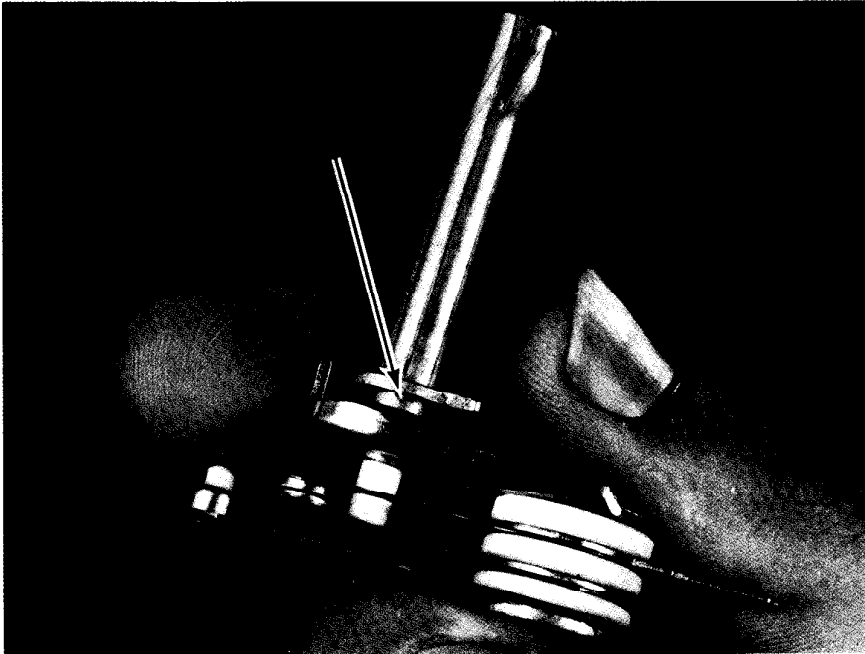


Foundry Service & Supplies, Inc.

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SAUEREISEN

INSA-LUTE ADHESIVE CEMENT NO. 1



A major manufacturer of home appliances utilizes No. 1 to seal the set screw (located at stem base indicated by arrow) of this thermostat, and thus assure maintenance of the proper temperature range calibration.

CHARACTERISTICS

- Heat conductive and thermal shock resistant
- Insulates electricity
- Resists all acids (except hydrofluoric)
- Resists oil and fire
- Resists temperature to 1800°F (982°C)
- More economical than resins or silicones
- Replaces resins for high temperature applications
- Good mechanical bond
- Can be colored
- One part cement, ready to use
- Odorless

PHYSICAL PROPERTIES

Coefficient of thermal expansion	6.2 x 10 ⁻⁶ in/in/°F (11.2 x 10 ⁻⁶ cm/cm/°C)
Color	Off white
Compressive strength	3900 psi (274 kg/cm ²)
Dielectric constant	3.5-6.0
Dielectric strength	12.5 to 51.0 Volts/mil (490 to 2000 Volts/mm)
at 70°F (21°C)	≤ 15.0 Volts/mil (588 Volts/mm)
at 750°F (399°C)	≤ 1.3 Volts/mil (51 Volts/mm)
at 1475°F (801°C)	
Maximum service temperature	1800°F (982°C)
Modulus of rupture	460 psi (32 kg/cm ²)
Shear strength	710 psi (49 kg/cm ²)
Tensile strength	410 psi (28 kg/cm ²)
Volume resistivity	
at 70°F (21°C)	10 ⁸ -10 ⁹ ohm-cm
at 750°F (399°C)	10 ⁴ -10 ⁵ ohm-cm
at 1475°F (801°C)	10 ² -10 ³ ohm-cm

Strong inorganic adhesive for:

Appliances **Insulating**
Assembling **Metals**
Ceramics **Sealing**

Sauereisen Insa-Lute Adhesive Cement No. 1 is specified throughout industry for assembling, insulating, heat treating, and cementing porcelain, glass, metal, and other materials. No. 1 is also used to replace sealing wax, bolts, nuts, screws, and mica because it readily adheres to practically any non-plastic surface which is clean and free from oil and grease.

APPLICATION/CURING

Sauereisen No. 1 is supplied as a ready mixed paste and may be applied by brushing, dipping, or spraying. Depending on the application, No. 1 may be thinned with Sauereisen Thinning Liquid No. 14.

No. 1 is suitable for use on production lines with mechanical dispensers or applicators as it will not harden in the equipment.

Hardening is by air drying into a white porcelain-like body. In applications where the cement is not exposed to the air, such as in spark plug or fuse assembling, it must be dried by baking at low temperatures.

The cement is also available in a powder form known as Sauereisen Insa-Lute Adhesive Cement No. P-1 (Powder). It is mixed with water to obtain the proper consistency when the cement is used. It has the same characteristics as No. 1 (Paste).

Physical properties were determined on specimens prepared under laboratory conditions using applicable ASTM procedures. Actual field conditions may vary and yield different results; therefore, data are subject to reasonable deviation. Data should not be used for specification purposes.

SAUEREISEN

CEMENTS *Company*

... since 1899