Features & Benefits

- Extremely fast setting
- Rapid development of high strength
- Ease of use – no mixing or heat cure
- Surface insensitive
- 100% reactive, no solvents

Description

PERMABOND® 798 is a high viscosity cyanoacrylate adhesive that combines fast cure with the ability to cure through a large gap. Plastics, metals, ceramics and can be bonded rapidly. The fast cure minimizes the occurrence of frosting and fogging. This adhesive is particularly well-suited for used on porous substrates, since it fixtures before wicking into the surface pores.

Cyanoacrylate adhesives are single component adhesives that polymerize rapidly when pressed into a thin film between parts. The moisture adsorbed on the surface initiates the curing of the adhesive. Strong bonds are developed extremely fast and on a great variety of materials. These properties make PERMABOND® cyanoacrylates the ideal adhesives for high speed production lines.

Physical Properties of Uncured Adhesive

<table>
<thead>
<tr>
<th>Chemical composition</th>
<th>Ethyl cyanoacrylate</th>
</tr>
</thead>
<tbody>
<tr>
<td>Appearance</td>
<td>Colourless</td>
</tr>
<tr>
<td>Viscosity @ 25°C</td>
<td>2000 mPa.s (cP)</td>
</tr>
<tr>
<td>Specific gravity</td>
<td>1.1</td>
</tr>
</tbody>
</table>

Typical Curing Properties

| Maximum gap fill     | 0.43 mm 0.017 in  |
| Cure speed*          | 6 seconds (Steel) |
|                      | 6 seconds (Buna N Rubber) |
|                      | 6 seconds (Phenolic)   |
| Full strength        | 24 hours              |

Typical Performance of Cured Adhesive

- Shear strength* ASTM D-1002 Steel 20-22 N/mm² (2900-3200 psi)
- Coefficient of thermal expansion 90 x 10⁻⁶ mm/mm/°C
- Coefficient of thermal conductivity 0.1 W/(m.K)
- Hardness 85 Shore D

*Strength results will vary depending on the level of surface preparation and gap.

SF = Substrate failure

Temperature Resistance

798 can withstand higher temperatures for brief periods (such as for paint baking and wave soldering processes) providing the joint is not unduly stressed. The minimum temperature the cured adhesive can be exposed to is -55°C (-65°F) depending on the materials being bonded.

The information given and the recommendations made herein are based on our research and are believed to be accurate but no guarantee of their accuracy is made. In every case we urge and recommend that purchasers before using any product in full-scale production make their own tests to determine to their own satisfaction whether the product is of acceptable quality and is suitable for their particular purpose under their own operating conditions. THE PRODUCTS DISCLOSED HEREIN ARE SOLD WITHOUT ANY WARRANTY AS TO MERCHANTABILITY OR FITNESS FOR A PARTICULAR PURPOSE OR ANY OTHER WARRANTY, EXPRESS OR IMPLIED.

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**Chemical Resistance**

Specimens were immersed for 1000 hours at 22°C (unless otherwise stated)

**Surface Preparation**

Surfaces should be clean, dry and grease-free before applying the adhesive. Use a suitable solvent (such as acetone or isopropanol) for the degreasing of 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.

**Directions for Use**

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

**Additional Information**

This product is not recommended for use in contact with strong oxidizing materials and polar solvents although will withstand a solvent wash without any bond strength deterioration. 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.

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**NB:**
For difficult or porous surfaces using a Permabond activator is recommended. If bonding polypropylene, polyethylene, PTFE or silicone, prime first with Permabond Polyolefin Primer.

**Storage & Handling**

<table>
<thead>
<tr>
<th>Storage Temperature</th>
<th>2 to 7°C (35 to 45°F)</th>
</tr>
</thead>
<tbody>
<tr>
<td>Shelf Life</td>
<td>Stored in original unopened containers</td>
</tr>
<tr>
<td></td>
<td>12 months</td>
</tr>
</tbody>
</table>

Allow adhesive to reach room temperature before opening bottle to prevent condensation inside the bottle which can reduce shelf life.