



## SI1500

SI1500 is a surface insensitive cyanoacrylate adhesive that is used in applications that require faster cure speeds, on parts that are dry, and on parts that may be acidic. The SI Series bonds a wide range of similar and dissimilar surfaces. The SI Series provides exceptional performance in a wide range of applications

<b>Technology / Base</b>	Modified Ethyl
<b>Type of Product</b>	Cyanoacrylate
<b>Components</b>	One Component
<b>Curing</b>	Humidity
<b>Appearance / Color</b>	Clear
<b>Consistency</b>	Viscous Liquid

### Technical Data

Uncured Material Characteristics	Value	Condition/Method
Viscosity	1500 cPs	
Specific Gravity	1.06	
Storage Condition	< 22°C	
Set Time		
Steel	< 10 sec	
Aluminum	<10 sec	
Neoprene	<5 sec	
ABS	<10 sec	
PVC	<10 sec	
Polycarbonate	<10 sec	
Phenolic	<10 sec	
Cured Material Characteristics		
Shear Strength		
Steel	>2100 psi	ISO 4587
Aluminum	>1750 psi	ISO 4587
Neoprene	>750 psi	ISO 4587
ABS	>900 psi	ISO 4587
PVC	>900 psi	ISO 4587
Polycarbonate	>900 psi	ISO 4587
Phenolic	>850 psi	ISO 4587
Tensile Strength	>1800 psi	ISO 6922
Damp Heat Aging	100%	Strength on PC after 500 hrs at 40°C, 95% R.H.
Dielectric Constant	2 to 3.5 at 1kHz	ASTM D150
Dissipation Factor	< 0.02 at 1kHz	ASTM D150
Volume Resistivity	2 to 10 x 10 <sup>15</sup> ohm·cm	ASTM D257



**General Instructions**

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. Factors Affecting Cure Speed Include: 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.

**Specifications and Approvals**

**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.

**Safety & Disposal**

For safe handling information and disposal instructions on this product, consult the Safety Data Sheet (SDS)

Date Modified: 03 January 2017

H.B. Fuller Company  
 9001 W. Fey Drive  
 Frankfort, IL 60423  
 +1.800.552.0299

[www.hbfuller.com](http://www.hbfuller.com)

Connecting what matters.™

IMPORTANT: Information, specifications, procedures and recommendations provided ("information") are based on our experience, and we believe this information to be accurate. No representation, guarantee or warranty is made as to the accuracy or completeness of the information or that use of the product will avoid losses or damages or give desired results. It is purchaser's sole responsibility to test and determine the suitability of any product for the intended use. Tests should be repeated if materials or conditions change in any way. No employee, distributor or agent has any right to change these facts and offer a guarantee of performance.

® and ™ are trademarks of H.B. Fuller Company or one of its affiliated entities.



**NOTE TO USER:** by ordering/receiving product you accept the H.B. Fuller General Terms and Conditions of Sale applicable in the region. Please request a copy if you have not received these. These Terms and Conditions contain disclaimers of implied warranties (including but not limited to disclaiming warranties of fitness for a particular purpose) and limits of liability. All other terms are rejected. In any event, the total aggregate liability of H.B. Fuller for any claim or series of related claims however arising, in contract, tort (including negligence), breach of statutory duty, misrepresentation, strict liability or otherwise, is limited to replacement of affected products or refund of the purchase price for affected products. H.B. Fuller shall not be liable for loss of profit, loss of margin, loss of contract, loss of business, loss of goodwill or any indirect or consequential losses arising out of or in connection with product supply.

H.B. Fuller  
[www.hbfuller.com](http://www.hbfuller.com)