



Rite-Lok™

General Purpose Instant Adhesives for Metal Bonding

SB30 • SB93 • SB96 • MC100

Technical Data

March, 2009

Product Description

Rite-Lok™ General Purpose Instant Adhesives for Metal Bonding are designed to give optimum performance and high strength bonds on metals.

Specific Features

- Rite-Lok™ General Purpose Instant Adhesive for Metal Bonding SB30 is a low-medium viscosity cyanoacrylate designed for metals bonding but which can also bond plastics, rubbers and other common substrates. It has been tested and passed the requirements of Commercial Item Description A-A-3097, Type I, Class 2 (formerly MIL-A-46050C).
- Rite-Lok™ General Purpose Instant Adhesive for Metal Bonding SB93 is a very low viscosity cyanoacrylate primarily used for bonding smooth, even, close fitting parts. It is a wicking type cyanoacrylate that can be used in preassembled parts. It has been tested and passed the requirements of Commercial Item Description A-A-3097, Type I, Class 1 (formerly MIL-A-46050C).
- Rite-Lok™ General Purpose Instant Adhesive for Metal Bonding SB96 is a low-medium viscosity cyanoacrylate designed for metals bonding which can also bond plastics, rubbers, and other common substrates.
- Rite-Lok™ General Purpose Instant Adhesive for Metal Bonding MC100 is a low-medium viscosity cyanoacrylate designed for metals bonding which can also bond plastics, rubbers, and other common substrates.

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**Typical Uncured
Physical Properties****Note:** The following technical information and data should be considered representative or typical only and should not be used for specification purposes.

	Rite-Lok™ General Purpose Instant Adhesives for Metal Bonding			
	SB30	SB93	SB96	MC100
Color	Clear	Clear	Clear	Clear
Base	Methyl	Methyl	Methyl	Methyl
Appearance	Liquid	Liquid	Liquid	Liquid
Specific Gravity	1.06	1.09	1.06	1.06
Viscosity (cps)	80 - 120 ¹	2 - 5 ²	80 - 120 ¹	80 - 120 ¹
Time to Handling Strength (sec)	5 - 20	15 - 35	5 - 20	5 - 20
Full Cure Time (hr)	24	24	24	24

¹ ISO 3104/3105.² U-Tube IC-C45.**Typical Cured
Properties****Note:** The following technical information and data should be considered representative or typical only and should not be used for specification purposes.

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Temperature Range (°F)	-65 to 180	-65 to 180	-65 to 180	-65 to 180
Gap Fill (in)	0.006	0.002	0.006	0.006
Tensile Strength (psi)³	4,800	5,100	4,800	4,800
Overlap Shear Strength (psi)⁴	3,100	3,100	3,100	3,100

³ ASTM D2095.⁴ ASTM D1002.

Handling Information**Surface Preparation**

For optimum strength structural bonds, paint, oxide films, oils, dust, mold release agents, and all other surface contaminants must be completely removed. However, the amount of surface preparation depends on the required bond strength and the environmental aging resistance desired by the user. Typical quick surface preparation would include wiping with a clean solvent (such as isopropyl alcohol*), abrading the surface with a clean fine abrasive, and then wiping again with a clean solvent to remove loose particles.

Directions for Use

1. Ensure that parts are clean, dry, and free from oil and grease.
2. A Rite-Lok™ Instant Adhesive Activator may be required if there are bonding gaps or porous substrate surfaces, if substrates are low surface energy plastics (e.g., polyethylene, polypropylene) or if substrates have acidic surfaces (e.g., paper, leather).
3. Bond speed is typically very fast so ensure that parts are properly aligned before dispensing.
4. Product is normally hand applied from the bottle. Apply sparingly to one surface and press parts firmly together until handling strength is achieved. As a general rule, as little cyanoacrylate as possible should be used. Over application will result in slower cure speed and lower bond strength.

Cured Bond Characteristics

1. Full bond strength will typically be achieved within a 24 hour cure time.
2. Low humidity or low temperature conditions will slow down the cure rate.
3. After curing, Rite-Lok™ General Purpose Instant Adhesive for Metal Bonding bonds are suitable for use up to about 180°F (82°C). At 180°F (82°C) the bonds will be approximately 70% of the strength at room temperature and at 212°F (100°C) about 50% of full strength.
4. Cyanoacrylate bond resistance to most oils and solvents is excellent. Long term humidity, moisture, or water immersion may affect the strength of a cured cyanoacrylate bond depending on the substrates and the bond gap. Testing is recommended to evaluate the effect.

***Note:** When using solvents, extinguish all ignition sources, including pilot lights, and follow the manufacturer's precautions and directions for use.

Storage

For short term storage (<30 days), keep adhesive in a cool (60°F to 80°F [16°C to 27°C]), dry place out of direct sunlight. Keep containers tightly covered and free of moisture. Refrigeration (40°F [4°C]) gives optimum long term storage stability.

Shelf Life

Rite-Lok™ General Purpose Instant Adhesives for Metal Bonding can be expected to have a shelf life of one year from the date of shipment from 3M when stored under refrigerated conditions.

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Precautionary Information

Refer to Product Label and Material Safety Data Sheet for health and safety information before using this product. For additional health and safety information, call 1-800-364-3577 or (651) 737-6501.

Technical Information

The technical information, recommendations and other statements contained in this document are based upon tests or experience that 3M believes are reliable, but the accuracy or completeness of such information is not guaranteed.

Product Use

Many factors beyond 3M's control and uniquely within user's knowledge and control can affect the use and performance of a 3M product in a particular application. Given the variety of factors that can affect the use and performance of a 3M product, user is solely responsible for evaluating the 3M product and determining whether it is fit for a particular purpose and suitable for user's method of application.

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ISO 9001:2000

This product was manufactured under a quality system registered to ISO 9001:2000 standards.



Industrial Adhesives and Tapes Division

3M Center, Building 225-3S-06
St. Paul, MN 55144-1000
800-362-3550 • 877-369-2923 (Fax)
www.3M.com/industrial



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