

Permabond 738 Cyanoacrylate, toughened

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

Material Notes:

PERMABOND 738 is a toughened cyanoacrylate with improved impact and peel strength when compared to a conventional cyanoacrylate. It bonds rapidly at room temperature and its viscosity is stable over the shelf life of the product. This provides consistent performance. The product adheres to a variety of surfaces including steel, aluminum, galvanized steel, plastics and elastomers. Features and Benefits: Provides better impact and peel strength Bonds in 20-30 seconds to most surfaces Color is suitable for matching dark surfaces Material is capable of curing through gaps as large as 0.020 inches Soluble In Nitroethane, Methyl Ethyl Ketone, Acetone. Information provided by Permabond.

Order this product through the following link:

http://www.lookpolymers.com/polymer_Permabond-738-Cyanoacrylate-toughened.php

Physical Properties	Metric	English	Comments
Specific Gravity	1.10 g/cc	1.10 g/cc	Uncured
Solids Content	100 %	100 %	
Viscosity	5000 cP @Temperature 25.0 °C	5000 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 A	85	85	
Adhesive Bond Strength	21.0 MPa	3050 psi	Grit-blasted Steel, Shear
Impact	16.8	16.8	kJ/m^2 Adhesive Impact Strength; ASTM D950
Peel Strength	2.28 kN/m	13.0 pli	ASTM D903

Thermal Properties	Metric	English	Comments
Maximum Service Temperature, Air	82.0 °C	180 °F	
Minimum Service Temperature, Air	-60.0 °C	-76.0 °F	
Flash Point	83.0 °C	181 °F	

Electrical Properties	Metric	English	Comments
Dielectric Strength	9.84 kV/mm	250 kV/in	

Processing Properties	Metric	English	Comments
Cure Time	0.0833 - 0.167 min	0.00139 - 0.00278 hour	Phenolic, set time, cured
	0.167 min	0.00278 hour	Steel, set time
	0.167 min	0.00278 hour	Buna N Rubber, set time
	0.167 min	0.00278 hour	Phenolic, set time
	0.167 - 0.250 min	0.00278 - 0.00417 hour	Buna Rubber, set time, cured
	0.417 - 0.500 min	0.00694 - 0.00833 hour	Steel, set time, cured
	0.500 - 0.583 min	0.00833 - 0.00972 hour	Aluminum, set time, cured
	1440 min	24.0 hour	
	@Temperature 25.0 °C	@Temperature 77.0 °F	
Shelf Life	6.00 Month	6.00 Month	

Descriptive Properties	Value	Comments
Appearance	Black	Uncured
Maximum Gap Fill (mm)	0.51	

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