

## Permabond 791 Cyanoacrylate, Surface insensitive

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

### Material Notes:

PERMABOND® 791 is a low viscosity, surface insensitive adhesive that will rapidly bond substrates with acidic surfaces such as wood and plated surfaces. Plastics, metals, ceramics and elastomers are also rapidly bonded. The fast cure minimizes the occurrence of frosting and fogging. 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. Features & Benefits: Extremely fast setting Rapid development of high strength Ease of use – no mixing or heat cure Surface insensitive 100% reactive, no solvents Information provided by Permabond.

Order this product through the following link:

[http://www.lookpolymers.com/polymer\\_Permabond-791-Cyanoacrylate-Surface-insensitive.php](http://www.lookpolymers.com/polymer_Permabond-791-Cyanoacrylate-Surface-insensitive.php)

Physical Properties	Metric	English	Comments
Specific Gravity	1.10 g/cc	1.10 g/cc	Uncured
Viscosity	30 - 50 cP @Temperature 25.0 °C	30 - 50 cP @Temperature 77.0 °F	Uncured
Storage Temperature	2.00 - 7.00 °C	35.6 - 44.6 °F	

Mechanical Properties	Metric	English	Comments
Hardness, Shore D	85	85	ISO 868
Tensile Strength	>= 20.0 MPa	>= 2900 psi	ISO 6922
Adhesive Bond Strength	18.0 - 22.0 MPa	2610 - 3190 psi	ISO 4587, Shear

Thermal Properties	Metric	English	Comments
CTE, linear	90.0 µm/m-°C	50.0 µin/in-°F	
Thermal Conductivity	0.100 W/m-K	0.694 BTU-in/hr-ft <sup>2</sup> -°F	
Maximum Service Temperature, Air	82.2 °C	180 °F	
Minimum Service Temperature, Air	-62.2 °C	-80.0 °F	

Electrical Properties	Metric	English	Comments
Dielectric Strength	25.0 kV/mm	635 kV/in	

Processing Properties	Metric	English	Comments
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Processing Properties	Metric - 0.0500 min	English - 0.000556 - 0.000833 hour	Comments
	0.0333 - 0.0500 min	0.000556 - 0.000833 hour	Buna N Rubber, handling time
	0.0333 - 0.0500 min	0.000556 - 0.000833 hour	Phenolic, handling time
	1440 min	24.0 hour	full strength

Descriptive Properties	Value	Comments
Appearance	Colorless	Uncured
Maximum Gap Fill (mm)	0.1	
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

## Contact Songhan Plastic Technology Co.,Ltd.

Website : [www.lookpolymers.com](http://www.lookpolymers.com)

Email : [sales@lookpolymers.com](mailto:sales@lookpolymers.com)

Tel : +86 021-51131842

Mobile : +86 13061808058

Skype : lookpolymers

Address : United North Road 215,Fengxian District, Shanghai City,China