C)

State: Solid

Typical Bond Thickness	0.002	0.004	.005"
Temperature Range	-65° to 175°F (-54° to 79°C)	-65° to 175°F (-54° to 79°C)	-65° to 175°F (-54° to 79°C)
Cure Speed (steel to steel)	< 7 sec	< 10 sec	< 15 sec
Gap Fill (in)	0.002"	0.004"	0.005"

Strength Data:

Tensile Sheer Strength, psi			
Steel	2700 (±10%)	2700 (±10%)	2700 (±10%)
Aluminum	2400 (±10%)	2400 (±10%)	2400 (±10%)
Copper	2100 (±10%)	2100 (±10%)	2100 (±10%)

NOTE: This product is not recommended for use with pure oxygen systems.

IMPORTANT NOTICE: All statements and technical data contained herein are based on tests we believe to be reliable, but the accuracy of completeness thereof is not guaranteed. It is recommended that the buyer test this product to determine its suitability for his application before use. **SAF-T-LOK International Corporation** is not responsible for loss, claim or damages resulting from use of its products.

TECHNICAL SUPPORT

Our technical support team stands ready to assist you with your technical questions regarding your SAF-T-LOK products. On-Site support when necessary within 24 hours.

PART NUMBERS

IBM 5 40621,31,41,51

IBM 45 44621,31,41,51

IBM 100 41101,05,21,31,41,51

SPECIFICATIONS:

MIL-A-46050C AA-3097

IBM 5 1/1 1/1

IBM 45 1/1 1/1

IBM 100 1/2 1/2

TURNKEY SOLUTIONS

As an ISO 9001:2015 certified company, SAF-T-LOK can design or refine products to fit your company's specific needs and requirements.

For more information on any of our products or services please