

Hi-Temp Instant Bonders

Technical Data Sheet

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. Solvent resistance is very good.

PRODUCT DESCRIPTION: *SAF-T-LOK Hi-Temp Instant Bonder* was developed to provide higher Temperature resistance for specific bonding requirements with engineered substrates. This ethyl cyanoacrylate satisfies many applications industry requirements and performs to 300°F.

Viscosity (cps)	100
Gap Fill (in)	.004
Tensile Strength (psi)	4000
Impact Strength (psi)	8-12

Larger bond line gaps result in somewhat slower cure and lower bond strength. 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	1.06
Refractive Index	1.45 (Similar to glass)
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 300°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) Acids/Alkali - Generally good for dilute solutions, though prolonged immersion can decrease adhesive strength.

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 Corporation* is not responsible for loss, claim or damages resulting from use of its products.