

## Permabond 931 Cyanoacrylate

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

**Material Notes:**

PERMABOND 931 is a low odor, nonfogging, nonfreezing cyanoacrylate. The reduced odor improves worker comfort. Unusually fogging adjacent to bondlines, common with other cyanoacrylate adhesives on hot and humid days, is eliminated. The elimination of fogging improves the production rate of acceptable parts as well as their appearance. Features & Benefits: Low odor Eliminates whitening (freezing and fogging) of parts Excellent adhesion to a wide variety of surfaces Good flexibility and impact resistance Typical Applications: Black or dark plastic and metal surface fascia Where ventilation is limited or difficult Visible bondlines on appliances or cabinets Nameplates Soluble in Nitroethane, Methyl Ethyl Ketone, Acetone. Information provided by Permabond.

Order this product through the following link:

[http://www.lookpolymers.com/polymer\\_Permabond-931-Cyanoacrylate.php](http://www.lookpolymers.com/polymer_Permabond-931-Cyanoacrylate.php)

Physical Properties	Metric	English	Comments
Specific Gravity	1.05 g/cc	1.05 g/cc	Uncured
Viscosity	40 cP	40 cP	Uncured
	@Temperature 25.0 °C	@Temperature 77.0 °F	
Storage Temperature	30 - 50 cP	30 - 50 cP	Uncured
	@Temperature 20.0 °C	@Temperature 68.0 °F	
Storage Temperature	2.00 - 7.00 °C	35.6 - 44.6 °F	

Mechanical Properties	Metric	English	Comments
Adhesive Bond Strength	0.690 MPa	100 psi	ABS, Substrate Failure, Shear; ASTM D1002
	1.38 MPa	200 psi	Polystyrene, Substrate Failure, Shear; ASTM D1002
	1.72 MPa	249 psi	Acrylic Substrate Failure, Shear; ASTM D1002
	2.10 MPa	305 psi	EPDM, Substrate Failure, Shear; ASTM D1002
	4.10 MPa	595 psi	PVC, Substrate Failure, Shear; ASTM D1002
	6.90 MPa	1000 psi	Aluminum, Shear; ASTM D1002
	18.6 MPa	2700 psi	Grit Blasted Steel, Shear; ASTM D1002

Thermal Properties	Metric	English	Comments
Maximum Service Temperature, Air	75.0 °C	167 °F	

Thermal Properties	75.0 °C Metric	167 °F English	Comments
Minimum Service Temperature, Air	-62.2 °C	-80.0 °F	
	-54.0 °C	-65.2 °F	
Flash Point	83.0 °C	181 °F	

Processing Properties	Metric	English	Comments
Cure Time	0.0833 - 0.167 min	0.00139 - 0.00278 hour	Steel, set time
	0.0833 - 0.167 min	0.00139 - 0.00278 hour	Buna N Rubber, set time
	0.167 - 0.333 min	0.00278 - 0.00556 hour	Phenolic, set time
	1440 min @Temperature 25.0 °C	24.0 hour @Temperature 77.0 °F	full strength
Shelf Life	12.0 Month	12.0 Month	

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

## Contact Songhan Plastic Technology Co.,Ltd.

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