

Permabond 820 Cyanoacrylate, High Temperature

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

Material Notes:

PERMABOND® 820 is a low viscosity modified ethyl cyanoacrylate suitable for applications where high temperature resistance is required. This material is fast setting and has good adhesion to rubber, metal and plastics. 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: High temperature resistance Rapid curing Ease of use – no mixing or heat cure 100% reactive, no solvents ISO10993 cytotoxicity approval Information provided by Permabond.

Order this product through the following link:

http://www.lookpolymers.com/polymer_Permabond-820-Cyanoacrylate-High-Temperature.php

Physical Properties	Metric	English	Comments
Specific Gravity	1.10 g/cc	1.10 g/cc	Uncured
Viscosity	90 - 110 cP @Temperature 25.0 °C	90 - 110 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
Adhesive Bond Strength	19.0 - 23.0 MPa	2760 - 3340 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-ft²-°F	
Maximum Service Temperature, Air	199 °C	390 °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
Cure Time	0.167 - 0.250 min	0.00278 - 0.00417 hour	Steel, handling time
	0.167 - 0.250 min	0.00278 - 0.00417 hour	Buna N Rubber, handling time

Processing Properties	Metric 0.250 min	English ¹ - 0.00417 hour	Comments handling time
	1440 min	24.0 hour	

Descriptive Properties	Value	Comments
Appearance	Colorless	Uncured
Maximum Gap Fill (mm)	0.15	
Strength Retention	100% at 0°C	Relative to 0°C
	15% at 200°C	Relative to 0°C
	30% at 150°C	Relative to 0°C
	75% at -50°C	Relative to 0°C
	80% at 100°C	Relative to 0°C
	90% at 50°C	Relative to 0°C

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