



**TECHNICAL DATA SHEET**  
**TDS #: FS 30**  
**CYANOACRYLATE ADHESIVE**  
REVISED: DECEMBER/2010

**ADVANCE PERFORMANCE SERIES**  
**FS 30 CYANOACRYLATE ADHESIVE**  
**FAST CURING ADHESIVE**

**DESCRIPTION:**

The FS Series represents the latest technology in cyanoacrylate adhesives. Extremely fast curing, ideal for applications where low moisture conditions exist and/or exceptionally fast fixture times are desired. Bonds to a wide range of substrates.

**PHYSICAL PROPERTIES:**

Color: Clear  
Viscosity: 30  
Specific Gravity: 1.05  
Base: Modified Ethyl

**PERFORMANCE PROPERTIES:**

| Substrate     | Fixture Time | Bond Strength |
|---------------|--------------|---------------|
| Steel         | < 10 Seconds | > 2100 psi    |
| Aluminum      | < 10 Seconds | > 1750 psi    |
| Neoprene      | < 5 Seconds  | > 750 psi     |
| ABS           | < 5 Seconds  | > 900 psi     |
| PVC           | < 5 Seconds  | > 900 psi     |
| Polycarbonate | < 5 Seconds  | > 900 psi     |
| Phenolic      | < 10 Seconds | > 850 psi     |

NOTE: Method used, ISO 4587.

**Tensile Strength:**

Steel: > 1800 psi  
NOTE: Method used, ISO 6922

**ELECTRICAL PROPERTIES:**

Dielectric Constant ASTM D 150 Dissipation Factor  
1 kHz 2 to 3.50/ < 0.02

Volume Resistivity ASTM D 257:  $2 \times 10^{15}$  to  $10 \times 10^{15}$

**FACTORS AFFECTING CURE SPEED:**

**GAP:** Thin bond line results in faster cure speed. Larger gaps will lengthen cure speed.

**HUMIDITY:** Cure and fixture times can be influenced by the humidity conditions at the time of assembly. The higher the RH the faster cure and fixture times will be. Fixture time data based on our testing is conducted at 50% relative humidity.

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**What we bond:**

|                |               |
|----------------|---------------|
| ABS            | NBR           |
| Acrylic        | Neoprene      |
| Aluminum       | Nitrile       |
| Bakelite       | Nylon         |
| Brass          | Phenolic      |
| Chloroprene    | Polycarbonate |
| Chrome         | Polyester     |
| Cooper         | Polystyrene   |
| EPDM           | Porcelain     |
| Fiberglass     | PVC           |
| Latex          | SBR           |
| Leather        | Steel         |
| Natural Rubber | Valox         |
|                | Wood          |

**CHEMICAL/SOLVENT RESISTANCE:**

% OF STRENGTH RETAINED AFTER AGING FOR 500 HOURS

|                             |      |
|-----------------------------|------|
| GASOLINE @ 22°C:            | 100% |
| ISOPROPANOL @ 22°C:         | 100% |
| ETHANOL @ 22°C:             | 100% |
| FREON TA @ 22°C%:           | 100% |
| MOTOR OIL @ 40°C%:          | 100% |
| POLYCARBONATE 40°C @ 95% RH | 100% |

**DIRECTIONS FOR USE:**

For optimum results parts should be clean and free from any contamination on the bonding surface. If parts do not mate flush together use a higher viscosity product to compensate for the gap. Any excess adhesive can be removed using Remove Debonder.

**STORAGE:**

Store product in unopened containers, out of direct sunlight, in a dry location. Material should be stored at or below 22°C. For extended shelf life unopened containers of the product may be refrigerated.

**Engineering Excellence**

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

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