



TS4000

The TS Series is a highly engineered rubber toughened cyanoacrylate adhesive. It is elastomer modified providing excellent impact resistance, thermocycling properties, and heat aging properties. The TS Series is ideal for bonding dissimilar surfaces that are exposed to high and low end temperatures. High end temperature resistance up to 250°F.

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

Technical Data

Uncured Material Characteristics	Value	Condition/Method
Viscosity	4000 cPs	
Specific Gravity	1.1	
Storage Condition	< 22°C	
Set Time		
Steel	< 20 sec	
Aluminum	<20 sec	
Neoprene	<5 sec	
ABS	<18 sec	
PVC	<16 sec	
Polycarbonate	<18 sec	
Phenolic	<18 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 ¹⁵ 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)

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