

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

### SI4000

#### Description:

Medium setting: general purpose adhesive designed to bond a wide variety of similar or dissimilar materials. The product is a versatile adhesive offering good climatic, thermal and impact resistance. It's elasticity makes it ideal for bonding dissimilar materials. Handling strength in 15 to 20 seconds. SI 4000 has a viscosity of 4000 cps and is capable of filling gaps up to .009.

#### Physical Properties:

|                    |                 |
|--------------------|-----------------|
| COLOR:             | Clear           |
| VISCOSITY:         | 4000cps         |
| BASE:              | Ethyl           |
| STRENGTH:          | 2800 / 4200     |
| TEMPERATURE RANGE: | - 65 - 200°F    |
| CURE SPEED:        | 10 seconds      |
| (FIXTURE)          |                 |
| FULL CURE:         | 8 hours         |
| MIL A 46050        | Type III        |
|                    | Class III       |
| SPECIFIC GRAVITY   | 1.09            |
| 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><br>(psi) | 28<br>(3770)   | 24 to 32<br>(3195 to 4355) |
| Etched Aluminum, N/mm <sup>2</sup><br>(psi)    | 20<br>(3770)   | 16 to 24<br>(3195 to 4355) |
| ABS, N/mm <sup>2</sup><br>*                    | >7<br>(>885)   |                            |
| PVC, N/mm <sup>2</sup><br>*                    | >5<br>(>640)   |                            |
| Polycarbonate, N/mm <sup>2</sup><br>*          | >6<br>(>825)   |                            |
| Phenolic, N/mm <sup>2</sup><br>*               | 12<br>(160)    | 6 to 18<br>(775 to 2450)   |
| Neoprene rubber, N/mm <sup>2</sup><br>*        | >12<br>(>1600) |                            |
| Nitrile rubber, N/mm <sup>2</sup><br>*         | >12<br>(>1600) |                            |
| Tensile Strength, ASTM D2095, DIN 53283        |                |                            |
| Grit Blasted Steel, N/mm <sup>2</sup><br>(psi) | 20<br>(3000)   | 14 to 28<br>(1900 to 4000) |

\* Substrate Failure

**Engineering Excellence**

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

**[www.instantca.com](http://www.instantca.com)**