

Revised
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9411 Corsair Road
Frankfort, IL 60423
1-800-552-0299 Phone
1-815-464-5650 Fax

EMERGENCY PHONE 1-800-255-3924

TECHNICAL DATA SHEETS

SI120

Description:

Surface insensitive instant adhesive used in applications that require exceptionally fast cure speeds, difficult to bond surfaces and acidic surfaces, wood, PVC, substrates that contain plasticizers, certain types of EPDM, etc. Handling strength in 8 to 10 seconds. SI 120 has a viscosity of 120 cps and is capable of filling gaps up to .006.

Physical Properties:

COLOR: Clear
VISCOSITY: 120cps
BASE: Ethyl
STRENGTH: 2800 / 4200
TEMPERATURE RANGE: - 65 - 200°F
CURE SPEED: 8 seconds
(FIXTURE)
FULL CURE: 8 hours
MIL A 46050 Type II
Class II
SPECIFIC GRAVITY 1.05
SOLUBLE IN: Remove Debonder

Storage

The SI series is ideally stored in a cold, dry location in unopened containers. Optimal storage temperature is under 50°F. To prevent contamination of unused product, do not return any material to its original container. For specific shelf life contact Adhesive Systems Inc.

Handling Characteristics:

| Shear Strength, ASTM D1002, DIN 53283 | Value | Range |
|--|----------------|----------------------------|
| Grit Blasted Steel, N/mm ² (psi) | 28 (3770) | 24 to 32 (3195 to 4355) |
| Etched Aluminum, N/mm ² (psi) | 20 (3770) | 16 to 24 (3195 to 4355) |
| ABS, N/mm ² * | >7 (>885) | |
| PVC, N/mm ² * | >5 (>640) | |
| Polycarbonate, N/mm ² * | >6 (>825) | |
| Phenolic, N/mm ² * | 12 (160) | 6 to 18 (775 to 2450) |
| Neoprene rubber, N/mm ² * | >12 (>1600) | |
| Nitrile rubber, N/mm ² * | >12 (>1600) | |
| Tensile Strength, ASTM D2095, DIN 53283 | | |
| Grit Blasted Steel, N/mm ² (psi) | 20 (3000) | 14 to 28 (1900 to 4000) |

* Substrate Failure

Engineering Excellence

For technical information
and support call **1-800-552-0299** or visit our website at

www.instantca.com