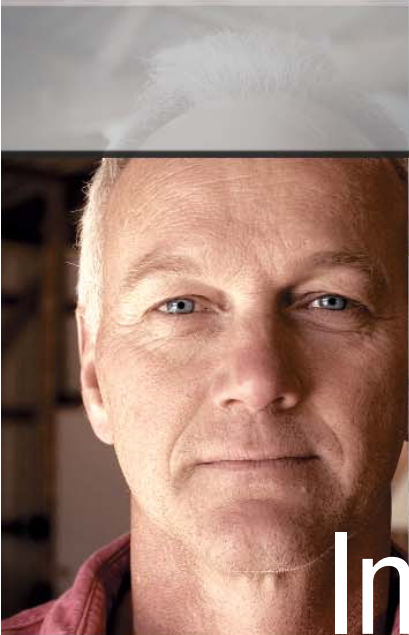


RITE-LOK™

Cyanoacrylate Adhesives

Instant
assembly

Instant
versatility



3M

Choices for instant performance and productivity... flexible bond line, low bloom, low odor, viscosities, and more

Known as instant adhesives, Rite-Lok™ Cyanoacrylate Adhesives offer more than a range of seconds-fast bonding for substrates ranging from metal to plastic, wood to rubber. These liquid and gel formulations give you a wide selection of other properties to help improve production and end use.



3

Super fast curing



4

- Reach handling strength in 5-20 seconds to speed production
- Reliable assembly of difficult-to-bond plastics and rubbers, and acidic surfaces such as wood, leather, and oily surfaces

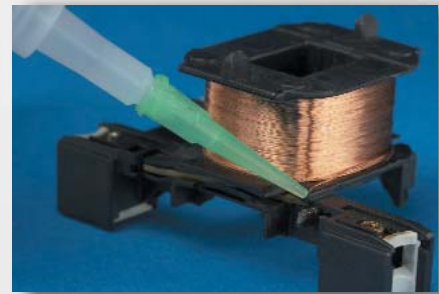
Low odor



5

- Low blooming/frosting for visual appeal; eliminates chlorosis (white residue at the joint)
- Reduces need for sophisticated ventilation equipment

High Temperature



6

- Superior resistance to high temperature, thermal cycling and shock

Rubber-toughened



7

- Unique polymer maximizes resistance to impact, peel, and thermal cycling
- Flexible bond lines for bonding flexible and dissimilar substrates

Flexible



8

- Extended resistance to impact, vibration, stress, peel, and humidity
- Faster curing than rubber-toughened

Engineered Grade



9

- Exceptional performance on difficult-to-bond plastics and rubbers, together or in combination with metals and/or composites
- Superior performance on PVC, ABS, nylon, EPDM, Santoprene, and Viton

Metal



- Optimum performance and high strength bonds on metal
- Bond galvanized, anodized, and other difficult-to-bond metals
- Two standard viscosities

Surface Insensitive



- Bond rough, porous, contaminated and acidic substrates including wood, cardboard, veneer, fabric, cork and leather
- Cure fast at low humidity
- Work where other cyanoacrylates fail

General Purpose



- Bond a wide variety of substrates
- Available in wide variety of viscosities

Production Aids

- Primers, activators, and cleaner optimize your productivity

Product Selection

Product	Typical Use	Color	Chemical Type	Typical Viscosity (cps)	Temperature Range	Time to Handling	Full Cure (hours)	Markets
Super Fast Cyanoacrylate Adhesives								
SF20	Optimum performance on wide range of rubber and plastic	Clear	Ethyl Hybrid	20	-65° to 180°F (-54° to 82°C)	3-30 sec.	24	Automotive, appliance, leather working, hand tools, electronics, power tools
SF100	Fast cure, high strength with EPDM and other elastomers			100		3-30 sec.		
Low Odor Cyanoacrylate Adhesives								
LO5	Very low viscosity wicking grade	Clear	Methoxyethyl	5	-65° to 160°F (-54° to 71°C)	5-60 sec.	24	Cosmetic cases, appearance-critical applications, black substrates, close-up bonding
LO100	Low-medium viscosity for close fitting parts			100		10-60 sec.		
PR03	Medium-high viscosity for gap filling			1000		20-70 sec.		
Rubber-Toughened Cyanoacrylate Adhesives								
PR80	Low viscosity for close fitting parts	Black	Ethyl Hybrid	300	Continuous -65° to 200°F (-54° to 93°C) Intermittent -65° to 225°F (-54° to 107°C)	20-50 sec.	24	Automotive, appliance, electric motors, hand tools, electronics, power tools
PR10	High viscosity for gap filling			3500		20-90 sec.		
Flexible Cyanoacrylate Adhesives								
PR851	Medium viscosity with some gap filling	Clear	Ethyl Hybrid	300	-65° to 160°F (-54° to 71°C)	10-35 sec.	24	Automotive, appliance, hand tools, electronics, power tools

Continued next page.

Product Selection (cont.)

Product	Typical Use	Color	Chemical Type	Typical Viscosity (cps)	Temperature Range	Time to Handling	Full Cure (hours)	Markets
High Temperature Cyanoacrylate Adhesives								
HT40	Low viscosity for close fitting parts	Clear	Ethyl Hybrid	40	Continuous -65° to 223°F (-54° to 106°C) Intermittent -65° to 250°F (-54° to 121°C)	5-20 sec.	24	Appliance, electronics, electric motors, automotive, transformers
SB98	Medium viscosity with some gap filling			500		15-40 sec.		
HT700	Medium viscosity with some gap filling			700		15-40 sec.		
Engineered Grade Cyanoacrylate Adhesives								
PR5	Very low viscosity wicking grade for plastics/rubbers	Clear	Ethyl Hybrid	5	-65° to 180°F (-54° to 82°C)	1-10 sec.	24	Automotive, appliance, electronics, hand tools, power tools
PR40	Low viscosity for close fitting plastics/rubber parts			40		3-20 sec.		
SB04	General purpose, low viscosity standard rubber bonder			100		10-30 sec.		
SB14	General purpose, low viscosity plastic bonder			100		10-30 sec.		
PR600	Medium viscosity with some gap filling for plastics/rubbers			600		4-25 sec.		
PR1500	High viscosity for gap filling with plastics/rubbers			1500		20-100 sec.		
SB16	General purpose, high viscosity for gap filling			1500		20-100 sec.		
PR54	Fast cure, gel viscosity for max gap filling			Gel		3-60 sec.		
Metal Cyanoacrylate Adhesives								
SB93	Low viscosity to penetrate between parts	Clear	Methyl	5	-65° to 180°F (-54° to 82°C)	15-35 sec.	24	Costume jewelry, treated metals, plated metals, metal working
MC100	Multi-purpose metal bonder			100		5-20 sec.		
SB30	Multi-purpose metal bonder			100		5-20 sec.		
Surface Insensitive Cyanoacrylate Adhesives								
SB20	Very low viscosity wicking grade	Clear	Ethyl Hybrid	2	-65° to 180°F (-54° to 82°C)	15-35 sec.	24	Woodworking, luggage and fabric, hobby, costume jewelry, leather
SB95	Low viscosity for close fitting parts			40		2-20 sec.		
SI100	Low-med viscosity for medium gaps			100		3-20 sec.		
SI1500	High viscosity for gap filling			1500		5-60 sec.		
SI2500	Very high viscosity for gap filling			2500		15-40 sec.		
SB22	Very high viscosity for gap filling			2500		15-40 sec.		
SB09	Fast cure, gel viscosity for max gap filling			Gel		3-60 sec.		

Note: This technical information and data should be considered representative only and should not be used for specification purposes.

Product Selection (cont.)

Product	Typical Use	Color	Chemical Type	Typical Viscosity (cps)	Temperature Range	Time to Handling	Full Cure (hours)	Markets
General Purpose Cyanoacrylate Adhesives								
EC5	Very fast cure for pre-assembled parts	Clear	Ethyl	5	-65° to 180°F (-54° to 82°C)	5-15 sec.	24	Automotive, general bonding, consumer products, toys, rubber/plastic assembly
EC40	General purpose, fast curing			40		10-30 sec.		
EC100	General purpose, fast curing			100		10-40 sec.		
EC600	Higher viscosity to reduce migration from bond area			600		5-60 sec.		
EC1500	Slower cure for porous materials or gap filling			1500		20-60 sec.		
EC2500	Slow cure for porous material or gap filling			2500		20-60 sec.		
ECIGEL	Industrial strength thixotropic gel for maximum gap filling			Gel		45-180 sec.		
Cyanoacrylate Primers, Activators, and Debonders								
AC12	Cyanoacrylate accelerator with isopropyl alcohol formulation for insensitive plastics, cosmetically critical bond lines, and medical applications.							
AC68	Cyanoacrylate debonder for clean up.							
AC77	Cyanoacrylate polyolefin primer for very fast bonding of difficult-to-bond polyethylene and polypropylene.							
AC113	Cyanoacrylate general purpose accelerator will not attack plastics.							
AC452	Cyanoacrylate acetone-based accelerator flashes off rapidly; excellent adhesion; overspray may attack some plastics.							

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