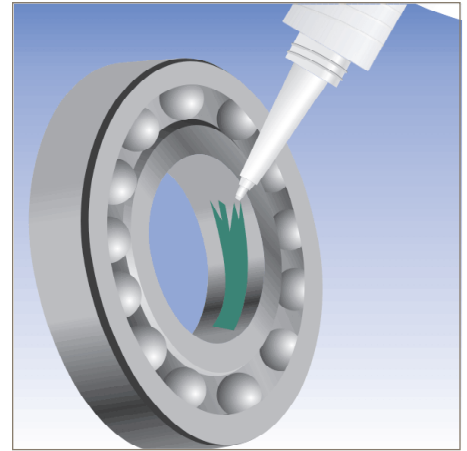


# Instant Adhesives

## IA Series



### Fast, safe bonding:

Based on cyanoacrylate technology, Parker's IA Series is made up of single-component adhesives available with a low, medium and high viscosity. All three types have fast setting time, offer high tensile strength and do not require pre-mixing.

These general purpose adhesives are used in various applications and bond to a variety of substrates such as metals, rubbers, ceramics, leather, wood and most plastics. They take only a few seconds to bond and are highly resistant to disassembly. IA Series Adhesives are easy to use and need only be placed on one surface to allow for almost immediate handling of bonded parts. Cure occurs at room temperature and in most instances does not require any further activator or heat to bond.

These adhesives are extremely easy to apply and can be used in manual, semi-automatic or automatic applications.

### Contact Information:

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### Product Features:

- Solvent free
- Cures at room temperature
- Resistant to major chemicals
- Temperature range of -22 to 176°F (-30 to 80°C)
- Easy to use
- Bonds in only a few seconds and can be handled immediately
- Economic
- Not recommended for vibration



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## Usage Guidelines:

- Clean parts, completely eliminating oily and other contaminating particulates, such as rust, dust and previous adhesive from parts
- Apply product directly from its original container
- Apply on one of the surfaces and join parts. Keep under pressure approximately 30 seconds to ensure maximum contact between bonded surfaces (this period may vary depending on substrate to be bonded)
- Keep the container closed at all times in order to maintain product integrity
- In general, one drop spreads over one square inch
- Optimal results are obtained with minimum quantity of adhesive applied to connect the joint

## Set Time:

Initial cure occurs between 1 and 20 seconds, depending on where the product was applied and the gap fills between the parts.

## Storage:

- Store product in cool and dry place, in its original container, at maximum temperature of 70°F (21°C) for short term usage. For long term usage, it is recommended to store the product in cool and dry place, refrigerated at 47°F (8°C).
- Allow product to reach room temperature before using
- To avoid contamination, do not return used product to original container

## Safety Precautions:

Bonds skin and eyes in seconds  
In case of contact with eyes, wash with warm water, keeping eyes open and wet. Do not force separation of bonded skin. The skin can be unglued after using warm water and soap. If irritation persists, get medical attention.<sup>5</sup>

## Toxicity:

Use in a well-ventilated room to avoid eye and respiratory irritation caused by vapors. Keep out of reach of children and animals.<sup>5</sup>

## IA Series Typical Properties Chart

Product	Color <sup>2</sup>	Work Temp.	Viscosity	Gap Fill	Tensile Strength <sup>3</sup>	Setting Time <sup>1</sup>		Activator <sup>4</sup>
						Partial	Total	
				mm	Kgf/cm <sup>2</sup>	Sec.	Hrs.	
IA01	Colorless	-22 to 176°F -30 to 80°C	Low	0.05	150 to 300	1 to 20	24	ST01
IA04	Colorless	-22 to 176°F -30 to 80°C	Medium	0.10	150 to 300	1 to 20	24	ST01
IA06	Colorless	-22 to 176°F -30 to 80°C	High	0.15	150 to 300	1 to 20	24	ST01

1. The setting time is strongly influenced by substrate, room temperature and presence of activators. Above data regards to substrate carbon steel flushed in temperature of 22°C without use of activators. The Set Time Test for cyanoacrylate products are conducted using NBR rubber test specimens.
2. These products can slightly yellow depending on product storage conditions and age. This is not expected to compromise effectiveness in application as long as the shelf life printed on the bottle has not been exceeded.
3. ASTM D1002, cured 24 hours @ 22°C flushed steel plaques.
4. Activators (ST01) may be required to enhance cure for PP, PE, POM, PA and stainless steel.
5. Refer to MSDS for additional information.

