DESCRIPTION:
SI 120 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.

PHYSICAL PROPERTIES:
- **Color:** Clear
- **Viscosity:** 120 cps
- **Specific Gravity:** 1.05
- **Base:** Modified Ethyl

PERFORMANCE PROPERTIES:
- **Substrate**
  - **Steel:** < 10 Seconds, > 2100 psi
  - **Aluminum:** < 10 Seconds, > 1750 psi
  - **Neoprene:** < 5 Seconds, > 900 psi
  - **ABS:** < 10 Seconds, > 900 psi
  - **PVC:** < 10 Seconds, > 900 psi
  - **Polycarbonate:** < 10 Seconds, > 900 psi
  - **Phenolic:** < 10 Seconds, > 850 psi
- **NOTE:** Method used, ISO 4587.

Tensile Strength:
- **Steel:** > 1800 psi
- **NOTE:** Method used, ISO 6922

ELECTRICAL PROPERTIES:
- **Dielectric Constant (ASTM D 150)**
  - **1 kHz:** 2 to 3.50
- **Dissipation Factor (ASTM D 150)**
  - **< 0.02**
- **Volume Resistivity (ASTM D 257)**
  - **2 x 10^15 to 10 x 10^15**

FACTORS AFFECTING CURE SPEED:
- **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 the cure and fixture times will be. Fixture time data based on our testing is conducted at 50% relative humidity.

CHEMICAL/SOLVENT RESISTANCE:
- **% OF STRENGTH RETAINED AFTER AGING FOR 500 HOURS**
  - **GASOLINE @ 22°C:** 100%
  - **ISOPROPANOL @ 22°C:** 100%
  - **ETHANOL @ 22°C:** 100%
  - **FREON TA @ 22°C:** 100%
  - **MOTOR OIL @ 40°C:** 100%
  - **POLYCARBONATE 40°C @ 95% RH:** 100%

DIRECTIONS FOR USE:
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. Any excess adhesive can be removed using Remove Debonder.

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.