



Pacer ISL Series threadlocking compounds are patented technology structural cyanoacrylate adhesives suitable for locking plastic and metal threaded fasteners. These products offer the strength and durability of anaerobics with the cure characteristics of a cyanacrylate; their versatility allows them to work on plated surfaces, plastic fasteners, wood, stainless steel and other metals without use of an activator. Five products are offered with varied strengths and viscosities to suit a wide variety of fastener sizes.

LIQUID STATE	ISL-22	ISL-42	ISL-71	ISL-90
Base Chemical	Modified Ethyl Cyanoacrylate			
Description	REMOVABLE		PERMANENT	WICKING
Strength	Low	Medium	High	High
Color	Purple	Blue	Red	Green
Viscosity, cP	85-160	1500-2000	130-250	10-25
Typical Gap, inches	.004	.008	.005	.002
Flashpoint, °F/°C	178/81	181/83	183/84	183/84
Specific Gravity (25°C)	1.03	1.06	1.05	1.05
Soluble in:	Acetone, MEK, Nitromethane			

CURED STATE	ISL-22	ISL-42	ISL-71	ISL-90
Locking Torque ¹ (in-lbs) Breakaway	39-91	58-151	116-180	141-196
Prevaling	18-35	30-83	144-217	138-161
Tensile Shear Strength ² , psi	800 (±10%)	1850 (±10%)	2500 (±10%)	2000 (±10%)
Rockwell Hardness, M	60	67	69	68
Dielectric Constant, @ 1MHz	4.40	4.30	4.04	4.17
Linear Expansion, mm/°C	10x10 ⁻⁵	15x10 ⁻⁵	8x10 ⁻⁵	13x10 ⁻⁵
Decomposition Temperature	405° F (207° C)			
Service Temperature Range	-65° F to +205° F (-54° C to +96° C)			
Soluble in:	Pacer X-9 Debonder, Acetone, Nitromethane			

¹ Breakaway/prevaling torque tested on Steel M10, 3/8" x 24 nuts & bolts.

² Tensile Shear Strength tested on steel lap shears per ASTM D-1002.



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APPLICATION AND CURE CHARACTERISTICS:

For best results, parts should be clean and free from oil and grease, or other contaminants. Apply adhesive to threads of screw and assemble. Fixture occurs in 1-5 minutes with 80% of full strength developing in 15-30 minutes. Although accelerators are not necessary, Pacer accelerators for instant adhesives are compatible and can be used.

Specification Compliance	ISL-22	ISL-42	ISL-71	ISL-90
MIL-A-46050C (Type/Class)	*II/2	*II/3	*II/2	*II/1
A-A-3097 (Commercial Spec)	*II/2	*II/3	*II/2	*II/1

*For Section 3.2.1. Compliance, the ISL products will be supplied colorless. Request for dyed products should qualify this deviation from the specification.

STORAGE AND SHELF LIFE:

Refrigerate unopened cyanoacrylate @ 40F (4C) for optimum results. Allow adhesive to reach room temperature before opening. Once opened, store in a cool, dry location. Stored under these conditions, a one year shelf life can be expected.

SAFETY AND HANDLING PRECAUTIONS:

Cyanoacrylate adhesives bond skin in seconds. In case of skin contact, flush with water. If skin becomes bonded, peel (not pull) apart after immersion in warm, soapy water. In case of eye or mouth contact, flush with water and get immediate medical attention. Use with adequate ventilation. Vapors can irritate eyes and mucous membranes. Symptoms disappear after removal of individual from vapors. For more information, refer to Material Safety Data Sheet, available upon request.

In case of emergency, call Pacer Technology at 800-538-3091 (outside CA only), or 909-987-0550.

Size/Part Number	ISL-22	ISL-42	ISL-71	ISL-90
10 mL	FG06034			FG06024
50 mL		FG06055	FG06015	
1 lb	FG06033	FG06053	FG06013	

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