

ACCRAbond

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TECHNICAL DATA SHEET

INSTAbond® SI-50
Cyanoacrylate Adhesive

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PRODUCT DESCRIPTION:

INSTAbond® SI-50 is a single component cyanoacrylate for use on difficult to bond surfaces. These includes acidic surfaces, porous substrates and material bonded under lower humidity conditions. INSTAbond® SI-50 his technology will bond most close fitting smooth surfaces in seconds. INSTAbond® SI-50 has no solvent and low toxicity, which make it very popular and easy to use. Additionally, this material requires no mixing or heating.

INSTRUCTIONS FOR USE:

To maximize performance of INSTAbond® SI-50 cyanoacrylate, clean and degrease all substrates before applying adhesive. Make sure substrates are dry before applying adhesive. Apply a thin bond line for best results.

Difficult to bond plastics like polyethylene, polypropylene, ABS, EPDM and silicone rubber will require INSTAbond® PDQ Primer for best results.

If setting time is longer than desired (caused by low humidity or large gap fill), use INSTAbond® PDQ Accelerator.

PROPERTIES OF MATERIALS AS SUPPLIED:

Property	Test Method	Unit	Value
Chemical Type	---	---	Ethyl Cyanoacrylate
Appearance	Visual	---	Transparent, clear liquid
Density	ASTM D-792	gms / cm ³	1.05
Brookfield Viscosity	ASTM D-2393	cPs	45-60

PROPERTIES OF CURED MATERIAL:

Property	Test Method	Unit	Value
Gap Filling	---	---	.05mm
Tensile Strength steel/steel	ASTM D-2095	N/mm ²	25-30
Shear Strength Steel/ steel	ASTM D-1002	N/mm ²	15.26

CURED SPEED:

Results based on 50% relative humidity at 22°C.

Substrate	Unit
Plastic	8-10 seconds
Rubber	6-8 seconds
Metal	6-8 seconds
Wood	6-8 seconds

STORAGE AND HANDLING:

The shelf life of INSTAbond® SI-50 is 12 months at 25°C. For best results, store in cool area and out of direct sunlight.

PACKAGING:

INSTAbond® SI-50 is available in standard sizes: 1-oz, 2-oz, 4-oz, 500 gram bottles. Other package sizes are available upon request.

NOTE:

The information contained in this document is furnished for information only and it's believed to be reliable based on previous evaluations. We cannot assume responsibility for the results obtained by others over whose methods we have no control. It is the user's responsibility to determine suitability for user's application based on user's production methods. This data should only be used as a guide for determining feasibility for a particular application.