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**TURBO FUSE SERIES 115SI - SURFACE INSENSITIVE  
(20 Viscosity)**

Palm Lab's Cyanoacrylate is a one component rapid bonding adhesive. TURBO FUSE SERIES 115SI – SURFACE INSENSITIVE 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 115SI is ideal for use in applications that require an easily handled low viscosity adhesive on difficult surfaces.

**Part Numbers for this TDS:** 04-115SI, 10-115SI, 15-115SI, 20-115SI, 25-115SI, 30-115SI, 35-115SI

**PHYSICAL PROPERTIES (Liquid State)**

Base compound	Surface Insensitive Ethyl Cyanoacrylate
Appearance	Clear Liquid
Viscosity cP	20
Flash Point	160° F - 200° F (Tag closed cup)
Shelf Life	1 Year
Soluble in	Acetone, MEK, Amide, Methylene Chloride

**PHYSICAL PROPERTIES (Cured State)**

Appearance	Clear-Hard
Full Cure	24 Hours
Melting Temperature	+160 to +170°C
Service Temperature	-60° to +80°C
Tensile Shear Strength	18-28 n/nm <sup>2</sup>
Gap Fill	0.05 mm

**MATERIAL SET UP TIME**

Rubber	< 3 seconds
Plastics	2 to 5 seconds
Metals	8 to 10 seconds
Wood	1 to 5 seconds
Leather	5 to 15 seconds
Ceramics	12 to 18 seconds

**SHEAR STRENGTH ASTM D 1002/DIN 53283**

Grit Based Steel	> 20 N/mn <sup>2</sup>
Etched Aluminum	> 18 N/mn <sup>2</sup>
Rubbers	> 22 N/mn <sup>2</sup>
Wood	> 25 N/mn <sup>2</sup>
Polycarbonate	> 12 N/mn <sup>2</sup>
ABS	> 10 N/mn <sup>2</sup>

Because of the 20 viscosity, it works especially well in close to medium fitting applications that have difficult bonding surfaces.

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.

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