

Permabond 910FS Cyanoacrylate, Methyl grade

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

Material Notes:

PERMABOND® 910FS is the original 100%-methyl cyanoacrylate adhesive. It is a single part, low viscosity liquid that will cure rapidly at room temperature when pressed into a thin film between parts. PERMABOND® 910FS will cure to a fixture strength in 5 seconds on most surfaces and strength develops rapidly. The adhesive was designed specifically for the bonding of metal surfaces, and provides excellent bond strength to steel, aluminum and most metal surfaces. The methyl cyanoacrylate will also adhere well to a wide variety of other materials including most plastics and rubbers. Features & Benefits: Excellent adhesion to metal surfaces Fast cure Easy to apply and dispense No mixing required Information provided by Permabond.

Order this product through the following link:

http://www.lookpolymers.com/polymer_Permabond-910FS-Cyanoacrylate-Methyl-grade.php

Physical Properties	Metric	English	Comments
Specific Gravity	1.10 g/cc	1.10 g/cc	Uncured
Viscosity	2.0 - 4.0 cP	2.0 - 4.0 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	>= 2.00 MPa	>= 290 psi	Butyl Rubber, Substrate Failure, Shear; ISO 4587
	>= 4.00 MPa	>= 580 psi	Nitrile Rubber, Substrate Failure, Shear; ISO 4587
	>= 9.00 MPa	>= 1310 psi	Phenolic, Substrate Failure, Shear; ISO 4587
	>= 9.00 MPa	>= 1310 psi	ABS, Substrate Failure, Shear; ISO 4587
	>= 14.0 MPa	>= 2030 psi	Acrylic, Shear; ISO 4587
	13.0 - 15.0 MPa	1890 - 2180 psi	Aluminum, Shear; ISO 4587
	21.0 MPa	3050 psi	Brass, Shear; ISO 4587
21.0 MPa	3050 psi	Stainless Steel, Shear; ISO 4587	
23.0 - 29.0 MPa	3340 - 4210 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 $\mu\text{m}/\text{m}\cdot^\circ\text{C}$	50.0 $\mu\text{in}/\text{in}\cdot^\circ\text{F}$	
Thermal Conductivity	0.100 W/m-K	0.694 BTU-in/hr-ft ² -°F	

Electrical Properties	Metric	English	Comments
Dielectric Constant	2.5	2.5	
	@Frequency 10000 Hz	@Frequency 10000 Hz	
Dielectric Strength	25.0 kV/mm	635 kV/in	

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

Descriptive Properties	Value	Comments
Appearance	Colorless	Uncured
Maximum Gap Fill (mm)	0.05	
Strength Retention	100% at 0°C	Relative to 0°C
	15% at 150°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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