



TECHNICAL DATA BULLETIN

INSTAbond® IR-1500

Cyanoacrylate Adhesive

PRODUCT DESCRIPTION:

INSTAbond® IR-1500 is a single component mid viscosity cyanoacrylate. This technology will bond most close fitting smooth surfaces and polymerizes to a tough shock resistant polymer. It is black in color, has a medium set time and can handle temperatures up to 220°F. INSTAbond® IR-1500 contains no solvent and has low toxicity, which makes it very popular and easy to use. Additionally, this material requires no mixing or heating and can be used on a wide variety of substrates.

INSTRUCTIONS FOR USE:

To maximize performance of INSTAbond® IR-1500 cyanoacrylate, clean and degrease all substrates before applying adhesive. Make sure substrates are dry before applying adhesive. Apply a thin bond line for best results. Difficult to bond plastics like polyethylene, polypropylene, ABS, EPDM and silicone rubber will require INSTAbond® PDQ Primer for best results. If setting time is longer than desired (caused by low humidity or large gap fill), use INSTAbond® PDQ Accelerator.

PROPERTIES OF MATERIALS AS SUPPLIED

Property	Test Method	Unit	Value
Chemical Type	-----	-----	Ethyl Cyanoacrylate
Appearance	Visual	-----	Black liquid
Density	ASTM D792	g/cc (lb/gal)	1.1
Brookfield Viscosity	ASTM D2393	cP	1,350-1,650

CURED PROPERTIES

Property	Test Method	Unit	Value
Gap Filling	-----	-----	0.20mm
Tensile Strength (steel to steel)	ASTM D-2095	N/mm ²	25-30
Tensile LapShear (steel to steel)	ASTM D-1002	N/mm ²	15-20



CURE SPEED – based on 50% RH at 22°C (72°F)

Substrate	Unit
Plastic	30 Seconds
Rubber	25-45 Seconds
Metal	25-45 Seconds
Wood	25-45 Seconds

STORAGE

This product should be stored at 25°C (77°F) and out of direct sunlight. Product should be stored in the original, closed container. Shelf life is 12 months when stored in accordance with manufacturer’s recommendations.

Refer to the INSTAbond® IR-1500 Material Safety Data Sheet for instructions on safe handling of this material.

PACKAGING:

INSTAbond® IR-1500 is available in 1-oz, 2-oz, 4-oz, 500 gram (1.1 lb.) bottles. Other package sizes and options are available upon request.

NOTE

The information contained in this document is furnished for information only and it’s believed to be reliable based on previous evaluations. We cannot assume responsibility for the results obtained by others over whose methods we have no control. It is the user’s responsibility to determine suitability for user’s application based on user’s production methods. This data should only be used as a guide for determining feasibility for a particular application.

Conversion Information:

- $(^{\circ}\text{C} \times 1.8) + 32 = ^{\circ}\text{F}$
- $\text{N} \times 0.225 = \text{lbs}$
- $\text{N}/\text{mm} \times 5.71 = \text{psi}$
- $\text{N}/\text{mm}^2 \times 145 = \text{psi}$
- $\text{N}\cdot\text{m} \times 8.851 = \text{lb. in}$
- $\text{mP}\cdot\text{s} = \text{cP}$

PRODUCT INFORMATION CONTAINED HEREIN IS INTENDED FOR REFERENCE ONLY. MATERIAL SAFETY DATA INFORMATION AVAILABLE AT (662) 895-4480 OR IN WRITING TO: ACCRAbond, Inc. 8848 Hacks Cross Road, Olive Branch, MS 38654-1827, www.accrabond.com.

ACCRAbond™

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