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ADHESIVES SYSTEMS, INC.

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methacrylates
epoxies
thread lockers

thread sealants
retaining compounds
gasket products
sealants
anti-sieze products
application systems

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ASI's TOTAL COMMITMENT TO QUALITY

Certificate of Registration

This is to certify that:

Adhesive Systems, Inc.

9411 Corsair Road
Frankfort, IL 60423

operates under a Quality Management system which complies with the requirements of

ISO 9001:2008

The Scope of Registration is for the following:

Manufacture and Supply of Adhesives, Dispensers, and Related Products

Date of Issuance: September 4, 2012

Date of Expiration: September 4, 2015



Joseph L. Mayton
Manager, Certification Services



Registered by:
Aston Global Certification Services, LLC
www.aston-global.com

CERTIFICATE No: 01120002

No registration or endorsement is given by Aston Global Certification Services, LLC for any product or service. The registration is for the purpose of providing a third party with information regarding the quality management system of the registrant. This is not a guarantee of quality or a statement of approval. The registrant is responsible for the quality of its products and services. This certificate is not a statement of approval or endorsement by Aston Global Certification Services, LLC for any product or service.

Engineering Excellence

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

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Adhesive Systems, Inc. going beyond what is expected

These words sum up the essence of our corporate philosophy. Our entire organization is dedicated to you our valued customers. **Adhesive Systems, Inc.** is built on a foundation of quality, experience, and team work. We are doing business with an eye to the future. Our products offer custom engineered solutions combined with innovative technologies to meet the new challenges of your assembly applications. We have embraced the challenge of developing faster curing, stronger, more durable adhesives to give you the optimum performance in your finished product. Comprehensive solutions, proven ability, and demonstrated excellence, are words that describe our organization.

Adhesive Systems still knows the meaning of customer service. You will experience quality teamwork in every aspect of our organization. Our team of professionals are all engineering specialists in adhesive products and assembly applications. We are committed to taking a value added approach in your assembly applications. Our Customer First Program offers you a specialized program that allows for fast, responsive handling of all aspects of your specific requirements. Whatever the assembly application—Automotive, industrial, electrical, medical—**Adhesive Systems** products offer you unsurpassed performance and value. Our quality standards assure maximum performance, consistency, and reliability.

We have what it takes to support you...

- Personalized technical support for fast answers when you need them.
- Research and Development Department that brings you the latest developments in adhesive technology.
- In house lab service to evaluate your specific applications that brings you new solutions for any application.
- Adhesives that enhance the performance of your finished product and optimize your process.
- Quality standards that assure premium quality, consistency, and reliability.
- People, products, and facilities that support you through the process of product selection, sampling and ordering.
- Working with you in developing high performance, cost effective solutions to meet your application requirements.

Adhesive Systems provides you with the resources to increase your productivity, enhance your product quality, and offers assistance you can count on. We are your partner in developing high performance cost effective solutions to meet your requirements. **Adhesive Systems** has a full range of solutions to meet the challenging demands of your assembly applications. Our staff is dedicated to a professional and responsive approach in servicing your needs. We strive to achieve the highest level of excellence throughout our entire organization. Your satisfaction is and will always remain our most important goal. We will work closely with you, listen to your requirements, and offer you a broad range of products and services capable of fulfilling your specific need.

WHEN ONLY THE BEST WILL DO



Clearly your best choice.

**A full range of solutions
to meet the challenging demands
of your assembly requirements.**



T e c h n o l o g y

- the latest, state of the art products
- a solutions orientated approach to your most demanding assembly requirements
- faster curing
- stronger
- outstanding durability
- excellent aging and weathering properties
- standards that assure premium quality, consistency, and reliability



S e r v i c e

- quality teamwork
- design assistance, application assistance, and after the sale support
- on site engineering assistance
- custom engineered products for your specific application
- personalized customer and technical service support
- Customer First Program that offers you a fast, responsive approach to servicing all aspects of your requirements
- on time delivery every time



V a l u e

- innovative, cost effective solutions for your applications
- adhesive products for virtually any assembly application
- the most comprehensive, widest range of engineered adhesive products
- a professional, responsive, and personal approach in servicing your needs

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

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**Used in these
high performance
applications:**

AEROSPACE
AIR FILTERS
ANTENNAS
APPLIANCES
AUTOMOTIVE
CHAIN SAWS
CATHETERS
COSMETIC CASES
DISPLAYS
ELECTRONICS
EXERCISE EQUIPMENT
FERRITES
HEARING AIDS
INSTRUMENTS
LIGHT FIXTURES
LOUDSPEAKERS
MEDICAL DEVICES
MOTORS
MUNITIONS
PLASTIC MOLDING
RUBBER GASKETS
SHOES
SIGNS
SNOW BLOWERS
SOAP DISPENSERS
SWITCHES
TELEVISIONS
TOYS
TRANSFORMERS
WEATHERSTRIPPING



The **ADVANCE PERFORMANCE SERIES™** offers you the most comprehensive range of cyanoacrylate adhesives available to tackle the rigorous demands of today's assembly requirements. These products will bond more materials better than other one-part systems.

Through our Advanced Adhesive Technology, these products have been engineered to achieve structural bonds with excellent results on difficult to bond substrates. These products have been formulated to bond a wide range of similar and dissimilar materials: plastics, metals, elastomers, wood, and porous surfaces, to name a few. This unique family of products possesses exceptional bond strength, with excellent aging and weathering characteristics.

ADVANCE PERFORMANCE SERIES

High Performance, Instant Adhesives, Cyanoacrylates for Bonding

For the
name
and number of
your nearest distributor call
1-800-552-0299

**Tech
Tip**

No other adhesives offer a better combination of convenience, ease of use, dependability, and strength. When compared to other products on the market today, you will find faster cure times and superior bond strength. Whether you're bonding rubber, plastic, metal, wood, or other surfaces, the **ADVANCE PERFORMANCE SERIES™** will give you the ultimate in performance.

The **ADVANCE PERFORMANCE SERIES™** of Instant Adhesives represents the widest selection of application specific cyanoacrylate adhesives in the market today. These products are manufactured using state of the art technology. They contain no solvents and are non-flammable, can be applied directly from the bottle, and are easily automated through dispensing systems. Convenient, ready to use, and single component are some of the reasons why engineers and production personnel are choosing the **ADVANCE PERFORMANCE SERIES™** for their assembly applications.





FEATURES

- Single component
- Fast setting, bonds in just seconds
- Solvent free
- Room temperature cure
- Strong, up to 4800 psi in sheer
- Ready to use right from the bottle
- Easy to use
- Clear liquid
- Versatile, bonds a wide range of similar and dissimilar materials
- Easily automated

BENEFITS

- Superior bond strength
- Durable, long term bonds
- Excellent aging and weathering characteristics
- Good resistance to high temperature and humidity
- More bond elasticity
- Good impact and vibration resistance
- Economical
- Meets MIL A 46050C

RESULTS

- Higher production output
- Improved finished product quality
- Lower production cost
- Little or no technical training for in-plant personnel
- No mixing or weighing of adhesive
- Replaces mechanical fastening devices
- Lighter weight, more reliable assemblies
- Allows for in-line production
- No stack offs
- Better utilization of in-plant space

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, 3 gram, 1/4 ounce bottles, 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	<8 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	.005	100 cps	2700/4300	-65 to +200° F	<8 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 5
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	-65 to +200° F	<5 Sec/8 Hours	1.07	Type I, Class 1
	M 60	Methyl	Clear	.004	60 cps	2800/4000	-65 to +200° F	<8 Sec/8 Hours	1.07	Type I, Class 2
	M 100	Methyl	Clear	.005	100 cps	2800/4000	-65 to +200° F	<10 Sec/8 Hours	1.09	Type I, Class 2
	M 500	Methyl	Clear	.006	500 cps	2800/4000	-65 to +200° F	<10 Sec/8 Hours	1.09	Type I, Class 2
	M 1000	Methyl	Clear	.008	1,000 cps	2800/4000	-65 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 5000	Ethyl	Clear	.009	5,000 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	<20 Sec/8 Hours	1.05	Type II, Class 5

Adhesive Systems, Inc.

	PRODUCT	BASE	COLOR	GAP FILL	VISCOSITY	STRENGTH	TEMP RANGE	CURE SPEED (FIXTURE/FULL)	SPECIFIC GRAVITY	MIL SPECS A46050 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 10000	Modified Ethyl	Black	.012	10,000 cps	3500	-65 to +250° F	<20 Sec/8 Hours	1.10	
NI "M" SERIES, Low Odor/Low Bloom Instant Adhesives										
Low odor/low bloom instant adhesive. Eliminate frosting and odors typically associated with cyanoacrylates.	NI 5M	Modified	Clear	.002	5 cps	1900/2700	-65 to +180° F	<10 Sec/24 Hours	1.10	
	NI 100M	Modified	Clear	.006	100 cps	1900/2700	-65 to +180° F	<10 Sec/24 Hours	1.10	
	NI 500M	Modified	Clear	.007	500 cps	1900/2700	-65 to +180° F	<12 Sec/24 Hours	1.10	
	NI 1000M	Modified	Clear	.008	1,000 cps	1900/2700	-65 to +180° F	<12 Sec/24 Hours	1.10	

**Tech
Tip**

Cyanoacrylates are a great adhesive solution for a wide variety of applications. Check out our videos and current research on [facebook@www.facebook.com/AdhesiveSystemsInc](https://www.facebook.com/AdhesiveSystemsInc)



	PRODUCT	BASE	COLOR	GAP FILL	VISCOSITY	STRENGTH	TEMP RANGE	CURE SPEED (FIXTURE/FULL)	SPECIFIC GRAVITY	MIL SPECS A46050 C
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	<5 Sec/8 Hours	1.05	Type II, Class 1
	MG 30	Ethyl	Clear	.003	30 cps	2700/4300	-65 to +200° F	<10 Sec/8 Hours	1.05	Type II, Class 1
	MG 100	Ethyl	Clear	.006	100 cps	2700/4300	-65 to +200° F	<10 Sec/8 Hours	1.05	Type II, Class 2
	MG 500	Ethyl	Clear	.007	500 cps	2700/4300	-65 to +200° F	<10 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 ounces, 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 ounces), 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.

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

www.instantca.com



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.

Send us
your
parts.

We will evaluate
your application and make
product recommendations
and suggestions.

**Tech
Tip**

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 ounces 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 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 NF (Non-Flammable)	Proprietary	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.



**Used in these
performance
applications:**

ALARM SYSTEMS

BLOWERS

CORE BONDING

DECORATIVE TRIM

FANS

FRACTIONAL HP MOTORS

FUEL PUMPS

JEWELRY

LIGHT FIXTURES

MAGNETS TO ROTORS

MARINE PLASTICS

MIRRORS

MOTOR END CAPS

NAME PLATES

PVC PIPE JOINTS

REAR VIEW MIRRORS

SIGNS

SPEAKER MAGNETS

STEEL DOORS

TRANSFORMERS



The **MAXIMUM PERFORMANCE SERIES™** is a complete family of engineered structural adhesives. These products, both one-and two-part systems, offer a wide range of versatility in meeting your application requirements. Engineered to provide a unique balance of tensile, shear, and peel strength, they assure maximum performance in assemblies that see stress, shock, and impact. Strong, durable bonds are their trademark, even then faced with severe environmental conditions.

MP SERIES

What we bond:

ABS
ACRYLICS
ALUMINUM
BRASS
COATED METALS
COLD ROLL STEEL
COPPER
FIBERGLASS
GALVANIZED
GLASS
MAGNET MATERIAL
METAL
NYLONS
PHENOLICS
PLATED METALS
POLYCARBONATE
PVC
STAINLESS STEEL
STYRENE
TITANIUM
URETHANES
VINYLs

Maximum Performance Series— Structural Adhesives

The **MP SERIES™** possesses excellent resistance to solvents, salt, humidity, acids, and caustics, with outstanding temperature cycling capability. Due to their unique bonding properties, they will structurally bond a variety of plastics, ceramics, and metals. They are available in a full range of viscosities and cure speeds to meet specific application requirements. The **MP SERIES™** lends itself well to high speed production applications. Whether the application is bonding similar or dissimilar parts, design engineers select the **MP SERIES™** for the optimum in finished product quality, reliability, performance, and cost effectiveness.



The **MAXIMUM PERFORMANCE SERIES™** is a complete line of engineered structural adhesives consisting of no mix structurals, UV curables, one and two part epoxies, and two-part methacrylates.

Engineering Excellence

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

www.instantca.com



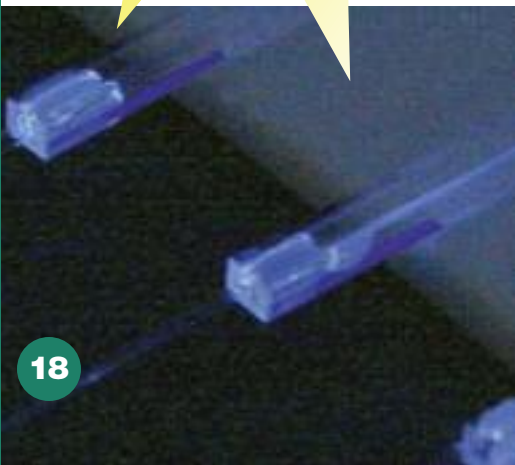
MAXIMUM PERFORMANCE SERIES

UV-Curing Adhesives

**We
Bond
at the
Speed
of Light**

The **MP 530000 SERIES** is made up of a complete range of UV curing adhesives that are used in a diverse range of assembly applications. These applications include bonding, sealing, coating, tacking, potting, and encapsulating. They are used in a wide range of product assembly applications that include automotive, electronic, medical, industrial, etc.

Engineers have found that the **MP 530000 SERIES** is an essential tool in improving overall product quality, lowering per unit cost, reducing processing time, and allows for innovative design solutions. The **MP 530000 SERIES** are single component, solvent free materials that cure in seconds when exposed to UV/visible light, and have been engineered to meet specific application requirements.



Medical Device Applications

The **MP 530000 M** family of products are high performance UV curing adhesives engineered to bond a wide range of plastics, glass, and metals. This UV curing adhesive is a leading performer when used for medical device applications. Our UV curing adhesives can be modified, or customized in an effort to assist the customer with their specific application needs. This product has passed ISO 10993 Cytotoxicity testing.

Product	Fixed Time	Water Absorp. 2 hrs. @ 100C	Viscosity	Durometer Hardness	Tensile Strength PSI	Temp. Range
MP531101M	0.5 Seconds	3.0%	110-170cps	D72	5800	-60 to 300 F
MP531102M	0.5 seconds	3.0%	180-270 cp	D70	4400	-60 to 300 F
MP531103M	0.5 seconds	3.0%	300-400 cp	D70	3650	-60 to 300 F
MP531104M	0.5 Seconds	3.0%	440-550 cp	D65	3450	-60 to 300 F
MP531105M	0.5 Seconds	3.6%	3000-5000 cp	D70	3600	-60 to 300 F
MP531106M	0.5 Seconds	3.0%	110-170 cp	D72	5800	-60 to 300 F
MP531107M	0.5 Seconds	3.0%	180-270 cp	D70	3650	-60 to 300 F
MP531108M	0.5 seconds	3.0%	300-400 cp	D70	3650	-60 to 300 F
MP531109M	0.5 Seconds	3.0%	400-550cp	D65	3450	-60 to 300 F
MP531110M	0.5 seconds	3.6%	3000-5000 cp	D70	3600	-60 to 300 F
MP531701M	0.5 seconds	3.7%	300-420 cp	A45		-60 to 300 F
MP532109M	0.5 seconds	2.9%	600-1000 cp	D68	4050	-60 to 300 F
MP532110M	0.5 seconds	2.9%	600-1000 cp	D68	4050	-60 to 300 F
MP532111M	0.5 seconds	3.6%	6000-12000 cp	D70	3200	-60 to 300 F
MP532112M	0.5 seconds	3.6%	6000-12000 cp	D70	3200	-60 to 300 F

Optical Applications

The **MP 530000 O** family of products are high performance UV curing adhesives engineered to bond a wide range of plastics and glass. This UV curing adhesive is a leading performer when used for binding optical applications. Our UV curing adhesives can be modified, or customized in an effort to assist the customer with their specific application needs.

Product	Fixed Time	Water Absorp. 2 hrs. @ 100C	Viscosity	Durometer Hardness	Linear Shrinkage	Temp. Range
MP5320880	11 seconds	2.4%	1200-1800 cp	D14	1.40%	-60 to 300 F
MP5320910	11 seconds	3.9%	25000-40000 cp	D17	1.80%	-60 to 300 F
MP5320920	11 seconds	4.3%	1800-2600 cp	D14	1.80%	-60 to 300 F

Potting Applications

The **MP 530000 P** family of products are high performance UV curing adhesives engineered to bond a wide range of plastics, glass, and metals. This UV curing adhesive is a leading performer when used for dome coating and potting applications. Our UV curing adhesives can be modified, or customized in an effort to assist the customer with their specific application needs.

Product	Fixed Time	Water Absorp. 2 hrs. @ 100C	Viscosity	Durometer Hardness	Tensile Strength PSI	Temp. Range
MP531192P	0.5 seconds	5.0%	180-260 cp	D70	4400	-60 to 300 F
MP531193P	0.5 seconds	5.0%	2000-4000 cp	D70	5100	-60 to 300 F



Adhesive Systems, Inc.

General Industry

The **MP 530000 I** family of products are high performance UV curing adhesives engineered to bond a wide range of plastics, glass, and metals. This UV curing adhesive is a leading performer when used for general industrial applications. Our UV curing adhesives can be modified or customized in an effort to assist the customer with their specific application needs.

Product	Fixed Time	Water Absorp. 2 hrs. @ 100C	Viscosity	Durometer Hardness	Lap Shear Strength PSI Polycarb. to Polycarb.	Temp. Range
MP531001I	1 second	4.7%	300-400 cp	D30	760	-60 to 300 F
MP531002I	1 second	4.7%	500-100 cp	D30	810	-60 to 300 F
MP531003I	1 second	4.7%	3500-5500 cp	D30	860	-60 to 300 F
MP531004I	1 second	4.7%	300-400 cp	D30	760	-60 to 300 F
MP531005I	1 second	4.7%	500-100 cp	D30	810	-60 to 300 F
MP531006I	1 second	4.7%	2800-4000 cp	D30	860	-60 to 300 F
MP531009I	1 second	4.7%	600-1000 cp	D30	1050	-60 to 300 F
Product	Fixed Time	Water Absorp. 2 hrs. @ 100C	Viscosity	Durometer Hardness	Tensile Strengths PSI	Temp. Range
MP531101I	0.5 seconds	3.0%	110-170 cp	D72	5800	-60 to 300 F
MP531102I	0.5 Seconds	3.0%	180-270 cp	D70	4400	-60 to 300 F
MP531103I	0.5 seconds	3.0%	300-400 cp	D70	3650	-60 to 300 F
MP531104I	0.5 seconds	3.0%	440-550 cp	D65	3450	-60 to 300 F
MP531105I	0.5 seconds	3.0%	3000-5000 cp	D70	3570	-60 to 300 F
MP531106I	0.5 seconds	3.0%	110-170 cp	D72	5800	-60 to 300 F
MP531107I	0.5 seconds	3.0%	180-270 cp	D70	4400	-60 to 300 F
MP531108I	0.5 seconds	3.0%	280-400 cp	D70	3650	-60 to 300 F
MP531109I	0.5 seconds	3.0%	440-550 cp	D65	3450	-60 to 300 F
MP531110I	0.5 seconds	3.0%	3000-5000 cp	D70	3600	-60 to 300 F
MP531201I	0.5 seconds	0.7%	22000-37000 cp	D35	Tg at 30C	-60 to 300 F

Clamshell Application

The **MP 530000 S** family of products are high performance UV curing adhesives engineered to bond a wide range of plastics. This UV curing adhesive is a leading performer when used for bonding PET, PVC, Clamshell Packaging, and general industrial applications. Our UV curing adhesives can be modified, or customized in an effort to assist the customer with their specific application needs.

Product	Fixed Time	Water Absorp. 2 hrs. @ 100C	Viscosity	Durometer Hardness	Lap Shear Strength PSI Polycarb. to Polycarb.	Temp. Range
MP531001S	1 second	4.7%	300-400 cp	D30	755	-60 to 300 F
MP531002S	1 second	4.7%	500-1000 cp	D30	810	-60 to 300 F
MP531003S	1 second	4.7%	3500-5500 cp	D30	860	-60 to 300 F
MP531004S	1 second	4.7%	300-400 cp	D30	755	-60 to 300 F
MP531005S	1 second	4.7%	500-1000 cp	D30	810	-60 to 300 F
MP531006S	1 second	4.7%	2800-4000 cp	D30	860	-60 to 300 F

Dome Coating Application

The **MP 530000 D** family of products are high performance UV curing adhesives engineered to bond a wide range of plastics and metals. This UV curing adhesive is a leading performer when used for general industrial applications. Our UV curing adhesives can be modified or customized in an effort to assist the customer with their specific application needs.

Product	Fixed Time	Water Absorp. 2 hrs. @ 100C	Viscosity	Durometer Hardness	Tensile Strengths PSI	Temp. Range
MP531824D	0.5 seconds	2.1%	1800-2600 cp	D75	8000	-60 to 300 F
MP531825D (higher clarity)	0.5 seconds	2.1%	1800-2600 cp	D75	8000	-60 to 300 F
MP531811D	0.5 seconds	2.1%	1800-2600 cp	D75	8000	-60 to 300 F
MP531812D	0.5 seconds	1.6%	1500-2400 cp	D80	7950	-60 to 300 F
MP532827D	0.5 seconds	2.1%	2500-3900 cp	D75	7900	-60 to 300 F

Electronic Applications

The **MP 530000 E** family of products are high performance UV curing adhesives engineered to bond a wide range of metals and plastics. This UV curing adhesive is a leading performer when used for bonding electronic and general industrial applications. Our UV curing adhesives can be modified, or customized in an effort to assist the customer with their specific application needs.

Product	Fixed Time	Water Absorp. 2 hrs. @ 100C	Viscosity	Durometer Hardness	Lap Shear Strength PSI Polycarb. to Polycarb.	Temp. Range
MP531001E	1 second	4.7%	300-400 cp	D30	755	-60 to 300 F
MP531002E	1 second	4.7%	500-1000 cp	D30	810	-60 to 300 F
MP531003E	1 second	4.7%	3500-5500 cp	D30	860	-60 to 300 F
MP531004E	1 second	4.7%	300-400 cp	D30	755	-60 to 300 F
MP531005E	1 second	4.7%	500-1000 cp	D30	810	-60 to 300 F
MP531006E	1 second	4.7%	2800-4000 cp	D30	860	-60 to 300 F

Glass Application

The **MP 530000 G** family of products are high performance UV curing adhesives engineered to bond a wide range of glass and metals. This UV curing adhesive is a leading performer when used for glass bonding applications. Our UV curing adhesives can be modified or customized in an effort to assist the customer with their specific application needs.

Product	Fixed Time	Water Absorp. 2 hrs. @ 100C	Viscosity	Durometer Hardness	Tensile Strengths PSI	Temp. Range
MP531050G	5 seconds	2.7%	100-175 cp	D72	6200	-60 to 300 F
MP531051G	3 seconds	2.7%	250-350 cp	D72	3500	-60 to 300 F
MP531052G	3 seconds	2.7%	450-850 cp	D72	3500	-60 to 300 F
MP531053G	3 seconds	2.7%	1200-2000 cp	D72	3650	-60 to 300 F
MP531054G	2 seconds	2.0%	1400-2200 cp	D74	3750	-60 to 300 F
MP531081G	1 second	3.2%	4000-9000 cp	D74	6100	-60 to 300 F
MP531084G	1 second	3.2%	GEL	D74	2950	-60 to 300 F

We supply UV light sources. Please contact techcenter@instantca.com or call 800-552-0299 to find the UV light source applicable for use with our UV products!



Adhesive Systems, Inc.



**Our UV Adhesives
can be used in a
wide variety of
applications!**

UVCS CURING SYSTEMS UV CURING SYSTEMS

Whether your application requires a hand held unit or a conveyor system **Adhesive Systems** has the curing equipment to meet your specific application needs and requirements. These systems provide durable, long lasting performance, that maximizes the efficiency of your assembly process. Whether your application is several parts at a time or several thousand we have a system for you.

**We
Bond
at the
Speed
of Light**

Benefits of using our light curing system and uv curing adhesives:

- Easy to use, operate, and set up
- Allows for in line production, no stack offs
- Eliminate the need for secondary curing systems
- Faster cycle times
- Complete, reliable curing
- Cost effective



UVCS 1000 HAND HELD FLOOD SYSTEM

- Easy to use
- Versatile portable curing system
- Durable and reliable system
- Idea for small or large areas
- Fast, deep curing
- High intensity 500mW/cm²



UVCS 2000FS FLOOD SYSTEM

- High Intensity
- Large curing area
- Use as a bench top system
- Conveyor compatible
- Versatile system
- Dependable, long lamp life



UVCS 5000 SC SPOT CURE SYSTEM

- Easy to use
- Hand held or can be mounted
- 100 Watt Long Life Mercury Lamp
- High Intensity Wand System
- Low temperature output
- Solid state, constant power
- Safety interlock
- Foot pedal operated.



CONVEYOR CURING SYSTEMS

UVCS 6000 BTCON (bench top)
UVCS 6100 SACON (stand alone)

- Ideal for high production volumes
- Variable speed motor
- Single or dual lamp system
- Adjustable belt speed
- Adjustable lamp height
- Digital speed read out
- Emergency stop switch

Adhesive Systems, Inc. offers a complete on hands approach to meet your assembly needs and requirements. In plant demonstrations are available upon request, as well as a free lab service to fully evaluate your application to make product recommendations and to select the uv curing system that will best fit your application. Custom and modified systems (wider, taller, shorter, faster, etc) are available upon request. **Adhesive Systems, Inc.** also has a complete line of dispensing systems for one and two component adhesives. Always wear eye and skin protection when using uv curing systems.

MAXIMUM PERFORMANCE SERIES

One and Two Part Epoxies

The **MP 5400 SERIES** offers a complete line of one and two part epoxies for structural bonding, potting, and encapsulating applications. These products offer engineers maximum design versatility by providing the following features and benefits:

- Superior bond strengths
- Dependable performance
- Excellent aging and weathering properties
- Good impact and vibration resistance
- Good resistance to high temperature and humidity
- Versatile, bonds a wide range of similar and dissimilar materials
- Cure at room temperature or can be accelerated with heat
- Solvent free
- Good gap filling characteristics
- Wide range of products that provide cure speeds, viscosities, and performance properties, to meet specific requirements
- Improves finished product quality
- Replaces mechanical fastening devices
- Lowers cost





The **MP 5400 SERIES** represents the most comprehensive family of products to meet your application requirements. They are conveniently packaged in 50 mil, and 400 mil dual syringe cartridges. This takes all the guess work out of using two component materials. This offers significant benefits for production personnel:

It's Already Done!

- No mixing, measuring, or weighing...
- No contact with material.
- No mess.
- No waste.
- Easy to use, right from the cartridge.
- Saves valuable production time.
- No clean up.



Visit us online at:
www.instantca.com

	RATIO	VISCOSITY	COLOR	WORK LIFE (MINUTES)	SHEAR STRENGTH PSI	DIELECTRIC STRENGTH	TEMPERATURE RESISTANCE
MP 5400 SERIES, Maximum Performance Epoxies — 2 Part Adhesives							
MP 5405 General purpose fast setting, 5 minute worklife epoxy. Forms a rigid bond, machinable, clear, flowable, low odor material.	1 to 1	12,500	Clear	3-5 Min.	2,000-4,000 psi	400 Volts/Mils	-60° F to 250° F
MP 5405BK General purpose fast setting, 5 minute worklife epoxy. Forms a rigid bond, machinable, black, flowable, low odor material.	1 to 1	13,000	Black	3-5 Min.	2,000-4,000 psi	400 Volts/Mils	-60° F to 250° F
MP 5405NS General purpose, non sag material. Ideal for applications that require maximum gap filling or high viscosity epoxy. Fast setting, 5 minute worklife, clear.	1 to 1	90,000	Clear	3-5 Min.	2,000-4,000 psi	400 Volts/Mils	-60° F to 250° F
MP 5405 FLEX MV Rubber toughened, good impact resistance, flexibility and peel strength.	1 to 1	40,000	Opaque/Tan	5 Min.	2,000-4,000 psi	400 Volts/Mils	-60° F to 250° F
MP 5430 General purpose, 20 minute worklife. Amber color, forms a rough, rigid bond.	1 to 1	13,000	Amber	20-30 Min.	2,000-4,000 psi	400 Volts/Mils	-60° F to 250° F
MP 5430 FLEX MV Rubber toughened, good impact resistance, flexibility and peel strength.	1 to 1	40,000	Opaque/Tan	5 Min.	2,000-4,000 psi	400 Volts/Mils	-60° F to 250° F
MP 54110 Fast curing, flexible, excellent weather resistance, bonds well to glass, metal, and plastic. Resist fuel and solvent environments, with good impact resistance.	1 to 1	45,000	Amber	9-12 Min.	2,000-4,000 psi	400 Volts/Mils	-60° F to 250° F
MP 54110GR Fast curing, good impact resistance and peel strength. Excellent for metal bonding or metal to dissimilar surfaces. Gray in color.	1 to 1	45,000	Gray	9-12 Min.	2,000-4,000 psi	400 Volts/Mils	-60° F to 250° F
MP 54125 Good peel strength, higher temperature resistance, medium open time for part adjustment and alignment.	1 to 1	48,000	Translucent	25 Min.	2,000-4,000 psi	400 Volts/Mils	-60° F to 250° F
MP 54125QR Gray color makes it ideal for aluminum and metal bonding. Flexible, toughened epoxy, with good impact resistance.	1 to 1	47,000	Gray	25 Min.	2,000-4,000 psi	400 Volts/Mils	-60° F to 250° F
MP 54190 Long work life, with good peel strength. Maximum adjustment and positioning time.	1 to 1	15,000	Translucent	70-100 Min.	3,300-4,000 psi	400 Volts/Mils	-60° F to 250° F
MP 54190QR Toughened epoxy, with good peel strength, impact resistance, and open time. Bonds metals, plastics, and many dissimilar materials. Gray in color.	1 to 1	60,000	Gray	70-100 Min.	3,300-4,000 psi	400 Volts/Mils	-60° F to 250° F



	RATIO	VISCOSITY	COLOR	WORK LIFE (MINUTES)	SHEAR STRENGTH PSI	DIELECTRIC STRENGTH	TEMPERATURE RESISTANCE
MP 5400 SERIES, Maximum Performance Epoxies (continued)							
MP 54270 Potting compound for electronic applications. Non corrosive material, with good worklife.	1 to 1	20,000	Clear	60 Min.	1,800-3,000 psi	550 Volts/Mils	-60° F to 250° F
MP 54270BK Long worklife potting compound ideal for tamper proofing electronic assemblies. Non corrosive with good flow properties, black color.	1 to 1	20,000	Black	60 Min.	1,800-3,000	550 Volts/Mils	-60° F to 250° F
MP 54420 High performance epoxy, excellent shear and peel strength. High viscosity for maximum gap filling.	2 to 1	43,000	Off-White	20-30 Min.	4,000-5,000	500 Volts/Mils	-60° F to 300° F
MP 54421 High performance epoxy, excellent shear and peel strength. High viscosity for maximum gap filling.	1 to 1	43,000	Off-White	20-30 Min.	4,000-5,000	500 Volts/Mils	-60° F to 250° F
MP 54460 High performance epoxy, high peel and shear strength. Longer worklife.	2 to 1	40,000	Off-White	50 Min.	4,000-5,000	500 Volts/Mils	-60° F to 250° F
MP 54216CL Long worklife, flexible epoxy. Bonds dissimilar materials, 18 hour fixture times.	1 to 1	10,000	Translucent	120 Min.	2,500-5,000	500 Volts/Mils	-60° F to 250° F
MP 54750 Versatile epoxy used for bonding and potting applications. Excellent resistance to water, acids, bases, and most organic solvents.	1 to 1	12,000	Clear	120 Min.	7,500	400 Volts/Mils	-60° F to 250° F

Packaging: MP 5400 Series Two Part Epoxies are available in 50 kits, 400 mil kits, and 10 gallon kits. Special packaging is available upon request.

	RATIO	SPECIFIC GRAVITY	VISCOSITY	COLOR	HEAT CURE CYCLE	TENSILE STRENGTH	SHEAR STRENGTH PSI	HARDNESS SHORE D	TEMP RANGE
MP 5400 SERIES, Maximum Performance Epoxies (continued)									
MP 5400 One part, heat cure, non-sag, structural adhesive. Ideal for bonding magnets, steel, aluminum, glass, some plastics, etc.	1 Part	1.41	Paste	Gray	@250° F - 15 Min. @300° F - 10 Min. @350° F - 2 Min.	6,400	3,100	85 Shore D	-40 to 400° F
MP 5401 One part, heat cure, forms a tough, durable bond. Excellent high performance at elevated temperatures and superior sag control.	1 Part	1.41	Paste	Gray	@250° F - 15 Min. @300° F - 10 Min. @350° F - 2 Min.	6,770	3,200	85 Shore D	-40 to 400° F
MP 5403 FLEX One part, heat cure formulated to provide excellent impact and shock resistance. Ideal for bonding dissimilar surfaces.	1 Part	1.35	Paste	Gray	@250° F - 15 Min. @300° F - 10 Min. @350° F - 2 Min.	6,400	3,100	45 Shore D	-40 to 400° F
MP 5404FS One part heat cure that cures rapidly. Cures in seconds by induction or infra-red heating.	1 Part	1.41	Paste	Gray	@250° F - 15 Min. @300° F - 10 Min. @350° F - 2 Min.	6,770	3,200	85 Shore D	-40 to 400° F

Packaging: MP 5400 Series One Part Epoxies are available in 6 ounce cartridges, 12 ounce cartridges and 5 gallon pails. Special packaging is available upon request.

Adhesive Systems, Inc.

MAXIMUM PERFORMANCE

STRUCTURAL BONDING

THE BENEFITS

**SUPERIOR BOND STRENGTHS
TOUGH, DURABLE BONDS
IMPROVE FINISHED PRODUCT QUALITY
EXCELLENT AGING AND WEATHERING
GOOD IMPACT AND VIBRATION RESISTANCE
ELIMINATE MECHANICAL FASTENING DEVICES
COST EFFECTIVE**



CE MP55000 SERIES

G METHACRYLATES

FITS!

ELIMINATES PRE DRILLING
RESIST TEMPERATURE EXTREMES AND THERMO CYCLING
BONDS SIMILAR AND DISSIMILAR MATERIALS
FULL RANGE OF WORK TIMES AND CURE TIMES
ROOM TEMPERATURE CURE
STRONGER, LIGHTER FINISHED ASSEMBLIES



STRUCTURAL ADHESIVES



MAXIMUM PERFORMANCE SERIES

Two Part Methacrylates

Interested in products that offer you the latest in technology and a cost effective approach in evaluating your application? Call 1-800-552-0299 to arrange a visit at your facility.

**Tech
Tip**

The **MP 55000 SERIES** is a complete family of two part methacrylate adhesives. These products are specifically engineered for structural bonding of nearly all thermoplastics, metals, and composite materials. They offer exceptional bond strength and are extremely durable adhesives.

The **MP 55000 SERIES** provides outstanding performance in a wide range of applications in the transportation, solid surface, industrial, construction, and marine market areas.





	RATIO	COLOR	VISCOSITY	WORK TIME	FIXTURE TIME	ALUMINUM	STEEL	FIBERGLASS	ACRYLIC	SMC	ABS	TEMPERATURE RESISTANCE
MP 55000 SERIES, Maximum Performance Methacrylates—Two Part Methacrylate												
MP 55300 General purpose used for bonding plastics and metal components. Fast cure time for high speed assembly.	1 to 1	Straw	Non-Sag	6-8 Min.	10-15 Min.	2,450	3,750	S-F	S-F	S-F	S-F	-55° F to 225° F
MP 55300HV High viscosity version of MP 55300.	1 to 1	Straw	120,000 cps	6-8 Min.	10-15 Min.	2,450	3,750	S-F	S-F	S-F	S-F	-55° F to 225° F
MP 55305 High impact resistance for metals and plastics. Tough, flexible adhesive with a fast cure time for high speed assembly.	1 to 1	Straw	Non-Sag	2-3 Min.	5-6 Min.	2,450	3,750	S-F	S-F	S-F	S-F	-55° F to 225° F
MP 55305HV High viscosity version of MP 55305.	1 to 1	Straw	Non-Sag	2-3 Min.	6-10 Min.	2,450	3,750	S-F	S-F	S-F	S-F	-55° F to 225° F
MP 55310 Excellent metal bonder with good results on plastics as well. Medium cure speed for part positioning and adjustment.	1 to 1	Straw	Non-Sag	10-18 Min.	20-35 Min.	3,700	4,200	S-F	S-F	S-F	S-F	-55° F to 225° F
MP 55310HV High viscosity version of MP 55310.	1 to 1	Straw	Non-Sag	10-18 Min.	20-35 Min.	3,700	4,200	S-F	S-F	S-F	S-F	-55° F to 225° F
MP 55320 High performance bonding, metal, aluminum, composite materials, FRP, wide range of plastics. Tough durable bonds with excellent aging and weathering properties.	10 to 1	Straw	Non-Sag	8-12 Min.	25-30 Min.	3,700	4,200	S-F	S-F	S-F	S-F	-55° F to 225° F
MP 55330 High impact, maximum flexibility and elongation. High tensile shear strength. Fast cure speed.	1 to 1	Straw	Non-Sag	25-30 Min.	40-60 Min.	3,700	4,200	S-F	S-F	S-F	S-F	-55° F to 225° F
MP 55350 Long open time with good worklife. Bonds well to most plastics, composites, and metals.	1 to 1	Straw	Non-Sag	30-40 Min.	60-90 Min.	2,350	3,200	S-F	S-F	S-F	S-F	-55° F to 225° F
MP 55350HV High viscosity version of MP 55350.	1 to 1	Straw	Non-Sag	30-40 Min.	60-90 Min.	2,350	3,200	S-F	S-F	S-F	S-F	-55° F to 225° F
MP 55395 Excellent overall performance properties, tough, durable, bonds, used on large structures where long open times are required.	1 to 1	Gray	Non-Sag	60-70 Min.	150-200 Min.	3,700	4,200	S-F	S-F	S-F	S-F	-55° F to 225° F
MP 55420 High performance bonding, metal, aluminum, composite materials, FRP, wide range of plastics. Tough durable bonds with excellent aging and weathering properties.	10 to 1	Straw	Non-Sag	4-6 Min.	12-18 Min.	3,300	4,200	S-F	S-F	S-F	S-F	-55° F to 225° F
MP 55420FS Fast Curing version of MP 55420.	10 to 1	Straw	Non-Sag	2-4 Min.	5-8 Min.	3,700	4,200	S-F	S-F	S-F	S-F	-55° F to 225° F
MP55420SC Slow Curing version of MP 55420.	10 to 1	Straw	Non-Sag	8-12 Min.	25-30 Min.	3,700	4,200	S-F	S-F	S-F	S-F	-55° F to 225° F

Fixture and cure times are measured at 75C. Products designated as FS, HV, and/or colored products, may require a minimum order.

Products are conveniently packaged in 50 mil and 400 mil mix packs. No weighing or manual mixing is needed. This convenient packaging minimizes production personnel coming in contact with the adhesive. Ten gallon kits are available for automated applications. Special packaging is available upon request. 200ml, 250ml, 380ml, coaxial, and universal cartridges.

**Used in these
high performance
applications:**

APPLIANCES
AUTOMOTIVE
COMPRESSORS
CONVEYORS
ELECTRONICS
ENGINES
FAUCETS
FUEL PUMPS
HYDRAULICS
LAWN EQUIPMENT
MACHINE TOOLS
MACHINERY
MILITARY EQUIPMENT
MOTORCYCLES
MOTORS
PUMPS
RADIATORS
SNOW BLOWERS
TRACTORS
VALVES
TRANSPORTATION
EQUIPMENT
VEHICLES
WEAPON SYSTEMS



TORQUE™ anaerobic adhesives/sealants are for threadlocking, threadsealing, retaining, and gasketing applications. These products are available in different strengths, cure times, and viscosities to meet your specific application requirements.

TORQUE™ forms a tough, durable material, capable of withstanding high impact with excellent resistance to extreme environmental conditions.

The **TORQUE™** products offer consistent, dependable performance and outstanding reliability in your finished product.



TORQUE SERIES

**High Performance Anaerobic Adhesives/
Sealants Threadlocking, Threadsealing,
Retaining, Gasketing**

Interested in dispensing systems to help your process? We have manual, semi-automated, and fully automated systems to fit every type of application requirement. Call an Application Specialist at 1-800-552-0299.

**Tech
Tip**

TORQUE ANAEROBIC PRODUCTS

represent the latest technology in anaerobic adhesives/sealants. This new technology is specifically engineered to provide the fastest fixture and full cure times of any anaerobic on the market today. Offering consistent strength on both active and inactive surfaces, combined with higher torque and shear strength values, has made **TORQUE** the choice of engineers to meet their demanding application requirements. This family of products provides for maximum performance and reliability in your finished assembly. They can be used on as received parts that have mild oil contamination present on the surface. **TORQUE ANAEROBIC PRODUCTS** are single component, solvent free adhesives, that cure in the absence of air and in the presence with metal ions.

*These anaerobic resins offer the best method to positively lock, retain, and seal a wide range of metal parts. Even in the tightest fitting assembly; voids are present which allows for movement and loosening of parts. **TORQUE ANAEROBIC PRODUCTS** form a tough, durable resin, that fills all these voids, creating a unitized assembly that is completely resistant to shock, vibration, and extremely harsh environmental conditions. These chemical tools significantly reduce production cost while enhancing the reliability and performance of the finished assembly.*



FEATURES

- Single component
- Tough, durable material
- Available in a full range of strengths and viscosities
- Solvent free
- Fills void between threaded and cylindrical parts
- Can be used right from the bottle or easily automated

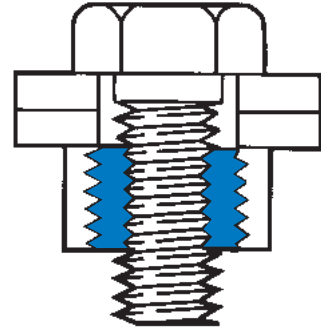
BENEFITS

- Faster cure times
- Consistent on active or inactive surfaces
- Easy to use
- Promotes a more reliable finished product
- Eliminates corrosion
- Eliminates vibration loosening
- Eliminates fastener fatigue
- Eliminates other mechanical locking devices
- Allows for relaxed machining tolerances
- Reduces cost

RESULTS

- Increased product reliability
- Higher production output
- Lighter weight assemblies
- Improved finished product quality

TORQUE TL SERIES™
Locks/seals threaded fasteners



TORQUE SERIES

Anaerobic Adhesives/Sealants Threadlocking

The **TORQUE THREADLOCKING SERIES** represent state of the art anaerobic technology, with world class performance. The **TORQUE THREADLOCKING SERIES** is manufactured to provide specific viscosities, strengths, and cure speeds to meet any application requirement. These anaerobic resins prevent against vibration loosening, while locking and sealing threaded assemblies and metal parts. They have excellent resistance to extremely harsh environments. **TORQUE THREADLOCKING** products are used in a wide range of assembly applications; from delicate electronic devices to heavy industrial equipment. They distribute the load on a fastener over the entire engagement length of the assembly, greatly reducing or completely eliminating fastener and material fatigue. They protect threaded areas by preventing rust and corrosion. These products significantly reduce production cost while enhancing the reliability of the finished product.





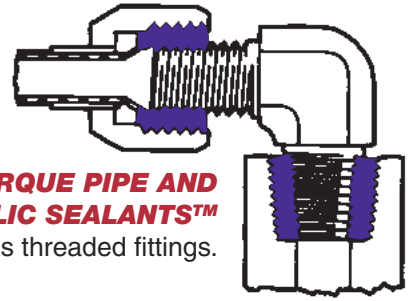
	COLOR	VISCOSITY	BREAKAWAY PREVAILING TORQUE	TEMP RANGE	CURE SPEED (FIXTURE/FULL)	SPECIFIC GRAVITY
TORQUE THREADLOCKERS						
TORQUE 21 TL Low strength threadlocking, low-viscosity, for small screws, easy disassembly.	Violet	200 cps LT	40/25	-60 to 350° F	10 Min/8 Hours	1.08
TORQUE 22 TL Low strength threadlocking. Ideal for small screws, 1/4" and smaller. Controlled lubricity for accurate clamp loading. Easy disassembly. MIL-S-46163A, Type II, Grade M	Purple	1,200 cps MT	75/50	-60 to 350° F	10 Min/8 Hours	1.05
TORQUE 41 TL Medium strength threadlocking. Low viscosity for fine tolerances and small diameter fasteners.	Blue	200 cps MT	150/75	-60 to 350° F	10 Min/8 Hours	1.08
TORQUE 42 TL General purpose, medium strength, removable. Ideal for fasteners 3/4" or smaller. Controlled lubricity, for accurate clamp loading. MIL-S-46163A, Type II, Grade N	Blue	1,200 cps MT	150/75	-60 to 350° F	10 Min/8 Hours	1.07
TORQUE 43 TL Medium strength, high viscosity. Improved oil resistance, larger diameter fasteners, removable.	Blue	3,000 cps MT	180/90	-60 to 350° F	10 Min/8 Hours	1.08
TORQUE 62 TL High strength, permanent threadlocking. High lubricity for easy assembly. Rapid handling strength, excellent resistance to extreme chemical and environmental conditions. MIL-S-46163, Type I, Grade O	Red	3,500 cps MT	200/275	-60 to 350° F	10 Min/8 Hours	1.05
TORQUE 71 TL High strength, permanent threadlocking. Ideal for fasteners up to 1". MIL-S-46163, Type I, Grade K	Red	500 cps MT	250/350	-60 to 350° F	10 Min/8 Hours	1.12
TORQUE 72 TL High strength, permanent threadlocking. Excellent high temperature properties 450° F.	Red	9,000 cps MT	250/375	-60 to 450° F	15 Min/24 Hours	1.11
TORQUE 77 TL High strength, permanent threadlocking. Higher viscosity for diameters over 1". MIL-S-46163A, Type I, Grade L	Red	7,000 cps MT	275/375	-60 to 350° F	10 Min/8 Hours	1.12
TORQUE 90 TL High strength, wicking grade. Ideal for post application to preassembled fasteners. Penetrates threads by capillary action. Secures screws, bolts, seals welds, porous metal parts. MIL-S-46163A, Type III, Grade R	Green	12 cps LT	150/275	-60 to 350° F	10 Min/8 Hours	1.08

All of the Torque Threadlocking products are available in 10 mil, 50 mil, 250 mil, and 1 liter containers. Special packaging is available upon request.

Engineering Excellence

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

www.instantca.com



**TORQUE PIPE AND
HYDRAULIC SEALANTS™**

Seals threaded fittings.

TORQUE SERIES

Anaerobic Adhesives/Sealants Threadsealing

The **TORQUE** liquid thread sealants are specifically designed to seal and secure metal pipes and fittings by filling the space between threaded metal parts and hardening to prevent leakage. They do an excellent job of sealing in severe environmental conditions and prevent leakage that may be caused by vibration loosening, damaged threads, or temperature cycling. **TORQUE** liquid thread sealants seal instantly to moderate pressures and when fully cured; they seal to the burst strength of most piping systems. They have excellent resistance to a wide range of chemicals such as hydraulic fluids, oils, fuels, water, lubricants, etc. They are ready to use, single component, solvent free materials, designed to handle both low and high pressure applications. The **TORQUE THREADSEALING** products do not shrink, shred, tear, or relax. They are formed in place sealants conforming to the parts they are used on, creating a durable, positive seal. The **TORQUE THREADSEALING** family of products offers a full range of viscosities, strengths, and cure speeds that are designed to meet your specific application requirements.

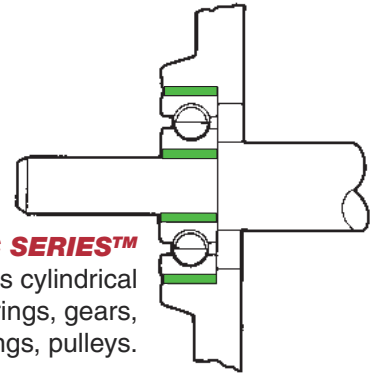
Need
help with your
application? Call 1-800-
552-0299 and ask to speak
with a Application Specialist
in our Technical Department.

**Tech
Tip**





	COLOR	VISCOSITY	TEMP RANGE	SEALS TO OPERATING PRESSURE	SPECIFIC GRAVITY	CURE SPEED (FIXTURE/FULL)
TORQUE THREADSEALERS						
TORQUE 145 Liquid Sealant for locking and sealing high pressure fluid power systems. Contains no fillers, will not clog filters. Packaged in: 50 mil bottle, 250 mil bottle, and 1 liter container.	Purple	10,000 cps	-60 to 350° F	10,000 psi	1.20	15 min/8 Hours
TORQUE 154 Refrigerant sealant. Excellent solvent resistance. For pipes up to 3" in diameter. Packaged in: 50 mil bottle, 250 mil bottle, and 1 liter container.	Red	2,500 cps	-60 to 350° F	10,000 psi	1.02	10 Min/8 Hours
TORQUE 165 Controlled strength pipe sealant for easy disassembly. General purpose, instant sealing. Packaged in: 50 mil tube, 250 mil tube, 1 liter container, 75 mil accordian, and 125 mil accordian.	White	300,000 cps	-60 to 350° F	10,000 psi	1.10	10 Min/8 Hours
TORQUE 170 Easy disassembly thread sealant. Seals and prevents vibration loosening. Lower viscosity for better flow and ease of application. Packaged in: 50 mil bottle, 250 mil bottle, and 1 liter container.	Blue	4,500 cps	-60 to 400° F	10,000 psi	1.12	10 Min/8 Hours
TORQUE 171 High viscosity, fast fixturing sealant. Controlled strength for ease of disassembly. Packaged in: 50 mil tube, 250 mil tube, 1 liter container, 75 mil accordian, and 125 mil accordian.	White	40,000 cps	-60 to 350° F	10,000 psi	1.08	5 Min/8 Hours
TORQUE 172 Low strength sealant for small threads and pneumatic fittings. Packaged in: 50 mil bottle, 250 mil bottle, and 1 liter container.	Blue	750 cps	-60 to 350° F	10,000 psi	1.05	15 Min/8 Hours
TORQUE 173 Hydraulic sealant, general purpose, fittings up to 3/4". Ideal for fine threads. Medium strength. Packaged in: 50 mil bottle, 250 mil bottle, and 1 liter container.	Brown	500 cps	-60 to 350° F	10,000 psi	1.06	10 Min/8 Hours
TORQUE 174 Hydraulic sealant, high viscosity, thixotropic. Ideal for larger tolerances. Medium strength. Packaged in: 50 mil bottle, 250 mil bottle, and 1 liter container.	Red	3,500 cps	-60 to 350° F	10,000 psi	1.08	10 Min/8 Hours
TORQUE 175 Medium strength, flexible sealant. Ideal for steam systems, dissimilar parts, and thermocycling applications. Replaces soldering copper fittings. Packaged in: 50 mil bottle, 250 mil bottle, 1 liter container.	Red	4,000 cps	-60 to 350° F	10,000 psi	1.08	10 Min/8 Hours
TORQUE 176 Medium strength sealant for larger tolerances. Packaged in: 50 mil tube, 250 mil tube, 1 liter container, 75 mil accordian, and 125 mil accordian.	Blue	20,000 cps	-60 to 350° F	10,000 psi	1.09	10 Min/8 Hours
TORQUE 177 Fast curing PTFE pipe sealant for gas and liquids. Highly thixotropic. Packaged in: 50 mil tube, 250 mil tube, 1 liter container, 75 mil accordian, and 125 mil accordian.	White	90,000 cps	-60 to 350° F	10,000 psi	1.09	5 Min/6 Hours
TORQUE 178 High viscosity, PTFE pipe sealant. Medium strength, general purpose of use on coarse threads. Packaged in: 50 mil tube, 250 mil tube, 1 liter container, 75 mil accordian, and 125 mil accordian.	Yellow	50,000 cps	-60 to 350° F	10,000 psi	1.09	10 Min/8 Hours
TORQUE 180 Very fast curing, high strength sealant for fittings up to 3/4". Packaged in: 50 mil bottle, 250 mil bottle, and 1 liter container.	Green	500 cps	-60 to 350° F	10,000 psi	1.06	2 Min/6 Hours
TORQUE 181 Fast curing, high strength, high temperature thread sealant, for larger tolerances. Packaged in: 50 mil bottle, 250 mil bottle, and 1 liter container.	Green	3,500 cps	-60 to 450° F	10,000 psi	1.10	15 Min/8 Hours
TORQUE 182 Delayed curing for maximum adjustment times, high strength, high viscosity thread sealant. Packaged in: 50 mil bottle, 250 mil bottle, and 1 liter container.	Red	6,000 cps	-60 to 350° F	10,000 psi	1.11	60 Min/24 Hours
TORQUE 192 General purpose sealant for locking and sealing threaded fittings. Easy disassembly. Packaged in: 50 mil tube, 250 mil tube, 1 liter container, 75 mil accordian, and 125 mil accordian.	White	350,000 cps	-60 to 450° F	10,000 psi	1.20	15 Min/8 Hours
TORQUE 193 Excellent for stainless steel. Good temperature resistance. Easy disassembly. Packaged in: 50 mil tube, 250 mil tube, 1 liter container, 75 mil accordian, and 125 mil accordian.	White	475,000 cps	-60 to 450° F	10,000 psi	1.15	15 Min/8 Hours



TORQUE RC SERIES™
Strengthens cylindrical
assemblies, bearings, gears,
shafts, bushings, pulleys.

TORQUE SERIES

Anaerobic Adhesives/Sealants Retaining

The **TORQUE RETAINING SERIES** is engineered to greatly increase the shear strength of cylindrical, non threaded assemblies. These products fill the inner space and surface irregularities between the parts forming a tough, durable polymer, that creates a unitized, strong, precision assembly, preventing corrosion. They are single component, solvent free compounds that are ready to use right from the bottle, or can be easily automated. The **TORQUE RETAINING SERIES** is formulated in a wide range of viscosities, gap filling ability, cure times and strength characteristics. This technology greatly enhances the reliability and performance properties of the finished assembly. Even in the best press fit application there is only 20 to 30 percent actual metal contact between the surfaces. The **TORQUE RETAINING SERIES** fills all the voids between the parts increasing the overall strength of the assembly by 2 to 3 times that of the original press fit. Other retaining and locking devices can be eliminated such as keyways, set screws, splines, tapers, knurls, etc. Machining tolerances can be relaxed lowering the cost of the assembly and simplifying the assembly process. Improved quality, reliability, cost effectiveness, ease of use, are just a few of the many benefits the **TORQUE RETAINING SERIES** brings to improve the manufacturing techniques in your assembly applications.

Have a
difficult
application and nothing
seems to work? Adhesives
Systems, Inc. offers
customized solutions to fit
your specific requirement.

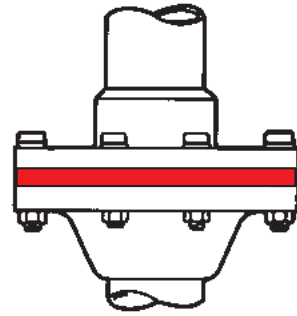
**Tech
Tip**



	COLOR	VISCOSITY	GAP FILL	SHEAR STRENGTH STEEL/STEEL	TEMP RANGE	CURE SPEED (FIXTURE/FULL)	SPECIFIC GRAVITY
TORQUE RETAINING COMPOUNDS							
TORQUE 03 RC Excellent for oily surfaces and other contamination. Prevents corrosion, provides strength up to 3,800 psi, temperature resistance to 350° F. MIL-R-46082B, Type I	Green	125 cps	.005"	3,800 psi	-65° to 350° F	10 Min/8 Hours	1.10
TORQUE 09 RC General purpose, low viscosity retaining compound. Fixtures in under 10 minutes, providing shear strength up to 3,800 psi, works well on similar and dissimilar metals. Temperature resistance to 350° F. MIL-R-46082B, Type I	Green	125 cps	.005"	3,800 psi	-65° to 350° F	15 Min/8 Hours	1.10
TORQUE 20 RC High strength, high temperature retaining compound. Shear strength up to 4,000 psi, radial clearance up to .015". Fixtures in under 15 minutes.	Green	8,500 cps	.015"	4,000 psi	-65° to 450° F	15 Min/8 Hours	1.16
TORQUE 35 RC Medium viscosity, ideal for slip fitted parts. Fixtures in 10 minutes, shear strength up to 4,200 psi, temperature up to 350° F. MIL-R-46082B, Type III	Green	2,000 cps	.010"	4,200 psi	-65° to 350° F	10 Min/8 Hours	1.05
TORQUE 38 RC Maximum strength for extremely high dynamic loading. 4,500 psi in shear strength, radial clearance up to 0.10".	Green	2,500 cps	.010"	4,500 psi	-65° to 350° F	2 Min/8 Hours	1.09
TORQUE 40 RC Medium strength, delayed curing for maximum adjustment times, up to 40 minutes. High temperature up to 450° F. MIL-R-46082B, Type II	Green	600 cps	.007"	3,500 psi	-65° to 450° F	40 Min/8 Hours	1.12
TORQUE 41 RC General purpose, controlled strength retaining. Excellent for parts that require disassembly. Radial clearance up to 0.10".	Yellow	750 cps	.010"	1,800 psi	-65° to 350° F	15 Min/8 Hours	1.07
TORQUE 48 RC Fast curing, high strength. Working temperatures up to 350° F. Fixtures in under 2 minutes.	Green	500 cps	.006"	4,000 psi	-65° to 350° F	2 Min/8 Hours	1.13
TORQUE 70 RC Low viscosity, delayed curing up to 30 minutes for positioning and adjustment. Ideal for press fib. MIL-R-46082B, Type I	Green	5,000 cps	.015"	4,000 psi	-65° to 425° F	10 Min/8 Hours	1.12
TORQUE 75 RC Low viscosity, delayed curing up to 30 minutes for positioning and adjustment. Ideal for press fib. MIL-R-46082B, Type I	Green	125 cps	.005"	3,500 psi	-65° to 350° F	30 Min/24 Hours	1.09
TORQUE 80 RC High strength for slip fitted parts, 4,200 psi. Fixtures in under 5 minutes with gap filling up to .015.	Green	1,400 cps	.015"	4,200 psi	-65° to 450° F	5 Min/8 Hours	1.11

Packaging: The Torque Series Retaining Compounds are available in 10 mil, 50 mil, 250 mil, and 1 liter containers. Special packaging is available upon request.

TORQUE GASKET MAKER™
Form-in-place gaskets.



TORQUE SERIES

Anaerobic Adhesives/Sealants Gasketing

**Tech
Tip**

Need more training for engineering, assembly personnel, plant safety, etc? Adhesive Systems, Inc. will conduct seminars at your facility. Call 1-800-552-0299 to get more of the details.

The **TORQUE GASKETING SERIES** allows for maximum clamp loading and positive sealing of mating flanges and housings. These liquid gasketing materials are ideally suited for applications where there are small gaps on rigid metal to metal assemblies. They create a formed in place gasket, eliminating the need for large inventories of pre cut gaskets. The **TORQUE GASKETING SERIES** keys into the surface of the flanges when they are mated together creating a positive, uniform seal in the joint. This material does not shrink, tear, or relax when fully cured and it is not necessary to re-torque flange bolts when using these products. They are extremely durable materials, that have exceptional pressure and chemical resistance. They are available in a full range of strengths, cure times, and viscosities, to meet specific application requirements. The **TORQUE GASKETING SERIES** is a total leak prevention system. They are single component, solvent free materials, that fill all the voids, surface gaps, and irregularities, allowing for a positive seal between mating flanges, along with improving the structural integrity of the assembly.



	COLOR	VISCOSITY	GAP FILL	TEMP RANGE	CURE STATE	CURE SPEED (FIXTURE/FULL)	SPECIFIC GRAVITY
TORQUE GASKETING							
TORQUE GM 10 General purpose, flange sealant. Forms a flexible seal, with gap filling up to .050".	Purple	275,000 cps	.010"-.050"	-65 to 350° F	Flexible	15 Min/8 Hours	1.10
TORQUE GM 20 Forms a rigid gasket, adds structural integrity to the assembly, fills gaps to .050".	Orange	500,000 cps	.030"-.050"	-65 to 350° F	Rigid	30 Min/8 Hours	1.08
TORQUE GM 25 Fast curing, flexible, high viscosity gasketing material, ideal for high speed production.	Red	125,000 cps	.010"-.020"	-65 to 350° F	Flexible	5 Min/8 Hours	1.20
TORQUE GM 30 Excellent to use on flexible metal assemblies. Will not tear, shrink, or relax. Excellent solvent resistance, fills gaps to .050".	Red	800,000 cps	.010"-.050"	-65 to 350° F	Flexible	20 Min/8 Hours	1.10
TORQUE GM 35 Long curing, semi-rigid gasketing material. Allows for maximum adjustment times on extended assembly operations.	Green	20,000 cps	.010"-.020"	-65 to 350° F	Semi-Rigid	90 Min/8 Hours	1.25
TORQUE GM 40 Excellent for applications that require high temperature properties (450° F) and chemical/solvent resistance.	Red	200,000 cps	.010"-.020"	-65 to 450° F	Rigid	30 Min/8 Hours	1.16
TORQUE GM 45 Extremely flexible, withstands flange movement and vibration. Holds to a vertical surface.	Blue	100,000 cps	.010"-.020"	-65 to 350° F	Flexible	45 Min/8 Hours	1.12
TORQUE GM 50 Fast curing material with good gap filling properties. High viscosity material, eliminates compression sets.	Orange	40,000 cps	.010"-.020"	-65 to 350° F	Semi-Rigid	5 Min/6 Hours	1.11

Packaging: Gasket Maker products are available in 50 mil tubes, 250 mil tubes, 1 liter containers, and 15 liter pails. Special packaging of Gasket Maker products is available upon request.

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

www.instantca.com

Surface Preparation Products

Need dispensing equipment? See the Application Systems section of this catalog, beginning on page 48.

Tech Tip

TORQUE SERIES SURFACE PREPARATION PRODUCTS are used to insure the maximum performance of the **TORQUE SERIES** anaerobic adhesives and sealants. **ADHESIVE SYSTEMS**, as a responsible manufacturer with concern for the environment, formulates these products with “non ozone depleting” chemicals. **TORQUE PRIMER N** and **PRIMER T** are used to speed the curing and increase the gap filling properties of **TORQUE ANAEROBIC PRODUCTS**. They are ideally suited for applications that require exceptionally fast fixture times on surfaces that are inactive. They increase the activity of the parts being assembled by priming the surfaces and removing contaminants that may be present. Both **TORQUE PRIMER N** and **PRIMER T** are solvent based products, and **TORQUE PRIMER SF** is a solvent free formulation. **TORQUE SAFETY SOLVENT** is an industrial strength cleaner that removes grease, oil, and dirt from the parts being assembled. Proper surface preparation on component parts that have a high level of contamination and/or involve inactive surfaces will greatly enhance the performance of the products in the finished application.



	BASE	COLOR	VISCOSITY	ON PART LIVE
TORQUE SURFACE PREPARATION PRODUCTS				
PRIMER T	Heptane	Green	2 cps	Up to 7 Days
PRIMER N	Heptane	Bluish Green	2 cps	Up to 30 Days
PRIMER SF	Modified Methacrylate	Green/Amber	5 cps	24 Hours
SAFETY SOLVENT	Acetone	Clear/Amber	2 cps	N/A



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www.instantca.com

AS SERIES

Anti-Seize Lubricating Compounds

Used in these high performance applications:

PUMPS
VALVES
SHAFTS
DRIVES
FLANGES
FITTINGS
MOTOR MOUNTS
ADAPTORS
CAM ROLLERS
GUIDES
VALVE STEMS
GLAND PLATES
PRESS FITS
KEYWAYS
BEARINGS
FASTENERS
PLUGS
DIES
PUNCHES
DRILLS
TAPS
STUDS
BOLTS
GEARS
PULLEYS
CHAIN
LIFTS
COUPLINGS

The **AS SERIES** represents the highest quality products for protecting machinery and equipment. These products offer the ultimate in protection and significant cost savings in both MRO and OEM applications. The **AS SERIES** of anti-seize products is compounded using the highest quality, heat resistant lubricants. Combine this with fine metallic particles and graphite, produces an extreme pressure lubricating compound that prevents galling, galvanic pitting, friction, corrosion, water wash out, and cold welding. These anti-seize compounds help provide constant, uniform, torque tension, speed assembly and disassembly, are non hardening, and will not drip. The **AS SERIES** products will greatly reduce costly and time consuming maintenance operations.



Tech Tip

Innovative packaging to meet any need or requirement you may have. From 1cc to 55 gallon drums.



	SPECIFIC GRAVITY	WEIGHT PER GALLON	PENETRATION	OIL SEPARATION	FLASH POINT	COLOR	FRICTION COEFFICIENT
AS SERIES							
AS 201 PREMIUM A copper, aluminum, and graphite compound, formulated to lubricate and protect threads, connections, flanges and other metal parts from rust, galling, and seizing. Temperature performance to +2,000° F, resist galvanic attack.	1.20	10 lb.	320-350'	<1%	450° F	Aluminum	.10
AS 202 COPPER Prevents against corrosion, rust, galling, seizing, pitting. Provides lubricating properties to threaded parts, with temperature resistance to +1,800° F.	1.20	10 lb.	320-350'	<1%	450° F	Copper	.10
AS 203 NICKEL Ideal for high temperature applications up to +2,600° F and when dissimilar metals are being joined. Excellent for stainless fittings and harsh environments.	1.20	10 lb.	320-350'	<1%	450° F	Nickel	.10

Packaging: Anti-seize products are available in 5 ounce brush top cans, 8 ounce brush top cans, 12.5 ounce aerosol cans, 1 pound brush top cans, 2.5 brush top cans, 8 pound cans, and 42 pound pails. Special packaging is available upon request.

FLEX SILICONE SERIES

**Used in these
high performance
applications:**

APPLIANCES
AUTOMOTIVE TRIM
NAME PLATES
SIGNS
SIGN LETTERS
SEALING DEVICES
DUCTWORK
COMPRESSORS
GEARBOXES
PUMPS
FLASHING VENTS
ELECTRICAL BOXES
MARINE HOUSINGS
TRUCK CABS
PIPE JOINTS
OVENS
REFRIGERATION EQUIPMENT
ELECTRICAL EQUIPMENT
CIRCUIT BOARDS
REGULATORS
JUNCTION BOXES
TOYS
WHEEL COVERS

The ***FLEX SILICONE SERIES*** is designed to meet a wide variety of industrial bonding and sealing applications. While each sealant has unique characteristics that make it particularly suited to certain applications, there are some properties common to all the products because of the silicone compounds used. The ***FLEX SILICONE SERIES*** is extremely versatile and bonds to a wide range of similar and dissimilar materials. All of the ***FLEX SILICONE SERIES*** are designed to provide good adhesion and sealing properties for many assembly applications. They are used on glass, ceramics, masonry, wood, painted surfaces, metal and plastics. These products offer maximum flexibility, provide a positive seal, and excellent high/low end temperature stability.



Need a
sample of any
of our products? Just
call 1-800-552-0299

**Tech
Tip**



COLOR

VISCOSITY

TEMP
RANGE

HARDNESS

TAC FREE

PACKAGING

FLEX SILICONE SERIES — One Part Silicones

FLEX 1100 Multi-purpose silicone for use in numerous bonding and sealing applications. (Acetoxy)	Clear, Black, Blue, White, Aluminum	Non-Sag Gel	-85 to 450° F	30 Shore A	15-20 Min.	10.3 oz. cart 4.5 gal pail 55 gal. drum
FLEX 1200 Low odor silicone, neutral cure sealant, fast curing, used in many of the same applications as FLEX 1100. (Oxime)	Clear, White	Non-Sag Gel	-85 to 450° F	28 Shore A	15-20 Min.	10.3 oz. cart 4.5 gal pail 55 gal. drum
FLEX 1300 High performance, high temperature adhesive/sealant. Continuous temperature resistance to 500° F, intermittent to 600° F. (Acetoxy)	Red	Non-Sag Gel	-85 to 500° F	30 Shore A	15-20 Min.	10.3 oz. cart 4.5 gal pail 55 gal. drum

Packaging: Flex Silicone products are available in 3 ounce tubes, 10.3 ounce cartridges, 5 gallon pails, and 55 gallon drums. Special packaging is available upon request.



FLEX SILICONE SERIES



DISPENSING SOLUTIONS

Reliable, consistent, and dependable are just a few features that characterize our dispensing systems.

ADHESIVE SYSTEMS, INC. provides dispensing application solutions through our staff of technical application specialist. These solutions range from hand held applicators to fully automated systems, microprocessor controllers, precision dispensing valves, and a complete family of accessories. By taking all the guesswork out of the application process through precision dispensing, finished product quality is greatly improved, faster production rates are achieved, waste is reduced, and assembly personnel have minimum contact with the material. Our staff of technical application specialists provide an effective and efficient results orientated approach, specifically engineered for your specific application.



AUTOMATIC DISPENSING Application Solutions

**Reduce cost, improve quality,
through precision dispensing.**

**Tech
Tip**

Our Application Engineers can evaluate your application and make product recommendations at your facility. Call 1-800-552-0299 to arrange a visit.

DS99025 Complete Manual Dispensing System

- Easy to use
- Versatile
- Operates off air pressure only
- Hand-held applicator
- Dispense directly from one pound bottle



DS99003 Shot Valve

Ideal for continuous micro shot applications. Adjustable for shot size and flow rate. Air actuated valve for semi or fully automated operation.

DS99030 Syringe System

- Precise application of thin to paste-like material
- Solid state controller and timer
- Timed shot for precise dispensing with excellent repeatability
- Syringe system



DS99050 Complete Valve System

- Precise metering and flow control
- Positive shut-off valve with adjustable diaphragm
- All wetted parts made of Teflon
- Excellent repeatability
- Time shot controller
- 1 quart to 5 gallon material reservoir



DS99004 Diaphragm Valve

Excellent for precision dispensing. The work horse for dispensing cyanoacrylates, UV's, and anaerobics. Positive shut off, no seals, adjustable fluid-flow control, easy cleaning, on line serviceability, cycle rates of up to 500 per minute, compact size and weight. Pneumatic operation allows for precise control, repeatability, and accuracy.

DS99000 S/V DIGITAL CONTROLLER

Reliable

**Dependable,
Performance**

EVERYTIME!

- Easy to use
- Dispenses a wide range of single component adhesives
- Capable of dispensing 600 cycles per minute
- Timing range from 0.020 to 60,000
- Repeat tolerance +/- 0.001%
- LCD Digital Display
- Dispense modes both continuous and timed
- Foot pedal or finger switch operated
- Used with the DS99004 Diaphragm Valve or Syringe System



PRESSURE TANKS

DS99300 pressure reservoir for 1 pound bottles of the **ADVANCE PERFORMANCE SERIES** and 250 ml **TORQUE SERIES** products.

DS99305 pressure tank for the 4.4 bottles. Larger size tank for less change outs of material.

DS99310 pressure reservoir for 250 cc and 1 pound bottles. See through acrylic chamber allows for monitoring of material. Chamber dimensions are 4" I.D. by 8" in height. Maximum pressure to 30 psi.

DS99315 pressure reservoir for 250 cc bottles and 1 pound bottles. Ideal for higher viscosity materials or larger volume dispensing. Chamber dimensions are 6" I.D. by 8.5" in height. Maximum pressure to 100 psi.

DS99320 pressure reservoir for 4.4 pound containers and 1 liter containers. Excellent for applications that require high flow volumes. Maximum pressure to 100 psi.

Engineering Excellence

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

www.instantca.com

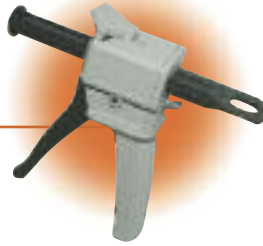
Adhesive Systems, Inc.

DISPENSING GUNS

Two Component Materials

DS99500 50 Mil Manual Gun

Available with 1:1 plunger. Please specify if you need a 2:1 or 10:1 plunger.



DS99500PG 50 Mil Pneumatic Gun

Available in ratio's for 1:1, 2:1



DS99965 200 Mil Manual Gun

Available in ratio's for 1:1, 2:1, 4:1, and 10:1



DS99505 200 Mil Pneumatic Gun

Available in ratio's for 1:1, 2:1



DS99515 380 Mil Manual Gun

For 10:1 CoAxial



DS99517 380 Mil Pneumatic Gun

For 10:1 CoAxial



DS99510 400 Mil Manual Gun

Available in ratio's for 1:1, 2:1, 4:1, and 10:1



DS99511 400 Mil Pneumatic Gun

Available in ratio's for 1:1, 2:1, 4:1, and 10:1



DS99490 490 Mil Manual Gun

For 10:1 side by side

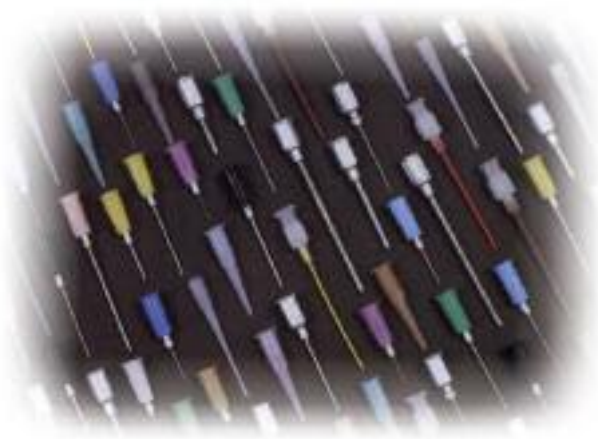


DS99490PN 490 Mil Pneumatic Gun

For 10:1 side by side



APPLICATION HELPERS



PART NUMBER	COLOR	GAUGE	I.D. INCHES	I.D. MM	LENGTH INCHES		PART NUMBER	COLOR	GAUGE	I.D. INCHES	I.D. MM	LENGTH INCHES		
DISPENSING TIPS, Stainless Steel dispensing Tips														
DS14-5M	99600	Alum	14	.063	1.60	.5		DS21-1	99616	Green	21	.020	50	1
DS14-1M	99601	Alum	14	.063	1.60	1		DS22-5	99617	Black	22	.016	.40	.5
DS14-2M	99602	Alum	14	.063	1.60	2		DS22-1	99618	Black	22	.016	.40	1
DS15-5M	99603	Alum	15	.054	1.37	.5		DS22-1M	99619	Alum	22	.016	.40	1
DS15-1M	99604	Alum	15	.054	1.37	1		DS23-.25	99620	Lt. Blue	23	.013	.33	.25
DS15-1.5M	99605	Alum	15	.054	1.37	1.5		DS23-5	99621	Lt. Blue	23	.013	.33	.5
DS16-1M	99606	Alum	16	.047	1.19	1		DS23-1	99622	Lt. Blue	23	.013	.33	1
DS18-5	99607	Pink	18	.033	.84	.5		DS23-1M	99623	Alum	23	.013	.33	1
DS18-1	99608	Pink	18	.033	.84	1		DS25-5	99624	Blue	25	.010	25	.5
DS18-1M	99609	Alum	18	.033	.84	1		DS25-1M	99625	Alum	25	.010	25	1
DS18-1.5M	99610	Pink	18	.033	.84	1.5		DS26-.25	99626	Beige	26	.010	25	.25
DS19-5	99611	Brown	19	.027	.69	.5		DS26-.5	99627	Beige	26	.010	25	.5
DS19-1	99612	Brown	19	.027	.69	1		DS26-1	99628	Beige	26	.010	25	1
DS20-5	99613	Yellow	20	.024	.61	.5		DS27-.25	99629	Grey	27	.008	20	25
DS20-1	99614	Yellow	20	.024	.61	1		DS27-.5/16	99630	Grey	27	.008	20	25
DS21-5	99615	Green	21	.020	.50	.5								

STATIC MIXERS

DS991018 8.5 inch static mixer, luer lock style for 490 mil kits.



DS99550 6 inch static mixer, luer lock style for 50 mil kits.



DS99202 for 400 mil kits.



DS99560 needle adapter for static mixers. Allows the use of dispensing tips for more accurate and precise application.

PLASTIC FLEXIBLE DISPENSING TIPS

(Flexible polypropylene tips/polypropylene locking hub)



	PART NUMBER	COLOR	GAUGE	I.D. INCHES	I.D. MM	LENGTH INCHES
DS15P-1.5	99640	Grey	15	.054	1.37	1.5
DS16P-1.5	99641	Brown	16	.047	1.19	.5
DS18P-1.5	99642	Pink	18	.033	0.89	1.5
DS20P-1.5	99643	Yellow	20	.24	.061	1.5
DS22P-1.5	99644	Black	22	.012	0.30	1.5
DS25P-1.5	99645	Red	25	.010	0.25	1.5

HIGH DENSITY POLYETHYLENE DISPENSING TIPS

(High density polyethylene tips/locking hub, taper tip)



DS14HD-1.25	99650	Tan	14	.063	1.60	1.25
DS16HD-1.25	99651	Grey	16	.047	1.19	1.25
DS18HD-1.25	99652	Green	18	.033	0.84	1.25
DS20HD-1.25	99653	Pink	20	.024	0.61	1.25
DS22HD-1.25	99654	Blue	22	.016	0.40	1.25

PLASTIC FLEXIBLE DISPENSING TIPS

	99665	Clear	2.50			
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PART NUMBER

DESCRIPTION

SIZE

DISPENSING BOTTLES, SYRINGES & RELATED ITEMS

99800	1 oz. low density applicator bottle with luer lock cap.	1 oz.
99804	4 oz. low density applicator bottle with luer lock cap.	4 oz.
99806	1 oz. high density applicator bottle with nozzle cap.	1 oz.
99807	2 oz. high density applicator bottle with nozzle cap.	2 oz.
99801	Luer lock cap 1 oz.	
99805	Luer lock cap 4 oz.	
99810	10cc syringe with polyethylene plunger	
99811	20cc syringe with polyethylene plunger	
99812	35cc syringe with polyethylene plunger	

Bringing people and products together...

IT ALL BEGINS WITH A CHALLENGE...

...a need for a creative solution to your assembly requirements. When you're breaking new ground in assembly technology...when you feel the need for guidance and support in an engineered adhesive...when you tackle new applications in your plant...or if you just want to check on the best and most comprehensive approach to meeting your adhesive requirements...**ADHESIVE SYSTEMS, INC.** is the answer.

EXCELLENCE, INNOVATION, AND COMMITMENT...

...are the roots of our corporate philosophy. Our success and growth is proof that those who know us and use our products and services believe in our dedication to provide our customers the best in high performance engineered adhesives. Through the quality and technology of our products we have exceeded where others have failed and raised the standard of performance for engineered adhesives.

SUCCESS IS A WAY OF LIFE...

...at **ADHESIVE SYSTEMS**. Our number one goal is to the success and satisfaction of you, our valued customer. It is our staff's on-going commitment to work closely with you, to listen to your requirements, and offer a broad range of products and services capable of fulfilling your specific needs. We welcome the opportunity to work with you.



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Telefax (815) 464-5650

Web Site: www.instantca.com

E-mail: asisupport@instantca.com

We have kept in mind the needs and concerns of design, production, and material engineers. Our products offer you increased design capability, efficient methods of assembly, and a wide cross-section of materials to choose from. This ensures a strong, reliable, quality product by combining all phases of product engineering into a better overall, efficient design.



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