

Permabond 268 Cyanoacrylate, General purpose

Category : Polymer , Adhesive , Thermoset , Acrylic/Cyanoacrylate Adhesive

Material Notes:

PERMABOND® 268 is a medium-high viscosity cyanoacrylate for large gap fill applications. Permabond® 268 provides faster set times and improved gap-filling capability compared to conventional cyanoacrylates. The adhesive bonds to a wide range of substrates including metals, ceramics, plastics and elastomers. It is excellent for bonding difficult-to-bond plastics such as polyacetals. It can also be used on passivated metal surfaces. Features & Benefits: Versatile and general purpose Good gap fill ability Instant setting Information provided by Permabond.

Order this product through the following link:

http://www.lookpolymers.com/polymer_Permabond-268-Cyanoacrylate-General-purpose.php

Physical Properties	Metric	English	Comments
Specific Gravity	1.10 g/cc	1.10 g/cc	Uncured
Viscosity	1200 - 2400 cP	1200 - 2400 cP	Uncured
	@Temperature 25.0 °C	@Temperature 77.0 °F	
Storage Temperature	2.00 - 7.00 °C	35.6 - 44.6 °F	

Mechanical Properties	Metric	English	Comments
Hardness, Shore D	85	85	ISO 868
Adhesive Bond Strength	20.0 - 22.0 MPa	2900 - 3190 psi	Steel, Shear; ISO 4587
Impact	3.0 - 5.0	3.0 - 5.0	kJ/m^2 Adhesive Impact Strength; ASTM D950

Thermal Properties	Metric	English	Comments
CTE, linear	90.0 $\mu\text{m/m} \cdot ^\circ\text{C}$	50.0 $\mu\text{in/in} \cdot ^\circ\text{F}$	
Thermal Conductivity	0.100 W/m-K	0.694 BTU-in/hr-ft ² -°F	
Maximum Service Temperature, Air	82.2 °C	180 °F	
Minimum Service Temperature, Air	-62.2 °C	-80.0 °F	

Processing Properties	Metric	English	Comments
Cure Time	0.0833 - 0.167 min	0.00139 - 0.00278 hour	Steel, handling time
	0.0833 - 0.167 min	0.00139 - 0.00278 hour	Buna N Rubber, handling time
	0.0833 - 0.167 min	0.00139 - 0.00278 hour	Phenolic, handling time
	1440 min	24.0 hour	full strength

Processing Properties	Metric	English	Comments
Descriptive Properties		Value	Comments
Appearance		Colorless	Uncured
Maximum Gap Fill (mm)		0.43	
Strength Retention		10% at 150°C	Relative to 0°C
		100% at 0°C	Relative to 0°C
		30% at 100°C	Relative to 0°C
		55% at -50°C	Relative to 0°C
		90% at 50°C	Relative to 0°C

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