



INSTANT ADHESIVE LIQUID • FAST SETTING SURFACE INSENSITIVE

PART NO. **CA120SI**

DESCRIPTION

CA120SI is a surface insensitive instant adhesive that is used in applications that require faster cure speeds, on parts that are dry, and on parts that may be acidic. It bonds a wide range of similar and dissimilar surfaces. CA120SI provides exceptional performance in a wide range of applicators.

PHYSICAL PROPERTIES

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

TECHNICAL DATA

Property	Value	Method/Condition
Rheology		
Viscosity	120 +/- 20 cPs	Brookfield SC4-27, @ 25°C
Density		
Specific Gravity	1.05	N/A
Uncured Materials Characteristics		
Flash Point	80°C (176°F)	N/A
Set Time	Steel (sec)	<10
	ABS (sec)	<10
	EPDM (sec)	<5
Shelf Life	12mo	N/A
Cured Materials Characteristics		
Full Cure Time	24 hours	N/A
Cure Appearance	Clear	N/A
Service Temperature	-55 to 95°C	N/A
Cured Mechanical Properties		
See Graphs and Table		



INSTRUCTIONS

Surfaces to be bonded should be clean and dry. Dispense a drop or drops to one surface only. Apply only enough to leave a thin film layer after compression. Press parts together and hold firmly for a few seconds. Good contact is essential. An adequate bond develops in less than one minute and maximum strength is attained in 24 hours. Wipe off excess adhesive from the top of the container and recap. Products, if left uncapped, may deteriorate by contamination from moisture in the air. Because products cure by polymerization, whitening may appear on the surface of the container or the bonded materials. This will not affect adhesive performance. Factors affecting cure speed include gap size and humidity. Thin bond line results in faster cure speed. Larger gaps will lengthen cure speed. 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.

CURING PERFORMANCE

Ambient surface moisture initiates the curing process. Handling strength is reached in a short time, and will vary based on environmental conditions, bond line gap, and other factors. Product will continue to cure for at least 24 hours before full strength and solvent resistance is developed.

STORAGE

Containers should be stored in a cool, dry, dark area. Storage temperature 15.5°C - 25°C (60°F - 77°F), without exposure to direct light or heat. Do not refrigerate.

SPECIFICATIONS AND APPROVALS

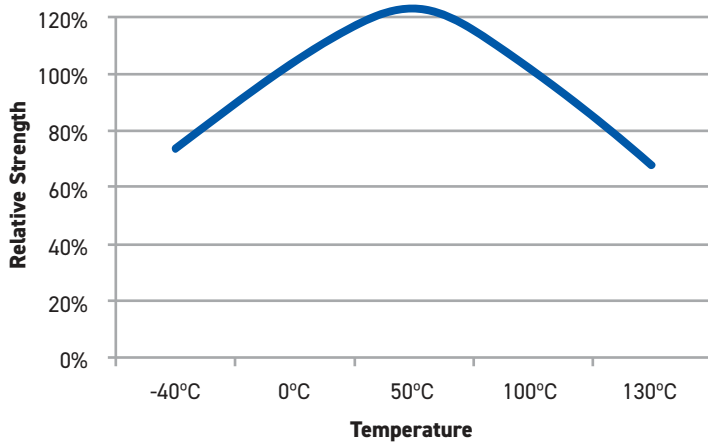
Mil-A-46050C, Type II Class 2,
CID A-A-3097, Type II Class 2

SAFETY & DISPOSAL

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



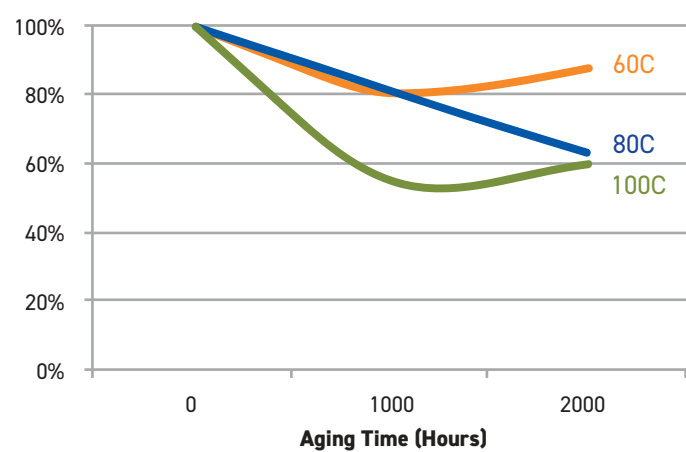
HOT STRENGTH %RT Strength, Tested at Temperature



SOLVENT RESISTANCE

Solvent	Resistance
Alcohol	Excellent
Ester (aromatic)	Excellent
Ketone (aromatic)	Poor
Aliphatic hydrocarbon (alkanes)	Good
Aromatic hydrocarbons	Good
Halogenated hydrocarbons	Poor
Weak aqueous acid	Excellent (Poor if concentrated)
Weak aqueous base	Excellent (Poor if concentrated)

HEATING AGING Aged at Temperature Indicated & Tested at 22°C

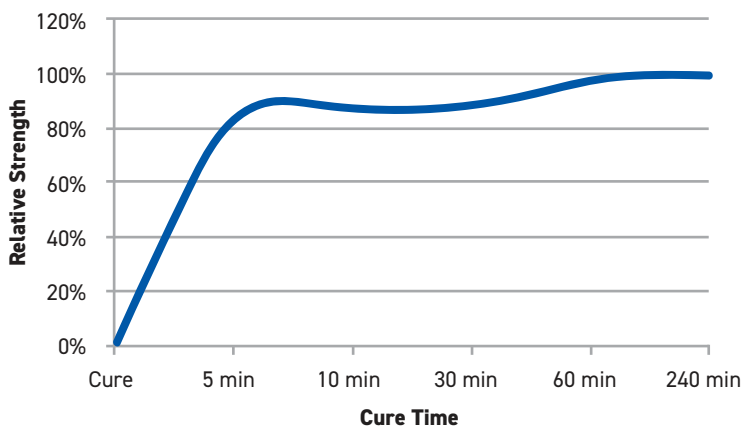


PERFORMANCE OF CURED ADHESIVE

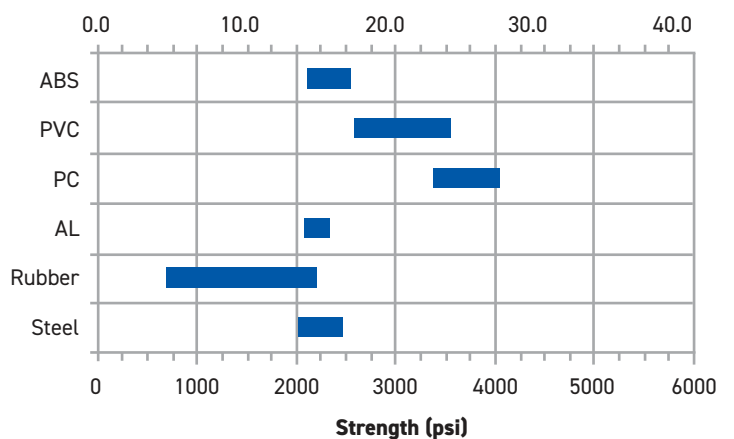
Substrate	N/mm ²	PSI
Steel	13.8 to 17.0	2000 to 2460
Rubber*	4.8 to 15.2	690 to 2200
AL	14.3 to 16.1	2070 to 2330
PC**	23.3 to 27.8	3375 to 4035
PVC**	17.7 to 24.4	2570 to 3545
ABS**	14.5 to 17.5	2110 to 2540

*Rubber figures given are typical. Your results may vary by specific rubber type.
 Tested to ASTM 4501 *n/r = not recommended

TIME UNTIL FULL CURE %RT Strength



PERFORMANCE RANGE BY SUBSTRATE (N/mm²)



DISCLAIMER

IMPORTANT: The information, specifications, procedures and recommendations herein (together "information") are based on our experience and we believe these to be accurate. No representation, guarantee or warranty is made as to the accuracy or completeness of the information or that the information will avoid losses or damages or give desired results. It is user's sole responsibility to test and determine the suitability of any product for the intended use. Tests should be repeated if materials or conditions change in any way. The user is advised to review the specific context of the intended use to determine whether the user's intended use violates any law or infringes upon any patent(s). No employee, distributor or agent has any right to change these facts and offer a guarantee of performance.

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TDS - Instant Adhesive - CA120SI - Updated 11-10-2021



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