Revised

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TECHNICAL DATA SHEETS SI500

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 8 to

10 seconds. SI 500 has a viscosity of 500 cps and is capable of filling gaps up to. 007.

Physical Properties:

COLOR: Clear

VISCOSITY: 500cps BASE: Ethyl STRENGTH: 2700 / 4300

TEMPERATURE RANGE: - 65 - 200°F CURE SPEED: 8 seconds (FIXTURE)

FULL CURE: 8 hours MIL A 46050 Type II Class I

SPECIFIC GRAVITY 1.05

SOLUBLE IN: Remove Debonder

|  |  |  |  |  |
| --- | --- | --- | --- | --- |
|  |  | % of initial strength | | |
| Enviroment | C° | 100 hr | 500 hr | 1000 hr |
| Motor Oil | 40 | 100 | 100 | 97 |
| Gasoline | 22 | 100 | 100 | 100 |
| Isopropanol | 22 | 100 | 100 | 100 |
| Ethanol | 22 | 100 | 100 | 100 |
| Freon TA | 22 | 100 | 100 | 100 |
| 1,1,1 Trichloroethane | 22 | 100 | 100 | 100 |
| Heat/Humidity 95% RH | 40 | 83 | 78 | 71 |
| HeatHumidity 95% RH On Polycarbonate | 40 | 100 | 100 | 100 |

Handling Characteristics:

Shear Strength, ASTM D1002, DIN 53283 Value Range

Girt Blasted Steel, N/mm^2 28 24 to 32 (psi) (3770) (3195 to 4355)

Etched Aluminum, N/mm^2 20 16 to 24 (psi) (3770) (3195 to 4355)

ABS, N/mm^2 >7

\* (psi) (>885)

PVC, N/mm^2 >5

\* (psi) (>640)

Polycarbonate, N/mm^2 >6

\* (psi) (>825)

Phenolic, N/mm^2 12 6 to 18

\* (psi) (160) (775 to 2450)

Neoprene rubber, N/mm^2 >12

\* (psi) (>1600)

Nitrile rubber, N/mm^2 >12

\* (psi) (>1600)

Tensile Strength, ASTM D2095, DIN 53283

Grit Blasted Steel, N/mm^2 20 14 to 28

(psi) (3000) (1900 to 4000)

\* Substrate Failure

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.



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