

Methyl Series Instant Bonder

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.

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.

	<u>IBM 5</u>	<u>IBM 45</u>	<u>IBM 100</u>
Viscosity (cps)	5	45	100
Gap Fill (in)	.002	.002	.004

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	Methyl cyanoacrylate
Color	Colorless/Transparent
Solids Content	100%
Solvent Content	Zero
Specific Gravity	1.09
Refractive Index	1.45 (Similar to glass)
Vapor Pressure	10mm at 170°F
Flash Point (SETA)	167°F

Resistance Qualities:

- (1) Temperature -Varies with substrate and exposure though in general optimum bonding performance within range of -114° to 168°F
- (2) Water -Unaffected for several weeks, after which poorly designed joint strength may decrease as much as 45% in shear values.
- (3) Oils -Good resistance to motor oils.

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.