

SAF-T-LOK®

Ethyl Series 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 Ethyl Series Instant Bonders** are offered in various grades which were developed to provide a range of viscosities for specific bonding requirements with engineered substrates. This ethyl series of cyanoacrylate products satisfies most applications requirements. The range of viscosity permits selection of a product thickness to accommodate the bonding gap of specified assemblies.

	IB5	IB 20	IB 45	IB 100	IB 609	IB 1500	IB 2500
Viscosity (cps)	5	20	45	100	600	1500	2500
Gap Fill (in)	.002	.002	.003	.004	.006	.010	.015

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 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) 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.