

PERMABOND® 910FS

Methyl Cyanoacrylate

Permabond
Engineering Adhesives

Ref. #: 041509PB910FS

FEATURES & BENEFITS

Fast setting and fixturing of parts
Rapid development at high strength
Ease of uses in single part no mixing
Excellent adhesion to metal surface

TYPICAL APPLICATIONS

Metal bonding
Sensitive plastic parts
Name plates
Orings
Parts before riveting or welding

GENERAL DESCRIPTION

PERMABOND 910FS is the original 100% methyl cyanoacrylate adhesive. It is a single part, low viscosity liquid that will cure rapidly at room temperature when pressed into a thin film between parts. **PERMABOND 910FS** will cure to a fixture strength in 5 seconds on most surfaces, and rapidly develops high strength with full cure obtained in 4 hours. The adhesive was designed specifically for the bonding of metal surfaces, and provides excellent bond strength to steel, aluminum, and most metal surfaces. The methyl cyanoacrylate will also adhere well to a wide variety of other materials including most plastics and rubbers. **PERMABOND 910FS** has been formulated to be less aggressive to sensitive plastic surfaces such as Styrofoam, polycarbonate and ABS. The cured adhesive is an inert plastic that is resistant to most chemicals. The cured 910 adhesive will also have a greater resistance to high temperatures than most conventional ethyl cyanoacrylate adhesives.

PHYSICAL PROPERTIES OF THE UNCURED ADHESIVE

Chemical Type	Methyl
Color	Colorless
Viscosity, cP @ 25 C	3
Specific Gravity	1.09
Flash point, °C (°F)	83 (181)
Shelf Life stored at 2°C – 7°C (35°F – 45°F), months	12
Maximum gap fill; in (mm)	.002 (0.05)

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CURE RATE

The cure rates of cyanoacrylates are dependent on the substrate used, gap, and relative humidity. The table below shows the set time of various substrates. Cyanoacrylate adhesives have limited gap-filling capability. The speed of cure and the ultimate strength might decrease as the gap increases. The cure speed of cyanoacrylates will depend on the ambient relative humidity; the cure rate generally increases with increasing humidity. The cure rate of cyanoacrylates can be increased by applying activator QFS16. However, the application of the activator might decrease the ultimate strength of the bond.

CURE RATE at 25°C

Set time, seconds	
Steel	5
Buna N Rubber	10
Phenolic	10
Full cure, hours	24

PHYSICAL PROPERTIES OF THE CURED ADHESIVE

Hardness (Shore A)	85
Dielectric Strength (volts/mil), approx.	250
Operating Temperature, °C, (°F)	-54°(-65°) to 90°(195°)
Soluble In	Nitroethane, Methyl, Ethyl, Ketone, Acetone

TYPICAL PERFORMANCE OF THE CURED ADHESIVE

Cured at 25°C for 24 hours

Lap Shear Strength on (ASTM D1002)	
Steel, psi (N/mm ²)	3000 (21)
Aluminum, psi (N/mm ²)	2000 (14)
Brass	3000 (21)
Stainless Steel	3000 (21)
Butyl Rubber	300 (2.1)*
Nitrile Rubber	550 (3.8)*
ABS	1300 (9.0)*
Acrylic	2000 (14)
Phenolic	1400 (9.7)*
<u>Impact Strength (ASTM D950),</u> ft-lbs/in ²	5 - 8

CHEMICAL RESISTANCE

Cured **PERMABOND** adhesives have good resistance to many common solvents. However, the cured resistance is reduced as the polarity of the solvent increases. Non-polar solvents such as gasoline, motor oil, and dioctyl phthalate (**DOP**) have only a minimal effect but polar solvents cause severe bond deterioration. Alcohols will only deteriorate bonds over several months, but acetone is a good solvent for cyanoacrylate. Boiling water will destroy the bonds in less than 24 hours and this process is accelerated when the solution is alkaline. Amines tend to dissolve the bond rapidly. Most solvent washes will not affect the adhesive bonds due to the short exposure time.

THERMAL RESISTANCE

The cured cyanoacrylate is a thermoplastic material that softens at approximately 177°C (350°F), but it can safely be used at temperatures between -54°C (-65°F) and 90°C (195°F). Beyond this temperature, strength loss is relatively rapid. While the product may perform in certain situations, a general recommendation is not made for use above 90°C (195°F). All grades can resist short exposures up to 150°C (300°F).

SURFACE PREPARATION

The surface should be free of gross contamination such as dirt, dust, grease or oil. An alcohol wipe is suitable for cleaning most surfaces. Acetone is recommended for epoxies, polyesters, phenolics, melamine, urea formaldehyde, nylon and polyurethane. Optimum strength is obtained by abrading the surface followed by a solvent wipe to remove any loose particles.

APPLICATION

1. For best results the surface should be properly cleaned.
2. Apply the adhesive sparingly to one surface.
3. Assemble the parts making sure that they are correctly aligned.
4. Apply sufficient pressure to ensure that the adhesive spreads into a thin film.
5. Do not move parts until fixture strength is achieved.
6. When bonding polyethylene, polypropylene, PTFE or silicone, we recommend priming the surfaces with Permabond Polyolefin Primer before using the adhesive.

STORAGE & HANDLING

Cyanoacrylate adhesives are subject to an aging process and have a limited shelf life. When stored in the original unopened container in a refrigerator between 2°C and 7°C (35°F and 45°F), the shelf life is 12 months from the date of shipment from Permabond. It could be less when stored at ambient environment depending on conditions of temperature and humidity.

A note of caution: Before opening, the containers must be warmed to room temperature; otherwise water might condense into the bottle and cause hardening of the adhesive.

Avoid skin contact. Wear polyethylene gloves and safety glasses. Do not use rubber or cloth gloves. Cyanoacrylates can form strong bonds rapidly to skin. To break the bond, peel and flex the skin carefully. Immersion in soapy water aids in breaking the cyanoacrylate bond. Acetone or nail polish remover may also be used. If cyanoacrylate should come in contact with the eye, seek medical attention.

Cyanoacrylate vapors are lachrymatory and can irritate eyes and mucous membranes. Use these materials with proper ventilation.

VAPOR CONTROL RECOMMENDATIONS

1. Use adequate ventilation. Remove adhesive vapors with suitable exhaust ducting. Since cyanoacrylate vapors are heavier than air, place exhaust intake below work area. Activated charcoal filters using an acidic charcoal have been found effective in removing vapors from effluent air.
2. Avoid use of excess adhesive. Excess adhesive outside of the bond area will increase the level of vapors. Automatic dispensing equipment will prevent excess adhesive.
3. Assemble parts as quickly as possible. Long open times will increase level of vapors.

CLEAN UP OF SPILLED LIQUID

When large quantities of cyanoacrylate adhesives are accidentally spilled, the area should be flooded with water that will cause the liquid cyanoacrylate to cure. The cured material can then be scraped from the surface. **NOTE:** The liquid adhesive should not be wiped up with rags or tissue. The fabric will cause polymerization and large quantities of adhesive will generate heat on cure, causing smoke and strong irritating vapors. **ALWAYS FLOOD WITH EXCESS WATER TO CLEAN UP SPILL CONDITIONS.**

For additional information consult the Material Safety Data Sheet (MSDS).

FOR INDUSTRIAL USE ONLY. KEEP OUT OF REACH OF CHILDREN