

Permabond®

Flexible Cyanoacrylate

ISO 9001 Certified
"Our Science ... Your Success"

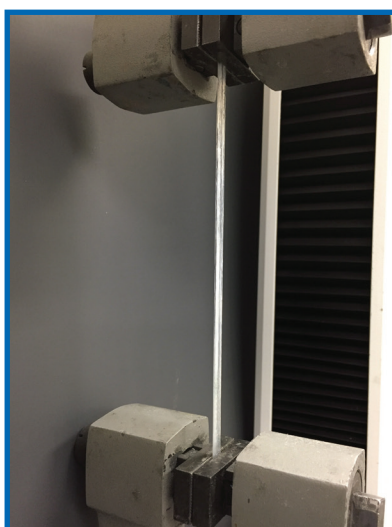
Permabond Flexible Cyanoacrylates are a new concept in the field of cyanoacrylate adhesives. They offer flexibility, high elongation, and softness while maintaining the set speed of standard cyanoacrylates.

In years past, toughened cyanoacrylates have been referred to as flexible because they were considerably more resilient than standard cyanoacrylates, which are hard and brittle.

These **NEW Flexible Cyanoacrylates** are truly FLEXIBLE!

Permabond® Flexible Cyanoacrylates Features & Benefits

- Highly flexible
- High elongation
- Fast setting
- Impact resistant
- Adhesion to a wide range of surfaces
- Solvent free



Above, a cured sample of Permabond 743 flexible cyanoacrylate is stretched to four times its original length!

The flexibility and elongation make Permabond Flexible Cyanoacrylates ideal for:

- Bonding a large variety of substrates
- Bonding dissimilar surfaces
- Bonding soft, porous, and flexible substrates
- Sealing
- Tamper-Proofing
- Threadlocking plastic fasteners



Permabond®
Engineering Adhesives

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The following product data for Permabond Flexible Cyanoacrylates is a guideline and does not constitute a specification. For more information please review the product's Technical Data Sheets.

Product		741	743	743HT	748
Key Feature		Fast setting	High elongation	High elongation / Thixo	High strength on metals
Viscosity		2-3 cP	2-3 cP	Thixotropic 2 rpm 10,000-20,000 cP 20 rpm 2,000-5,000 cP	Thixotropic Gel 2 rpm 30,000-50,000 cP 20 rpm 2,000-8,000 cP
Elongation		100 - 150%	300-500%	300-400%	50-80%
Shore Hardness		~D50	~A60	~A60	~D30
Fixture Time	ABS	2-5 secs	2-7 secs	5-10 secs	3-6 secs
	NBR Rubber	2-7 secs	2-7 secs	5-10 secs	2-5 secs
	Polycarbonate	10-20 secs	10-20 secs	10-20 secs	10-20 secs
	Silicone*	2-5 secs	2-5 secs	2-5 secs	2-5 secs
	Steel	1-5 secs	1-5 secs	2-5 secs	2-5 secs
Shear Strength	ABS	3-4 N/mm ² (435-580 psi)	1-2 N/mm ² (145-290 psi)	2-4 N/mm ² (290-580 psi)	2-4 N/mm ² (290-580 psi)
	Acrylic	3-4 N/mm ² (435-580 psi)	2-3 N/mm ² (290-435 psi)	1-2 N/mm ² (145-290 psi)	2-4 N/mm ² (290-580 psi)
	Polycarbonate	6-8 N/mm ² (870-1,200 psi)**SF	6-8 N/mm ² (870-1,200 psi)**SF	4-6 N/mm ² (580-870 psi)	5-7 N/mm ² (725-1,000 psi)
	Steel	6-8 N/mm ² (870-1200 psi)	0.5-1.5 N/mm ² (70-220 psi)	1-2 N/mm ² (145-290 psi)	8-12 N/mm ² (1,200-1,700 psi)

* Prime silicone with Permabond POP prior to bonding.

**SF = Substrate Failure

Non-Warranty: The information given and the recommendations made herein are based on our research and are believed to be accurate but no guarantee of their accuracy is made. In every case, we urge and recommend that purchasers, before using any product in full scale production, make their own tests to determine to their own satisfaction whether the product is of acceptable quality and is suitable for their particular purpose, under their own operating conditions. The products discussed herein are sold without any warranty, expressed or implied. No representative of ours has any authority to waive or change the foregoing provisions but, subject to such provisions, our engineers are available to assist purchasers in adapting our products to their needs and to circumstances prevailing in their business. Nothing contained herein shall be construed to imply the non-existence of any relevant patents or to constitute a permission inducement, or recommendations to practice any invention covered by any patent without authority from the owner of the patent. Purchasers of Permabond products are expected to follow the guiding principles of the Chemical Manufacturers Association's Responsible Care® program. Please refer the Technical Data Sheet for the most up to date information on each product. While every effort has been made to insure the accuracy of the information provided, Permabond cannot be held responsible for typographical errors.



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