

### CYANOACRYLATE

Permagold cyanoacrylate adhesives bring a wide variety of performance benefits to the production environment. These benefits include joining dissimilar and hard-to-bond materials, quick curing with very strong adhesion and a wide range of viscosities. Permagold one-part cyanoacrylates are a versatile solution for even the most demanding manufacturing and assembly applications.

#### Benefit

- One-part adhesive chemistry speeds application.
- Join dissimilar materials, such as rubber to metal, with no compromise in bond strength.
- Cures in seconds at room temperature; eliminates need for costly jigs or ovens; accelerates assembly rates.
- Gap fill up to 0.5mm (.02 in.)
- Solvent free; non flammable.
- Superior bond strength; often exceeds that of substrate material.
- High-temperature resistance of up to 250°C (480°F)
- Non-blooming, low odour, improves worker comfort.



Grade	Description	Viscosity mPa.s = cP	Maximum Gap Fill (mm) in	Shear Strength Steel (N/mm <sup>2</sup> ) psi	Set Time Steel in secs	Service Temperature (°C) °F
101	Low viscosity, penetrating grade	2-3	(0.05) 0.002	(19-23) 2800-3300	3-5	(-55 to +80) -65 to +180
102	General purpose	70-90	(0.15) 0.006	(19-23) 2800-3300	10-15	(-55 to +80) -65 to +180
105	Difficult rubbers (e.g. EPDM)	30-50	(0.10) 0.004	(18-22) 2600-3200	10-15	(-55 to +80) -65 to +180
108	Intermediate gap fill, plastic bonding	400-600	(0.20) 0.008	(20-22) 2900-3200	10-15	(-55 to +80) -65 to +180
170	Metal bonding, maximum gap fill	1000-2000	(0.38) 0.015	(23-25) 3300-3600	15-20	(-55 to +90) -65 to +195
240	High viscosity, slow cure	1200-2500	(0.43) 0.017	(21-25) 3000-3600	15-20	(-55 to +80) -65 to +180
268	Fast curing, intermediate gap fill	1200-2400	(0.43) 0.017	(20-22) 2900-3200	10-15	(-55 to +80) -65 to +180
731	Toughened	100-200	(0.15) 0.006	(24-30) 3500-4400	30-50	(-55 to +120) -65 to +250
735	Toughened, black	100-200	(0.15) 0.006	(24-30) 3500-4400	30-50	(-55 to +120) -65 to +250
737	Toughened, black, max. gap fill	2000-4000	(0.50) 0.020	(19-23) 2800-3300	25-30	(-55 to +120) -65 to +250
741	<b>FLEXIBLE</b> - fast setting, elongation 125%	2-3	(0.05) 0.002	(6-8) 870-1200	1-5	(-55 to +80) -65 to +180
743	<b>FLEXIBLE</b> - high elongation 400%	2-3	(0.05) 0.002	(0.5-1.5) 70-200	1-5	(-55 to +80) -65 to +180
743HT	<b>FLEXIBLE</b> - high elongation 350%, thixotropic	Thixo	(0.30) 0.012	(1-2) 145-290	2-5	(-55 to +80) -65 to +180
748	<b>FLEXIBLE</b> - elongation 65%	Gel	(0.50) 0.020	(8-12) 1200-1700	2-5	(-55 to +80) -65 to +180
790	Ultra fast cure, wicking type	1-3	(0.05) 0.002	(18-22) 2600-3200	2-3	(-55 to +80) -65 to +180
791	Ultra fast cure, low viscosity	30-50	(0.10) 0.004	(18-22) 2600-3200	2-3	(-55 to +80) -65 to +180
792	Ultra fast cure, general purpose	60-125	(0.15) 0.006	(18-22) 2600-3200	2-3	(-55 to +120) -65 to +250
795	Ultra fast cure, general purpose	400-600	(0.18) 0.007	(18-22) 2600-3200	3-5	(-55 to +80) -65 to +180
799	Ultra fast cure, maximum gap fill	4000-6000	(0.50) 0.020	(20-22) 2900-3200	5-10	(-55 to +80) -65 to +180
801	High temperature resistance	10-15	(0.05) 0.002	(19-23) 2800-3300	10-15	(-55 to +130) -65 to +270
802	High temperature resistance	90-110	(0.15) 0.006	(19-23) 2800-3300	10-15	(-55 to +160) -65 to +320
820	High temperature resistance	90-110	(0.15) 0.006	(19-23) 2800-3300	10-15	(-55 to +200) -65 to +390
910 <sup>®</sup>	Metal bonding	70-90	(0.15) 0.006	(23-29) 3300-4200	5-10	(-55 to +90) -65 to +195
910FS	Metal Bonding, wicking type	2-4	(0.05) 0.002	(23-29) 3300-4200	3-5	(-55 to +90) -65 to +195
919*	High temp. resistance, wicking	2-6	(0.05) 0.002	(20-22) 2900-3200	10-15	(-55 to +250) -65 to +480
920*	High temp. resistance	70-90	(0.15) 0.006	(19-23) 2800-3300	10-15	(-55 to +250) -65 to +480
922*	High temp. resistance, max gap fill	1200-2000	(0.43) 0.017	(19-23) 2800-3300	10-15	(-55 to +250) -65 to +480
940	Low odour, low bloom	3-10	(0.05) 0.002	(16-20) 2300-2900	10-15	(-55 to +80) -65 to +180
941	Low odour, low bloom	10-20	(0.08) 0.003	(16-20) 2300-2900	10-15	(-55 to +80) -65 to +180
943	Low odour, low bloom	90-110	(0.15) 0.006	(16-20) 2300-2900	10-15	(-55 to +80) -65 to +180
947	Low odour, low bloom	900-1500	(0.25) 0.010	(16-20) 2300-2900	20-30	(-55 to +80) -65 to +180
2010	Very fast cure, thixotropic	10,000-20,000	(0.50) 0.020	(19-23) 2800-3300	10-15	(-55 to +80) -65 to +180
2011	Non-drip, non sag gel	Gel	(0.50) 0.020	(20-24) 2900-3500	5-10	(-55 to +120) -65 to +250