

**TURBO FUSE SERIES 190  
(4000 Viscosity)**

Palm Lab's Cyanoacrylate is a one component rapid bonding adhesive. TURBO FUSE SERIES 190 advanced formula is designed to polymerize instantly by absorbing surface moisture. The product's performance has been tested with a variety of materials, and is recommended for a multitude of applications. The fast curing qualities make it especially desirable in high speed industrial production. TURBO FUSE SERIES 190 is ideal for use in applications that require a relatively thick, viscous adhesive. It is also ideal for applications on vertical or angled surfaces.

**PHYSICAL PROPERTIES (Liquid State)**

Base compound (Resin)	Ethyl Cyanoacrylate
Appearance	Clear Liquid
Viscosity cP	3600 to 4400
Specific Gravity	1.05
Flash Point	170° F - 200° F (Tagliabue closed cup)
Shelf Life	1 Year
Soluble in Acetone, MEK, Amide, Methylene Chloride	

**PHYSICAL PROPERTIES (Cured State)**

Appearance	Clear-Hard
Softening Temperature (Fahrenheit)	300°F.
Service Temperature (Fahrenheit)	-65° to 180°F.
Hardness Barcol	65
Dielectric Constant at 1 MHz.	3.33
Specific Resistance	8.6 X 10 <sup>2</sup> ohm/cm
Strength psi-Tensile Shear	2,500
Gap Fill	0.009 "

**MATERIAL SET UP TIME**

Aluminum to Aluminum	< 25 seconds
Steel to Steel	30 to 50 seconds
Phenolic to Phenolic	50 to 80 seconds
Polycarbonate to Polycarbonate	50 to 70 seconds
Rubber to Rubber	< 10 seconds

Because of the 4000 viscosity, it works especially well in poor fitting applications such as rough metal or ceramic repair, unfinished metal to metal bonding, and metal to rubber. This product is a very good, thick, almost gel like adhesive.

INFORMATION ON THIS PRODUCT AND OTHERS SUPPLIED TO USER IS BASED ON OUR GENERAL EXPERIENCE AND IS GIVEN IN GOOD FAITH, BUT BECAUSE OF THE MANY PARTICULAR FACTORS WHICH ARE OUTSIDE OF OUR KNOWLEDGE AND CONTROL AND AFFECT THE USE OF THE PRODUCT, NO WARRANTY IS GIVEN OR IMPLIED WITH RESPECT TO SUCH INFORMATION. FREEDOM UNDER PATENTS, COPYRIGHTS AND REGISTERED DESIGNS CANNOT BE ASSUMED.

**Palm Labs Adhesives**  
10 Office Way, Hilton Head, SC 29928  
Phone: 843 686-2345 Fax: 843 686-2230