

Permabond 737 Cyanoacrylate, toughened

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

Material Notes:

PERMABOND® 737 is a toughened cyanoacrylate with improved impact and peel strength for maximum flexibility. Its increased temperature resistance and dark color make 737 suitable for a wide range of applications. It bonds rapidly to a variety of surfaces including aluminum, steel (both zinc-plated and uncoated), plastics and rubbers. Features & Benefits: Good gap fill (up to 0.5mm / 0.02") Toughened and flexible Ease of use – no mixing or heat cure Black - so suitable for dark surfaces 100% reactive, no solvents Information provided by Permabond.

Order this product through the following link:

http://www.lookpolymers.com/polymer_Permabond-737-Cyanoacrylate-toughened.php

Physical Properties	Metric	English	Comments
Specific Gravity	1.10 g/cc	1.10 g/cc	Uncured
Viscosity	2000 - 4000 cP	2000 - 4000 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
Tensile Strength	25.0 MPa	3630 psi	ISO 6922
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
	13.0 - 15.0 MPa	1890 - 2180 psi	Aluminum, Shear; ISO 4587
	19.0 - 23.0 MPa	2760 - 3340 psi	Steel, Shear; ISO 4587
Impact	5.0 - 10	5.0 - 10	kJ/m ² Adhesive Impact Strength; ASTM D950
Peel Strength	1.60 - 2.40 kN/m	9.13 - 13.7 pli	ASTM D903

Thermal Properties	Metric	English	Comments
CTE, linear	90.0 µm/m-°C	50.0 µin/in-°F	
Thermal Conductivity	0.200 W/m-K	1.39 BTU-in/hr-ft²-°F	

Maximum Service Temperature, Air Thermal Properties	116 °C Metric	240 °F English	Comments
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	0.0833 - 0.167 min	0.00139 - 0.00278 hour	Phenolic, handling time
	0.167 - 0.250 min	0.00278 - 0.00417 hour	Buna N Rubber, handling time
	0.250 - 0.333 min	0.00417 - 0.00556 hour	Steel, handling time
	0.500 - 0.583 min	0.00833 - 0.00972 hour	Aluminum, handling time
	1440 min	24.0 hour	full strength

Descriptive Properties	Value	Comments
Appearance	Black	Uncured
Maximum Gap Fill (mm)	0.5	
Strength Retention	10% at 150°C	Relative to 0°C
	100% at 0°C	Relative to 0°C
	50% at 100°C	Relative to 0°C
	75% at -50°C	Relative to 0°C
	90% at 50°C	Relative to 0°C

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