



SI120

SI120 is a surface insensitive cyanoacrylate adhesive that is used in applications that require faster cure speeds, on parts that are dry, and on parts that may be acidic. The SI Series bonds a wide range of similar and dissimilar surfaces. The SI Series provides exceptional performance in a wide range of applications.

| | |
|---------------------------|----------------|
| Technology / Base | Modified Ethyl |
| Type of Product | Cyanoacrylate |
| Components | One Component |
| Curing | Humidity |
| Appearance / Color | Clear |
| Consistency | Liquid |

Technical Data

| Uncured Material Characteristics | Value | Condition/Method |
|----------------------------------|-----------------------------------|--|
| Viscosity | 120 cPs | |
| Specific Gravity | 1.05 | |
| Storage Condition | < 22°C | |
| Set Time | | |
| Steel | < 10 sec | |
| Aluminum | <10 sec | |
| Neoprene | <5 sec | |
| ABS | <10 sec | |
| PVC | <10 sec | |
| Polycarbonate | <10 sec | |
| Phenolic | <10 sec | |
| Cured Material Characteristics | | |
| Shear Strength | | |
| Steel | >2100 psi | ISO 4587 |
| Aluminum | >1750 psi | ISO 4587 |
| Neoprene | >750 psi | ISO 4587 |
| ABS | >900 psi | ISO 4587 |
| PVC | >900 psi | ISO 4587 |
| Polycarbonate | >900 psi | ISO 4587 |
| Phenolic | >850 psi | ISO 4587 |
| Tensile Strength | >1800 psi | ISO 6922 |
| Damp Heat Aging | 100% | Strength on PC after 500 hrs at 40°C, 95% R.H. |
| Dielectric Constant | 2 to 3.5 at 1kHz | ASTM D150 |
| Dissipation Factor | < 0.02 at 1kHz | ASTM D150 |
| Volume Resistivity | 2 to 10 x 10 ¹⁵ ohm·cm | ASTM D257 |



General Instructions

For optimum results parts should be clean and free from any contamination on the bonding surface. If parts do not mate flush together use a higher viscosity product to compensate for the gap. Factors Affecting Cure Speed Include: GAP: Thin bond line results in faster cure speed. Larger gaps will lengthen cure speed. HUMIDITY: Cure and fixture times can be influenced by the humidity conditions at the time of assembly. The higher the RH the faster cure and fixture times will be. Fixture time data based on our testing is conducted at 50% relative humidity.

Specifications and Approvals

Storage

Store product in unopened containers, out of direct sunlight, in a dry location. Material should be stored at or below 22°C. For extended shelf life unopened containers of the product may be refrigerated.

Safety & Disposal

For safe handling information and disposal instructions on this product, consult the Safety Data Sheet (SDS)

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