

Permabond 947 Cyanoacrylate, low odor

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

Material Notes:

PERMABOND 947 is a low odor, non-fogging non-frosting alkoxyethyl cyanoacrylate. The reduced odor improves worker comfort. Unsightly 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. The adhesive is very stable and will provide optimum performance for one year when refrigerated. Features & Benefits: Low odor for improved worker comfort Non-frosting –good aesthetic appearance 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-947-Cyanoacrylate-low-odor.php

Physical Properties	Metric	English	Comments
Specific Gravity	1.10 g/cc	1.10 g/cc	Uncured
Viscosity	900 - 1500 cP	900 - 1500 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
Adhesive Bond Strength	4.00 MPa	580 psi	Phenolic, Shear; ISO 4587
	5.00 MPa	725 psi	PVC, Shear; ISO 4587
	>= 5.00 MPa	>= 725 psi	PC, Substrate Failure, Shear; ISO 4587
	>= 6.00 MPa	>= 870 psi	ABS, Substrate Failure, Shear; ISO 4587
	8.00 MPa	1160 psi	Zinc, Shear; ISO 4587
	8.00 - 9.00 MPa	1160 - 1310 psi	Aluminum, Shear; ISO 4587
	16.0 - 20.0 MPa	2320 - 2900 psi	Steel, Shear; ISO 4587
Impact	3.0 - 5.0	3.0 - 5.0	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	0.100 W/m-K	0.694 BTU-in/hr-ft ² -°F	

Maximum Service Temperature, Air Thermal Properties	82.2 °C Metric	180 °F English	Comments
Minimum Service Temperature, Air	-62.2 °C	-80.0 °F	

Electrical Properties	Metric	English	Comments
Dielectric Constant	3.0 @Frequency 1.00e+6 Hz	3.0 @Frequency 1.00e+6 Hz	
Dielectric Strength	25.0 kV/mm	635 kV/in	DIN 53481

Processing Properties	Metric	English	Comments
Cure Time	0.0333 - 0.0833 min	0.000556 - 0.00139 hour	Neoprene, handling time
	0.167 - 0.250 min	0.00278 - 0.00417 hour	Aluminum, handling time
	0.167 - 0.250 min	0.00278 - 0.00417 hour	PVC, handling time
	0.167 - 0.250 min	0.00278 - 0.00417 hour	Phenolic resin, handling time
	0.167 - 0.250 min	0.00278 - 0.00417 hour	ABS, handling time
	0.333 - 0.500 min	0.00556 - 0.00833 hour	Steel, handling time
	0.500 - 0.667 min	0.00833 - 0.0111 hour	Zinc, handling time
	1440 min	24.0 hour	full strength

Descriptive Properties	Value	Comments
Appearance	Colorless	Uncured
Maximum Gap Fill (mm)	0.25	
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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