

Revised  
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## TECHNICAL DATA SHEETS

### SI1000

#### 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 1000 has a viscosity of 1000 cps and is capable of filling gaps up to .008.

#### Physical Properties:

COLOR: Clear  
VISCOSITY: 1000cps  
BASE: Ethyl  
STRENGTH: 2800 / 4200  
TEMPERATURE RANGE: - 65 - 200°F  
CURE SPEED: 15 seconds  
(FIXTURE)  
FULL CURE: 8 hours  
MIL A 46050 Type II  
Class III  
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 <sup>2</sup> (psi)	28 (3770)	24 to 32 (3195 to 4355)
Etched Aluminum, N/mm <sup>2</sup> (psi)	20 (3770)	16 to 24 (3195 to 4355)
ABS, N/mm <sup>2</sup> * (psi)	>7 (>885)	
PVC, N/mm <sup>2</sup> * (psi)	>5 (>640)	
Polycarbonate, N/mm <sup>2</sup> * (psi)	>6 (>825)	
Phenolic, N/mm <sup>2</sup> * (psi)	12 (160)	6 to 18 (775 to 2450)
Neoprene rubber, N/mm <sup>2</sup> * (psi)	>12 (>1600)	
Nitrile rubber, N/mm <sup>2</sup> * (psi)	>12 (>1600)	
Tensile Strength, ASTM D2095, DIN 53283		
Grit Blasted Steel, N/mm <sup>2</sup> (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](http://www.instantca.com)**