

## Permabond 240 Cyanoacrylate, gap filling

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

### Material Notes:

PERMABOND® 240 is a high viscosity product useful in large gap applications. It is ideal for porous substrates. 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: Rapid development of high strength Ease of use – no mixing or heat cure Bonds most materials 100% reactive, no solvents Information provided by Permabond.

Order this product through the following link:

[http://www.lookpolymers.com/polymer\\_Permabond-240-Cyanoacrylate-gap-filling.php](http://www.lookpolymers.com/polymer_Permabond-240-Cyanoacrylate-gap-filling.php)

| Physical Properties | Metric                                 | English                                | Comments |
|---------------------|----------------------------------------|----------------------------------------|----------|
| Specific Gravity    | 1.10 g/cc                              | 1.10 g/cc                              | Uncured  |
| Viscosity           | 1200 - 2500 cP<br>@Temperature 25.0 °C | 1200 - 2500 cP<br>@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 | >= 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             |
|                        | 8.00 - 9.00 MPa | 1160 - 1310 psi | Aluminum, Shear; ISO 4587                           |
|                        | 10.0 MPa        | 1450 psi        | Zinc, Shear; ISO 4587                               |
|                        | 14.0 MPa        | 2030 psi        | Phenolic, Shear; ISO 4587                           |
|                        | 21.0 - 25.0 MPa | 3050 - 3630 psi | Steel, Shear; ISO 4587                              |
| Impact                 | 3.0 - 5.0       | 3.0 - 5.0       | $\text{kJ/m}^2$ 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 Conductivity<br>Thermal Properties | 0.100 W/m-K<br>Metric | 0.694 BTU-in/hr-ft <sup>2</sup> -°F<br>English | Comments |
|--------------------------------------------|-----------------------|------------------------------------------------|----------|
|--------------------------------------------|-----------------------|------------------------------------------------|----------|

| 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             | 0.250 - 0.333 min | 0.00417 - 0.00556 hour | Steel, handling time         |
|                       | 0.250 - 0.333 min | 0.00417 - 0.00556 hour | Buna N Rubber, handling time |
|                       | 0.250 - 0.333 min | 0.00417 - 0.00556 hour | Phenolic, handling time      |
|                       | 1440 min          | 24.0 hour              | full strength                |

| Descriptive Properties | Value        | Comments        |
|------------------------|--------------|-----------------|
| Appearance             | Colorless    | Uncured         |
| Maximum Gap Fill (mm)  | 0.4          |                 |
| 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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