

Permabond 101 Cyanoacrylate, Wicking Viscosity

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

Material Notes:

PERMABOND® 101 is a low viscosity product useful in wicking or penetrating applications or bonding closely fitting parts. It is fast setting and suitable for use on plastics, rubber and metals. 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: Ultra-low viscosity Suitable for bonding pre-assembled parts Ideal for close-fitting plastic components Information provided by Permabond.

Order this product through the following link:

http://www.lookpolymers.com/polymer_Permabond-101-Cyanoacrylate-Wicking-Viscosity.php

Physical Properties	Metric	English	Comments
Specific Gravity	1.10 g/cc	1.10 g/cc	Uncured
Viscosity	2.0 - 3.0 cP	2.0 - 3.0 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	>= 5.00 MPa	>= 725 psi	PC, Substrate Failure, Shear; ISO 4587
	>= 6.00 MPa	>= 870 psi	ABS, Substrate Failure, Shear; ISO 4587
	>= 6.00 MPa	>= 870 psi	PVC, Substrate Failure, Shear; ISO 4587
	7.00 - 9.00 MPa	1020 - 1310 psi	Aluminum, Shear; ISO 4587
	8.00 - 10.0 MPa	1160 - 1450 psi	Zinc, Shear; ISO 4587
	12.0 - 14.0 MPa	1740 - 2030 psi	Phenolic, Shear; ISO 4587
	19.0 - 23.0 MPa	2760 - 3340 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 $\mu\text{m/m}^\circ\text{C}$	50.0 $\mu\text{in/in}^\circ\text{F}$	

Thermal Properties	0.100 W/m-K Metric	0.694 BTU-in/hr-ft ² -°F English	Comments
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 Constant	2.5 @Frequency 10000 Hz	2.5 @Frequency 10000 Hz	
Dielectric Strength	25.0 kV/mm	635 kV/in	

Processing Properties	Metric	English	Comments
Cure Time	0.0333 - 0.0833 min	0.000556 - 0.00139 hour	Buna N Rubber, handling time
	0.0500 - 0.0833 min	0.000833 - 0.00139 hour	Steel, handling time
	0.0833 - 0.167 min	0.00139 - 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	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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