

# PERMABOND<sup>®</sup> 738

**Toughened Cyanoacrylate**



Ref #: 010106PB738

## TYPICAL APPLICATIONS

Speaker Assembly  
Bonding to Black Substrates  
Black PVC Wire Bonding

## FEATURES & 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

## GENERAL DESCRIPTION

**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.

## PHYSICAL PROPERTIES OF THE UNCURED ADHESIVE

Properties	
Solids, %	100
Color <sup>(1)</sup>	Black
Viscosity, cP at 25°C	5000
Flash Point, °C (°F)	83(181)
Specific Gravity	1.1
Gap Filling, inches (mm)	0.020 (0.51)
Shelf Life stored at 2°C-7°C (35°F-45°F), months	6

(1) To obtain maximum opacity, the product should be refrigerated when not in use. Total time at room temperature is about 10 days before settling of the black additive occurs reducing black intensity. Shaking will not restore the original black intensity. Vigorously shaking will restore acceptable blackness for 1-2 days. This can be done a maximum of two times.

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 DISCLOSED HEREIN ARE SOLD WITHOUT ANY WARRANTY AS TO MERCHANTABILITY OR FITNESS FOR A PARTICULAR PURPOSE OR ANY OTHER WARRANTY, EXPRESS OR IMPLIED.

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## PERFORMANCE OF THE CURED ADHESIVE

<u>Set Time, Seconds</u>	
Steel	25-30
Aluminum	30-35
Phenolic	5-10
Buna Rubber	10-15
<u>Lap Shear Strength, psi</u>	
24 hours at room temperature)	
Grit blasted/Steel	3100
PVC/PVC (rigid)	Substrate Failure
Acrylic/Acrylic	Substrate Failure
Polycarbonate/Polycarbonate	Substrate Failure
<u>Peel Strength, pli</u>	
180° Peel (ASTM D903)	
Steel/Steel <sup>1</sup>	13.0
<sup>1</sup> ) Using sandblasted steel	
<u>Impact Resistance, ft-lb/in<sup>2</sup></u>	
(ASTM D950)	
Steel/Steel	8.0
<u>PVC Plasticizer Resistance</u>	
180° Peel Strength, pli (ASTM D903)	
aged 1 week at 70°C (158°F)	
Flexible PVC/Steel	Substrate Failure
T-Peel (ASTM D1876)	
aged 1 week at 70°C (158°F)	
Flexible PVC/PVC	Substrate Failure
Operating Temperature °C (°F)	-60 (-80) to 82 (180)

## 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 increase 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	10
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)	-60 (80°) to 82 (180°)
Soluble In	Nitroethane, Methyl, Ethyl, Ketone, Acetone

## 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 -60°C (-80°F) and 120°C (240°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 120°C (240°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 clean.
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.

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. The shelf life is six months when stored in a refrigerator. 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 eyes, 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 INDUSTRIAL USE ONLY. KEEP OUT OF REACH OF CHILDREN.**