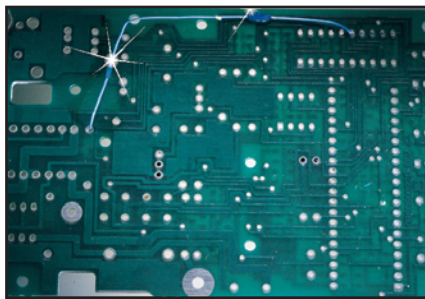


INSTANT BONDING

SAF-T-LOK Instant Bonder cyanoacrylate adhesives provide exceptional tensile shear strengths within seconds at room temperature. Materials such as metals, plastics, rubber and glass may be bonded with these single part adhesives. Both Ethyl and Methyl products are available and meet MIL-A-46050C and CID A-A-3097.

General properties of the primary Instant Bonder line are shown below, but see IB Technical Data Sheets for detailed properties of these products. Refer to page 11 for Accelerators, Debonder, Surface Conditioner and Cleaners.

Available Packaging of these products and IB20, IB300, IB600 as well as Accelerators etc. by Item No. are shown on Page 25.



Wire tacking

IB5—Penetrating

- Fast cure
- High strength
- Low viscosity
- Penetrating for post application
- Wicking 360° circumference

IB45—General Purpose

- Fast cure
- High strength
- Low viscosity
- Bonds rubber, metal, plastics
- Close fitting parts

IB100—Plastic Bonder

- Fast cure
- Weather resistant
- Medium viscosity
- Compensates for irregularities

IB1500—Gap Filling

- Slower cure
- High viscosity
- Porous surfaces
- Poorly mated parts
- Bonds rubber, metal, plastics

IB—Hi-Temp

- Fast cure
- Temperature resistant to 300°F
- Medium viscosity
- Compensates for irregularities

IB—Gel

- Gap filling
- All surfaces
- No-run
- Vertical surface application

IB Black— Impact

- Black color
- High viscosity
- Good shock/impact resistance

IB Surface Insensitive

- Rapid cure
- Medium viscosity
- Flexible EPDM bonds

IB—Non-Frosting

- Fast cure
- Low blooming
- Medium viscosity
- Low odor

IB—101

- “O” Ring bonder
- Fast cure
- High Strength



Typical Properties	IB-5	IB-45	IB-100	IB-1500	IB-2500	IBM-5	IBM-45	IBM-100	HI TEMP	BLACK
Chemical Type	Ethyl	Ethyl	Ethyl	Ethyl	Ethyl	Methyl	Methyl	Methyl	Ethyl HB	Ethyl
Viscosity (cps) Brookfield at 77°F	5	45	100	1500	2500	5	45	100	100	2500
Specific Gravity	1.05	1.05	1.06	1.06	1.06	1.10	1.09	1.08	1.08	1.10
Flashpoint COC (°F)	185	185	185	185	185	167	167	167	185	185
Vapor Pressure at 70°C. mm Hg	8	8	8	8	8	10	10	10	8	8
Melting Point	365	365	365	365	365	400	400	400	370	365
Service Temperature Range, °F	-114 to +180	-114 to +180	-114 to +180	-114 to +180	-114 to +180	-114 to +180	-114 to +180	-114 to +180	-114 to +300	-114 to +210
Tensile Shear Strength Steel/Steel, lbs/in ²	4000	4700	4000	4000	4000	5000	5000	5000	3500	4000
Impact Strength Steel/Steel, lbs/in ²	3-5	7-14	3-5	3-5	3-5	3-6	3-6	3-6	8-12	15-25