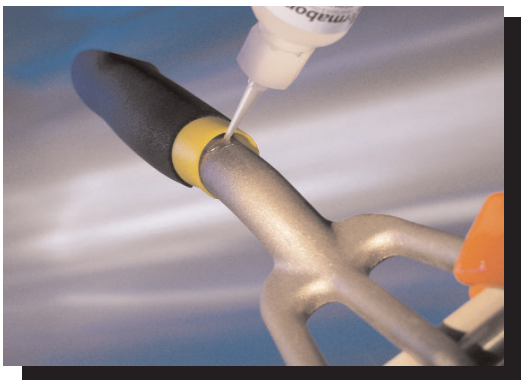
C920 Cyanoacrylate Adhesive

Permabond C920

Permabond C920 is the original allyl cyanoacrylate adhesive specifically designed to provide the high temperature resistance required by certain applications. It provides excellent bond strengths on most metal surfaces and to a wide variety of plastic and rubber materials. Whilst a room temperature cure will give better temperature resistance than other cyanoacrylates, maximum performance (up to 250°C) will be achieved by using a post cure at 150°C for 2 hours.



C920 is ideal for high temperature applications

- High temperature resistance
- Bonds well to plastics, rubbers and metals
- Solvent free
- Quick curing
- No mixing required

Summary:
Low viscosity
High strength
Temperature resistance

PHYSICAL PROPERTIES

Colour	**Colourless**
Viscosity	**100 mPa.s**
Chemical Type	**Allyl Cyanoacrylate**
Density	**1.05**

TYPICAL PROPERTIES

Handling Time	**10-30 seconds**
Full Strength	**4 hours**
Tensile Strength	**30 MPa**
Temperature Range	**-30 to +250°C**
Maximum Gap Fill	**0.125 mm**

This is a typical cure speed to be expected on most rubber and plastic surfaces. The handling times can be affected by temperature, humidity and specific surfaces being bonded. Larger gaps or acidic surfaces will also reduce cure speed but this can be overcome by the use of Permabond C Surface Conditioner (CSA).

Permabond®
Engineering Adhesives

TEMPERATURE RESISTANCE

Thermal resistance is excellent between -30 and 250°C. Heating causes the adhesive to soften but strength is regained on cooling, provided 250°C is not exceeded for prolonged periods.

Storage and Handling

When stored in the original unopened containers at 5-7°C, the shelf life of this product is 9 months from the date of despatch from Permabond.
Please also read the Material Safety Data Sheet. Users are reminded that all materials, whether innocous or not, should be handled according to the principles of good industrial hygiene.

Directions for use:

- Surfaces should be clean, dry and grease free prior to bonding. Abrading and degreasing the surface will give a much stronger bond. (MEK or similar solvent can be used to degrease surfaces.)
- Apply the adhesive sparingly to one surface (usually 1 drop is sufficient) bring the components together quickly and correctly aligned.
- Apply sufficient pressure to ensure the adhesive spreads into a thin film.
- Do not disturb or re-align until curing is achieved, normally in a few seconds.
- Any surplus adhesive can be removed with MEK (or similar solvent).
- For high temperature resistance; post-cure at 150°C for two hours
- For difficult or porous surfaces try using Permabond CSA activator. When bonding polypropylene, polyethylene, PTFE or silicone, we would recommend priming first with Permabond Polyolefin Primer

Other Products in the Permabond Range...

Cyanoacrylate adhesives...
General purpose
Low bloom / Low odour
High temperature resistance
Metal bonding
Flexible
Toughened

We also have a new polyolefin primer for pre-treating polypropylene, polyethylene, PTFE. For use with cyanoacrylate adhesive.

Anaerobic adhesives...
Threadlocking
Pipe-sealing
Retaining
High temperature resistance
Toughened
Variety of viscosities and strengths available

If you require help with an application, please contact the Permabond team for technical advice on surface preparation, joint design, adhesive selection and how to optimise your production process.

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