

SAF-T-LOK®

SURFACE INSENSITIVE 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, 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 Surface Insensitive is a modified ethyl cyanoacrylate that was developed to provide moderate gap filling for specific bonding requirements where surfaces are contaminated with oil, silicone grease or release agents. This ethyl cyanoacrylate product satisfies many applications requirements.

Viscosity (cps)	100
Gap Fill (in)	.01
Tensile Strength (psi)	4000
Impact Strength (psi)	3-5

Larger bond line gaps result in somewhat slower cure and lower bond strength. Products are packaged in 20 gram 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) Acids/Alkalis - 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.