

ADVANCE PERFORMANCE SERIES

Cyanoacrylate Adhesives Bonding

What we bond:

ABS
ACRYLIC
ALUMINUM
BAKELITE
BRASS
CHLOROPRENE
CHROME
COPPER
EPDM
FIBERGLASS
LATEX
NATURAL RUBBER
NBR
NEOPRENE
NITRILE
NYLON
PHENOLIC
POLYCARBONATE
POLYESTER
POLYSTYRENE
PORCELAIN
PVC
SBR
STAINLESS STEEL
VELOX
WOOD

All of the *ADVANCE PERFORMANCE SERIES* products are available in a complete range of viscosities, cure speeds, and performance properties to meet your specific application requirements. These products represent the latest technology in cyanoacrylate adhesives, offering the ultimate in performance and value. When needed products can be custom formulated to meet specific application requirements.

All *ADVANCE PERFORMANCE SERIES*, Instant Adhesives, are available in 2 gram pipettes, 1/2 ounce bottles, 1 ounce bottles, 2 ounce bottles, 1 pound bottles, 4.4 pound containers, 20 kilo containers, and 55 gallon drums. Custom packaging, blister carding, metal tubes, special bottles, cartridges etc. are available upon request. Shelf life is 2 years from date of shipment on most products.

	PRODUCT	BASE	COLOR	GAP FILL	VISCOSITY	STRENGTH	TEMP RANGE	CURE SPEED (FIXTURE/FULL)	SPECIFIC GRAVITY	MIL SPECS A46050 C
RP SERIES, RUBBER AND PLASTIC BONDING CYANOACRYLATES										
General purpose instant adhesives ideal for rubber and plastic bonding. Versatile product line offering a complete range of viscosities and cure times.	RP 5	Ethyl	Clear	.002	5 cps	2700/4300	-65 to +200° F	<5 Sec/8 Hours	1.05	Type II, Class 1
	RP 5L	Ethyl	Clear	.002	5 cps	2700/4300	-65 to +200° F	<10 Sec/8 Hours	1.05	Type II, Class 1
	RP 30	Ethyl	Clear	.003	30 cps	2700/4300	-65 to +200° F	<10 Sec/8 Hours	1.05	Type II, Class 1
	RP 45	Ethyl	Clear	.004	45 cps	2700/4300	-65 to +200° F	<10 Sec/8 Hours	1.05	Type II, Class 1
	RP 100	Ethyl	Clear	.006	100 cps	2700/4300	-65 to +200° F	<10 Sec/8 Hours	1.05	Type II, Class 2
	RP 200	Ethyl	Clear	.006	200 cps	2700/4300	-65 to +200° F	<10 Sec/8 Hours	1.05	Type II, Class 2
	RP 500	Ethyl	Clear	.007	500 cps	2700/4300	-65 to +200° F	<10 Sec/8 Hours	1.05	Type II, Class 2
	RP 750	Ethyl	Clear	.007	750 cps	2700/4300	-65 to +200° F	<12 Sec/8 Hours	1.05	Type II, Class 2
	RP 1000	Ethyl	Clear	.008	1,000 cps	2700/4300	-65 to +200° F	<15 Sec/8 Hours	1.09	Type II, Class 3
	RP 1500	Ethyl	Clear	.008	1,500 cps	2700/4300	-65 to +200° F	<15 Sec/8 Hours	1.09	Type II, Class 3
	RP 2000	Ethyl	Clear	.008	2,000 cps	2700/4300	-65 to +200° F	<15 Sec/8 Hours	1.09	Type II, Class 3
	RP 2400	Ethyl	Clear	.008	2,400 cps	2700/4300	-65 to +200° F	<15 Sec/8 Hours	1.09	Type II, Class 3
	RP 3200	Ethyl	Clear	.008	3,200 cps	2700/4300	-65 to +200° F	<15 Sec/8 Hours	1.09	Type II, Class 3
	RP 4000	Ethyl	Clear	.008	4,000 cps	2700/4300	-65 to +200° F	<15 Sec/8 Hours	1.09	Type II, Class 3
	APS GEL	Ethyl	Clear	.010	Gel	2700/4300	-65 to +200° F	<25 Sec/8 Hours	1.05	Type II, Class 3
M SERIES, METAL BONDING CYANOACRYLATES										
Metal bonding instant adhesives Used to bond metal to itself and other substrates. Available in a complete range of products.	M 5	Methyl	Clear	.002	5 cps	2800/4000	-85 to +200° F	<5 Sec/8 Hours	1.07	Type I, Class 1
	M 60	Methyl	Clear	.004	60 cps	2800/4000	-85 to +200° F	<8 Sec/8 Hours	1.07	Type I, Class 2
	M100	Methyl	Clear	.006	100 cps	2800/4000	-85 to +200° F	<10 Sec/8 Hours	1.09	Type I, Class 2
	M 1000	Methyl	Clear	.008	1,000 cps	2800/4000	-85 to +200° F	<10 Sec/8 Hours	1.09	Type II, Class 3
SI SERIES, SURFACE INSENSITIVE CYANOACRYLATE ADHESIVES										
Surface insensitive instant adhesives 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. Excellent for almost all surfaces.	SI 5	Ethyl	Clear	.002	5 cps	2800/4200	-65 to 200° F	<5 Sec/8 Hours	1.05	Type II, Class 1
	SI 30	Ethyl	Clear	.004	30 cps	2800/4200	-65 to 200° F	<5 Sec/8 Hours	1.05	Type II, Class 1
	SI 120	Ethyl	Clear	.006	120 cps	2800/4200	-65 to 200° F	<8 Sec/8 Hours	1.05	Type II, Class 2
	SI 500	Ethyl	Clear	.007	500 cps	2800/4200	-65 to 200° F	<8 Sec/8 Hours	1.05	Type II, Class 2
	SI 1000	Ethyl	Clear	.008	1,000 cps	2800/4200	-65 to 200° F	<8 Sec/8 Hours	1.05	Type II, Class 3
	SI 1500	Ethyl	Clear	.008	1,500 cps	2800/4200	-65 to 200° F	<8 Sec/8 Hours	1.05	Type II, Class 3
	SI 2000	Ethyl	Clear	.009	2,000 cps	2800/4200	-65 to 200° F	<8 Sec/8 Hours	1.07	Type II, Class 3
	SI 3200	Ethyl	Clear	.009	3,200 cps	2800/4200	-65 to 200° F	<10 Sec/8 Hours	1.09	Type II, Class 3
	SI 4000	Ethyl	Clear	.009	4,000 cps	2800/4200	-65 to 200° F	<10 Sec/8 Hours	1.09	Type II, Class 3
	SI GEL	Ethyl	Clear	.010	Gel	2800/4200	-65 to 200° F	<10 Sec/8 Hours	1.05	Type II, Class 3

Adhesive Systems, Inc.

	PRODUCT	BASE	COLOR	GAP FILL	VISCOSITY	STRENGTH	TEMP RANGE	CURE SPEED (FIXTURE/FULL)	SPECIFIC GRAVITY	MIL SPEC A 46050 C
FS SERIES, FAST SETTING CYANOACRYLATE ADHESIVES										
Fast curing instant adhesives. The latest technology in cyanoacrylates. Ideal in applications where low moisture conditions exist and/or exceptionally fast fixture times are desired. Bonds to a wide range of materials.	FS 5	Modified Ethyl	Clear	.002	5 cps	2700/4200	-65 to+200° F	<2.5 Sec/4 Hours	1.05	Type II, Class 1
	FS 30	Modified Ethyl	Clear	.003	30 cps	2700/4200	-65 to+200° F	<2.5 Sec/4 Hours	1.05	Type II, Class 1
	FS 100	Modified Ethyl	Clear	.006	100 cps	2700/4200	-65 to+200° F	<5 Sec/4 Hours	1.05	Type II, Class 2
	FS 500	Modified Ethyl	Clear	.007	500 cps	2700/4200	-65 to+200° F	<5 Sec/4 Hours	1.05	Type II, Class 2
	FS 1000	Modified Ethyl	Clear	.008	1,000 cps	2700/4200	-65 to+200° F	<7.5 Sec/4 Hours	1.09	Type II, Class 3
	FS 1500	Modified Ethyl	Clear	.008	1,500 cps	2700/4200	-65 to+200° F	<7.5 sec/4 Hours	1.09	Type II, Class 3
	FS 2000	Modified Ethyl	Clear	.008	2,000 cps	2700/4200	-65 to+200° F	<7.5 Sec/4 Hours	1.09	Type II, Class 3
	FS 3200	Modified Ethyl	Clear	.008	3,200 cps	2700/4200	-65 to+200° F	<7.5 Sec 4 Hours	1.09	Type II, Class 3
	FS 4000	Modified Ethyl	Clear	.008	4,000 cps	2700/4200	-65 to+200° F	<7.5 Sec/4 Hours	1.09	Type II, Class 3
	FS Gel	Modified Ethyl	Clear	.010	Gel	2700/4200	-65 to+200° F	<12.5 Sec/4 Hours	1.05	Type II, Class 3
TS SERIES, CLEAR, TOUGHENED INSTANT ADHESIVES										
Excellent impact resistance and thermocycling properties. Ideal for bonding dissimilar materials on a wide range of surfaces.	TS 300	Modified Ethyl	Clear	.006	300 cps	3750	-65 to+250° F	<10 Sec/8 Hours	1.10	Type II, Class 2
	TS 800	Modified Ethyl	Clear	.008	800 cps	3750	-65 to+250° F	<15 Sec/8 Hours	1.10	Type II, Class 3
	TS 2400	Modified Ethyl	Clear	.010	2,400 cps	3750	-65 to+250° F	<15 Sec/8 Hours	1.10	Type II, Class 3
	TS 4000	Modified Ethyl	Clear	.010	4,000 cps	3750	-65 to+250° F	<18 Sec/8 Hours	1.10	Type II, Class 3
HP SERIES, BLACK, TOUGHENED INSTANT ADHESIVES										
Excellent peel, impact, and shear strength. Bonds a wide range of similar and dissimilar materials.	HP 300	Modified Ethyl	Black	.006	300 cps	3750	-65 to+250° F	<10 Sec/8 Hours	1.10	Type II, Class 2
	HP 1000	Modified Ethyl	Black	.009	1,000 cps	3750	-65 to+250° F	<12 Sec/8 Hours	1.10	Type II, Class 3
	HP 4000	Modified Ethyl	Black	.010	4,000 cps	3750	-65 to+250° F	<18 Sec/8 Hours	1.10	Type II, Class 3
	HP 10,000	Modified Ethyl	Black	.012	10,000 cps	3500	-65 to+250° F	<20 sec/8 Hours	1.10	
NI SERIES, LOW ODOR/LOW BLOOM INSTANT ADHESIVES (Butyl)										
Low odor/low bloom instant adhesives. Greatly reduces frosting on parts and the need for sophisticated ventilation.	NI 5	Butyl	Clear	.002	5 cps	1900/3000	-65 to +180° F	<7 Sec/24 Hours	1.05	
	NI 100	Butyl	Clear	.005	100 cps	1900/3000	-65 to +180° F	<7 Sec/24 Hours	1.05	
	NI 500	Butyl	Clear	.007	500 cps	1900/2900	-65 to +180° F	<20 Sec/24 Hours	1.05	
	NI 1000	Butyl	Clear	.008	1,000 cps	1900/3000	-65 to +180° F	<7 Sec/24 Hours	1.05	
NI "E" SERIES, LOW ODOR/LOW BLOOM INSTANT ADHESIVES										
Low odor/low bloom instant adhesive. Eliminates frosting and odors typically associated with cyanoacrylates.	NI 5E	Modified	Clear	.002	5 cps	1900/2700	-65 to +180° F	<10 Sec/24 Hours	1.10	
	NI 100E	Modified	Clear	.006	5 cps	1900/2700	-65 to +180° F	<10 Sec/24 Hours	1.10	
	NI 500E	Modified	Clear	.007	500 cps	1900/2700	-65 to +180° F	<25 Sec/24 Hours	1.10	
	NI 1000E	Modified	Clear	.008	1,000 cps	1900/2700	-65 to +180° F	<10 Sec/24 Hours	1.10	

	PRODUCT	BASE	COLOR	GAP FILL	VISCOSITY	STRENGTH	TEMP RANGE	CURE SPEED (FIXTURE/FULL)	SPECIFIC GRAVITY	MIL SPEC A 46050C
HT SERIES, HIGH TEMPERATURE CYANOACRYLATES										
Excellent high end temperature resistance. Ideal for applications that have a high degree of temperature cycling and/or extended operation at elevated temperatures.	HT 5	Modified Ethyl	Clear	.002	5 cps	2700/4200	-60 TO +275° F	<7 Sec/8 Hours	1.06	Type II, Class 1
	HT 30	Modified Ethyl	Clear	.003	30 cps	2700/4200	-60 TO +275° F	<12 Sec/8 Hours	1.06	Type II, Class 1
	HT 100	Modified Ethyl	Clear	.006	100 cps	2700/4200	-60 TO +275° F	<14 Sec/8 Hours	1.06	Type II, Class 2
	HT 500	Modified Ethyl	Clear	.007	500 cps	2700/4200	-60 TO +275° F	<14 Sec/8 Hours	1.06	Type II, Class 2
	HT 1000	Modified Ethyl	Clear	.008	1,000 cps	2700/4200	-60 TO +275° F	<18 Sec/8 Hours	1.09	Type II, Class 3
	HT 1500	Modified Ethyl	Clear	.008	1,500 cps	2700/4200	-60 TO +275° F	<18 Sec/8 Hours	1.09	Type II, Class 3
	HT 2400	Modified Ethyl	Clear	.008	2,400 cps	2700/4200	-60 TO +275° F	<18 Sec/8 Hours	1.09	Type II, Class 3
	HT 4000	Modified Ethyl	Clear	.008	4,000 cps	2700/4200	-60 TO +275° F	<20 Sec/8 Hours	1.09	Type II, Class 3
MG SERIES, MEDICAL GRADE INSTANT ADHESIVES (USP CLASS VI)										
Medical grade instant adhesives. These products have USP Class VI Certification and are used in assembling medical devices.	MG 5	Ethyl	Clear	.002	5 cps	2700/4300	-65 to +200° F	<15 Sec/8 Hours	1.05	Type II, Class 1
	MG 30	Ethyl	Clear	.003	30 cps	2700/4300	-65 to +200° F	<15 Sec/8 Hours	1.05	Type II, Class 1
	MG 100	Ethyl	Clear	.006	100 cps	2700/4300	-65 to +200° F	<15 Sec/8 Hours	1.05	Type II, Class 2
	MG 500	Ethyl	Clear	.007	500 cps	2700/4300	-65 to +200° F	<15 Sec/8 Hours	1.05	Type II, Class 2
	MG 1000	Ethyl	Clear	.008	1,000 cps	2700/4300	-65 to +200° F	<15 Sec/8 Hours	1.05	Type II, Class 3
	MG 1500	Ethyl	Clear	.008	1,500 cps	2700/4300	-65 to +200° F	<15 Sec/8 Hours	1.05	Type II, Class 3
	MG 2400	Ethyl	Clear	.008	2,400 cps	2700/4300	-65 to +200° F	<15 Sec/8 Hours	1.05	Type II, Class 3
	MG 3200	Ethyl	Clear	.008	3,200 cps	2700/4300	-65 to +200° F	<15 Sec/8 Hours	1.05	Type II, Class 3
	MG 4000	Ethyl	Clear	.008	4,000 cps	2700/4300	-65 to +200° F	<15 Sec/8 Hours	1.05	Type II, Class 3

PACKAGING: All of the ADVANCE PERFORMANCE SERIES products are available in 1 ounce, 2 ounce, 1 pound, and 4.4 pound containers. Special packaging is available: 2 gram pipettes, aluminum tubes, 3 gram bottles, 1/4 ounce bottles, brush on bottles, pin and collar bottles, cartridges, 20 kilo containers and 55 gallon drums.

STORAGE: For maximum shelf life the products should be stored at or below 72°F, in a cool area, away from heat, and out of direct sunlight. Once a bottle is opened do not refrigerate the container. Condensation may develop and this will effect shelf life. For all spout top bottles (1/2 ounce, 1 ounce, 2 ounce), after each use lightly squeeze the bottle to purge any adhesive that may have remained in the tip. A small amount of adhesive may come out. Wipe the tip, place the overcap on the tip, and tip will remain clog free for many uses. To prevent contamination of unused adhesive, do not fill any used material into a new container.

SURFACE PREPARATION: To guarantee the maximum performance characteristics of the adhesive, parts should be clean and free of all contamination. This includes mold release agents, grease, oil, dirt, oxidation, etc.

ADHESIVE APPLICATION: In using cyanoacrylate adhesives only a minimum amount of material is needed to achieve the optimum performance. These products are designed to cure between two surfaces in a thin film. A free falling drop will typically spread to give one square inch of coverage. The adhesive only needs to be applied to one surface. Then mate the parts together with firm pressure until the adhesive cures to fixture strength. This will happen in most cases within 30 seconds.

In applications that require bridge bonding, creating a fillet, and/or the adhesive is exposed, Quick Tac Accelerators can be used to cure the adhesive that is not between two surfaces. Quick Tac Accelerators can also be used to achieve faster cure speeds and fixture times of any of the ADVANCE PERFORMANCE SERIES products.

PERFORMANCE PROPERTIES: Each assembly application has specific criteria that influence the performance properties of the adhesive. This criteria must be evaluated on the basis of each individual application. Some of the criteria that effect adhesive performance are temperature, environmental conditions, the type of stress on the bondline, surface conditions of the parts, the total bond area, moisture, etc. ADHESIVE SYSTEMS, INC. has in place a complete staff of application engineers and professionals to assist in product selection. This service includes on site evaluation, in house lab testing, training, sampling, and custom formulation when required.

APPLICATION HELPERS: Poly Prep Primers enhance the bonding characteristics of difficult to bond surfaces. These surfaces include polyolefins (polyethylene, polypropylene), teflon, delrin, low energy surfaces, etc. Poly Prep Primer can be applied by brushing, spraying, or dipping. It is single component material that dries rapidly at room temperature.

Engineering Excellence
For technical product information call 1-800-401-1441



Surface Preparation Products

A complete family of accelerators and primers that enhance the performance of the *Advance Performance Series* adhesive products. Quick Tac accelerator products are specifically engineered to shorten fixture times, cure speeds and increase the gap filling capabilities of these instant adhesive products. Poly Prep Primers are formulated to improve the bonding properties on difficult to bond surfaces. Remove Instant Adhesive Debonder removes cured adhesive residue from a variety of surfaces.

QUICK-TAC ACCELERATOR™

QUICK-TAC ACCELERATOR™ has been developed as a treating agent for use with the *ADVANCE PERFORMANCE™* family of instant adhesive products. If faster setting speeds are desired, *QUICK-TAC™* will aid the curing process and give exceptionally faster set times. When curing beads or in applications where the adhesive is not between two parts, it will allow for fast uniform curing.

QUICK-TAC™ will aid the bonding of porous materials such as fabrics or woods. It is useful when bonding acidic surfaces or in low humidity conditions promoting consistent curing times. Ideal for wire tacking, silk screening, or in loudspeaker assembly. Using *QUICK-TAC™* enables the adhesive to fill gaps up to 0.20". *QUICK-TAC™* can be applied by brushing or spraying. Available in 2 and 8 ounce pump spray bottles, 1 gallon containers, and 55 gallon drums.

POLY PREP PRIMER™

This primer system is used for difficult to bond surfaces. *POLY PREP PRIMER™* can be applied by brushing, spraying, or parts may be dipped prior to assembly. It is used on polyethylene, polypropylene, certain elastomers, or other difficult to bond substrates.

It is a single component, ready to use material. Simply apply it to the surface you wish to bond, wait 30 seconds, and the parts are ready for assembly.

POLY PREP PRIMER™ is used with the *ADVANCE PERFORMANCE™* products. Available in 2 ounce bottles and 1 gallon containers.

TECH TIP

Send us your parts. We will evaluate your application and make product recommendations and suggestions.

REMOVE INSTANT ADHESIVE DEBONDER™

This unique product easily removes cured adhesive from countertops, work stations, assembly tools and production parts. Just apply to the area that needs to be treated, wait 30 seconds, wipe residue away with a damp cloth and discard. If adhesive residue remains on the surface, repeat this process.

Available in 2 ounce bottles and 1 gallon containers.

INSTANT ADHESIVES RELATED PRODUCTS

ADVANCE PERFORMANCE SERIES Accelerators, Primers, Debonder

QUICK TAC ACCELERATOR, for faster curing.

Product	Base	Color	Viscosity	Application
QUICK TAC 1	Trichlorethane	Clear/amber	3 cps	All APS cyanoacrylates
QUICK TAC 2	Acetone	Clear/amber	3 cps	All APS cyanoacrylates
QUICK TAC 3	Isopropyl Alcohol	Clear/amber	3 cps	All APS cyanoacrylates
QUICK TAC 4	Heptane	Clear	3 cps	All APS cyanoacrylates
QUICK TAC 5	Modified Solvent	Clear/amber	3 cps	All APS cyanoacrylates
QUICK TAC 6	Mineral Spirits	Clear	3 cps	All APS cyanoacrylates
QUICK TAC 7	Modified Solvent	Clear	3 cps	All APS cyanoacrylates

QUICK TAC ACCELERATOR products are available in a 2 ounce pump spray bottle, 8 ounce pump spray bottle, 1 gallon can, and 55 gallon drum. Shelf life is 2 years from date of shipment.

POLY PREP PRIMER, for bonding difficult surfaces.

Product	Base	Color	Viscosity	Application
POLY PREP	Heptane	Amber/brown	3 cps	Difficult to bond substrates
POLY PREP 2	Isopropyl Alcohol	Clear/amber	3 cps	Difficult to bond substrates

POLY PREP PRIMER products are available in a 2 ounce bottle, 1 gallon can, and 55 gallon drums. Shelf life is 1 year from date of shipment.

REMOVE DEBONDER, for removing adhesive residue and flushing dispensing systems.

Product	Base	Color	Viscosity	Application
REMOVE	Nitromethane	Clear/amber	3 cps	Adhesive remover

REMOVE DEBONDER products are available in a 2 ounce bottle, 1 gallon can, and 55 gallon drums. Shelf life is 2 years from date of shipment.

