

SAF-T-LOK CYANOACRYLATE ADHESIVES

INSTANT BONDER HIGH IMPACT

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, 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. Solvent resistance is very good.

PRODUCT DESCRIPTION: INSTANT BONDER 1500 HI ethyl cyanoacrylate was developed to provide impact resistance and moderate gap filling viscosities for specific bonding requirements with engineered substrates. This ethyl cyanoacrylate product satisfies most applications requirements.

Viscosity (cps)	1500
Gap Fill (in)	.012
Tensile Strength (psi)	5000
Impact Strength (psi)	15-25

Larger bond line gaps result in somewhat slower cure and lower bond strength. Products are packaged in 1 ounce bottles, 10 per case and 1 pound bottles, 2 per case. Gap filling and porous substrate bonding can be improved by the use of SAF-T-LOK Accelerator.

PRODUCT CHARACTERISTICS:

Base	Ethyl cyanoacrylate
Color	Colorless/Transparent
Solids Content	100%
Solvent Content	Zero
Specific Gravity	1.10
Refractive Index	Similar to glass (1.45 + .03)
Flash Point (SETA)	185°F
Resistance Qualities	
(1) Temperature	Varies with substrate and exposure though in general optimum bonding performance within range of 114° to 180°F.
(2) Water	Unaffected for several weeks, after which poorly designed joint strength may decrease as much as 25% in shear values.
(3) Oils	Good resistance to motor oils.
(4) Dilute Acids/Alkalis	Generally good, though prolonged immersion can decrease adhesive strength.

Shelf life is approximately 1 year when stored in dark, cool area. Instant Bonder adhesive should be kept in a cool, dry location. For best results, store in a refrigerator at 35° to 40°F. Exposure to sunlight is to be avoided.

10/1/90