

#### TECHNICAL SUPPORT

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

#### PART NUMBERS

IB NF	40121, 31, 41, 51
IB B	40301, 21, 31, 41, 51
IB 101	40411, 21, 31, 41, 51
IB SI	40721, 31, 41, 51
IB HT	41221, 31, 41, 51
IB HI	41621, 31, 41, 51
IB EPDM	41721, 31, 41, 51
IB GEL	44022

#### SPECIFICATIONS

Product MIL-A-46050C A-A-3097		
IB NF	II/2	II/2
IB EPDM	II/2	II/2
IB101	I/2	I/2
IB SI	II/2	II/2
IB HT	II/2	II/2
IB HI	II/3	II/3
IB BLACK		II/3
IB GEL		II/5

#### 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 visit us on the Web at:  
www.saflok.com

### 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 metals, 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 amount of moisture on the surface of parts to be bonded. Shrinkage is negligible because **Instant Bonder** adhesives contain 100% reactive materials. Solvent resistance is very good.

### PRODUCT DESCRIPTION:

**SAF-T-LOK Specialty Series Instant Bonders** are offered in many varieties, which were developed to provide a range of viscosities for specific bonding requirements with engineered substrates. This specialty series of cyanoacrylate products satisfies most application requirements. The range of viscosity permits selection of a product thickness to accommodate the bonding gap of specified assemblies.

### PHYSICAL PROPERTIES:

#### State: Liquid

Product	IB HT	IB NF	IB EPDM	IB 101	IB SI	IB HI	IB B	IB GEL
Viscosity (cps)	100	100	100	100	100	1500	3000	50,000
Gap Fill (in)	0.004	0.010	0.010	0.004	0.01	0.012	0.012	0.015
Vapor Pressure, mm Hg @70°C	10	10	10	10	10	10	10	10
Specific Gravity, @ 77°F / 25°C	1.06	1.10	1.10	1.09	1.10	1.10	1.10	1.05
Refractive Index, n20C/D+/-03	1.45	1.45	1.45	1.45	1.45	1.45	1.45	1.45
Solubility Parameter	10.7	10.8	10.7	10.7	10.7	10.7	10.8	10.7

#### State: Solid

Softening Point	304°F	311°F	310°F	306°F	306°F	302°F	301°F	301°F
Heat Distortion	245°F	304°F	292°F	250°F	250°F	245°F	240°F	240°F
Glass Transition	341°F	347°F	345°F	342°F	342°F	341°F	340°F	340°F
Volume Shrinkage, %	13	15	14	13	13	12	12	12
Rockwell Hardness, M	73	75	75	74	74	73	72	72
Cured Temperature Range	-65°F to 300°F	-65°F to 180°F (-54°C to 82°C) 0<2						
Outgassing, 10 <sup>4</sup> 6mmHg, 72°F								
Elongation, %								
Dielectric Constant, 1 mhz	3.85	3.98	3.79	3.9	3.89	3.85	3.94	3.77
Volume Resistivity, ohm-cm(x10 <sup>12</sup> )	8.4	8.6	8.5	8.5	8.5	8.4	8.4	8.3

#### Strength Data:

Impact. Ft-lbs, ASTM-D950	8 to 12	3 to 5	3 to 5	15 to 25	3 to 5	15 to 25	4 to 6	3 to 5
Tensile, Steel, psi, ASTM-D2095	4000 (±10%)	3000 (±10%)	4000 (±10%)	5000 (±10%)	4000 (±10%)	4000 (±10%)	4000 (±10%)	4000 (±10%)
<b>Tensile Shear, psi, ASTM-D1002:</b>								
Steel	2300 (±10%)	2700 (±10%)	2200 (±10%)	2700 (±10%)	2400 (±10%)	2300 (±10%)	2700 (±10%)	2000 (±10%)
Aluminum	1600 (±10%)	1600 (±10%)	1600 (±10%)	1600 (±10%)	1600 (±10%)	1600 (±10%)	1600 (±10%)	1600 (±10%)
ABS	SF*	SF*	SF*	SF*	SF*	SF*	SF*	SF*
Nylon	SF*	SF*	SF*	SF*	SF*	SF*	SF*	SF*
Rigid PVC	SF*	SF*	SF*	SF*	SF*	SF*	SF*	SF*
SBR	SF*	SF*	SF*	SF*	SF*	SF*	SF*	SF*
EPDM	100 (±10%)	100 (±10%)	100 (±10%)	100 (±10%)	100 (±10%)	100 (±10%)	100 (±10%)	100 (±10%)

\*Substrate Failure (adhesive bond was stronger than substrate)

Note: These products are not recommended for use on 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.