

Permabond 240 (previously Permabond C4) has been specifically developed to provide a slower cure than most cyanoacrylates. This allows time for accurate alignment of parts or to enable the assembly of somewhat larger components. In addition, its high viscosity makes it particularly suitable for use on foamed rubber or semi-porous materials, such as leather and wood.

Physical Properties

Chemical Type	Ethyl cyanoacrylate
Colour	Colourless
Viscosity	2200 mPa.s
Density	1.05

Typical Performance

Gap Fill		0.375mm
Handling Time [†]	Rubber	15 seconds
	Plastic	30 seconds
	Metal	55 seconds
Full Strength		24 hours
Tensile Strength	ASTM D-2095	25 MPa (steel)
Service Temperature *		-30 to +85°C

[†]Handling times can be affected by temperature, humidity and specific surfaces being bonded. Larger gaps or acidic surfaces will also reduce cure speed but this can be overcome by the use of Permabond C Surface Activator (CSA).

*Higher temperatures may be endured for short periods providing the parts are not unduly stressed.

Surface Preparation

Surfaces should be clean, dry and grease-free before applying the adhesive. Permabond Cleaner A is recommended for the degreasing of most surfaces. Some metals such as aluminium, copper and its alloys will benefit from light abrasion with emery cloth (or similar), to remove the oxide layer.

Adhesive Application

- Apply the adhesive sparingly to one surface (usually 1 drop is sufficient). Bring the components together quickly and correctly aligned.
- Apply sufficient pressure to ensure the adhesive spreads into a thin film.
- Do not disturb or re-align until curing is achieved, normally in a few seconds.
- Any surplus adhesive can be removed with Permabond Cleaner A.

NB:

- For difficult or porous surfaces, Permabond CSA activator is recommended.
- If bonding polypropylene, polyethylene, PTFE or silicone, prime first with Permabond Polyolefin Primer.

Storage and Handling

Storage Temperature	5 to 7°C
Shelf Life Stored in original unopened containers	12 months

Users are reminded that all materials, whether innocuous or not, should be handled in accordance with the principles of good industrial hygiene. Full information can be obtained from the Material Safety Data Sheet.

Contact Permabond:

Europe: Tel. +44 (0)1962 711661
UK Helpline: 0800 975 9800
Deutschland: 0800 10 13 177
France: 0805 11 13 88
info.europe@permabond.com

US: Tel. 00 1 732-868-1372
Helpline: 800-640-7599
info.americas@permabond.com
Asia: Tel. 00 886 939 49 3310
info.asia@permabond.com

www.permabond.com

The information given and the recommendations made herein are based on our experience and are believed to be accurate. No guarantee as to, or responsibility for, their accuracy can be given or accepted, however, and no statement herein is to be treated as a representation or warranty. In every case we urge and recommend that purchasers, before using any product, make their own tests to determine, to their own satisfaction, its suitability for their particular purposes under their own operating conditions.