

### Features & Benefits

- Natural and synthetic rubber bonding
- Ideal for hard to bond plastics
- Ease of use – no mixing or heat cure
- Bonds most materials
- 100% reactive, no solvents

Approved to MIL-A-46050C Type II Class 1

### Description

**PERMABOND 105** is a low viscosity general purpose elastomer bonding product useful in wicking or penetrating applications or bonding closely fitting parts. It is fast setting and suitable for use on plastics, rubber and metals. Cyanoacrylate adhesives are single component adhesives that polymerize rapidly when pressed into a thin film between parts. The moisture adsorbed on the surface initiates the curing of the adhesive. Strong bonds are developed extremely fast and on a great variety of materials. These properties make **PERMABOND** cyanoacrylates the ideal adhesives for high speed production lines.

### Physical Properties of Uncured Adhesive

|                      |                     |
|----------------------|---------------------|
| Chemical composition | Ethyl cyanoacrylate |
| Appearance           | Colourless          |
| Viscosity @ 25°C     | 30-50 mPa.s (cP)    |
| Density              | 1.05                |

### Typical Curing Properties

|                  |  |
|------------------|--|
| Maximum gap fill | 0.1 mm <b>0.004 in</b>   |
| Cure speed*      | 10-15 seconds (Steel)<br>5-10 seconds (Buna N Rubber)<br>5-10 seconds (Phenolic)<br>5-10 seconds (PVC)<br>5-10 seconds (ABS) |
| Full strength    | 24 hours   |

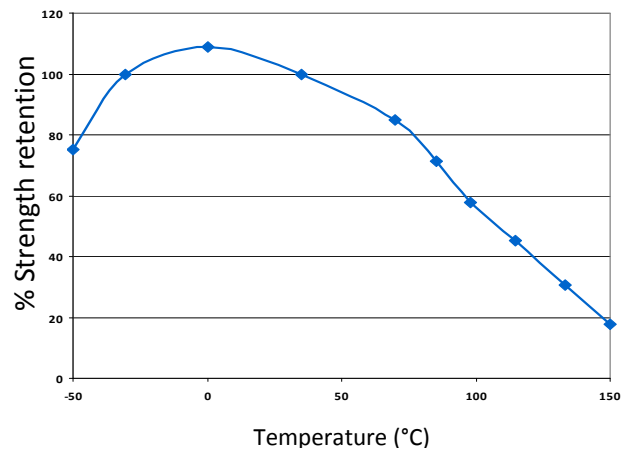
\*Handling times can be affected by temperature, humidity and specific surfaces being bonded. Larger gaps or acidic surfaces will also reduce cure speed but this can be overcome by the use of Permabond C Surface Activator (CSA) or Permabond QFS 16.

### Typical Performance of Cured Adhesive

|   |   |   |
|---|---|---|
| Shear strength*<br>ASTM D-1002            | Steel   | 18-22 N/mm <sup>2</sup> (2600-3200 psi) |
|   | Aluminium   | 6-8 N/mm <sup>2</sup> (900-1200 psi)    |
|   | Zinc  | 6-8 N/mm <sup>2</sup> (900-1200 psi)    |
|   | ABS   | >6 N/mm <sup>2</sup> (900psi) SF        |
|   | PVC   | >6 N/mm <sup>2</sup> (900psi) SF        |
|   | PC  | >5 N/mm <sup>2</sup> (700 psi) SF       |
|   | Phenolic  | 12-14N/mm <sup>2</sup> (1700-2000 psi)) |
| Impact Strength<br>(ASTM D-950)           | 6-14 kJ/m <sup>2</sup> (3-7 ft-lb/in <sup>2</sup> ) |   |
| Dielectric constant<br>@10kHz             | 2.5   |   |
| Coefficient of<br>thermal expansion       | 90 x 10 <sup>-6</sup> mm/mm/°C                      |   |
| Coefficient of<br>thermal<br>conductivity | 0.1 W/(m.K)   |   |

\*Strength results will vary depending on the level of surface preparation and gap.  
SF = Substrate failure

### Temperature Resistance



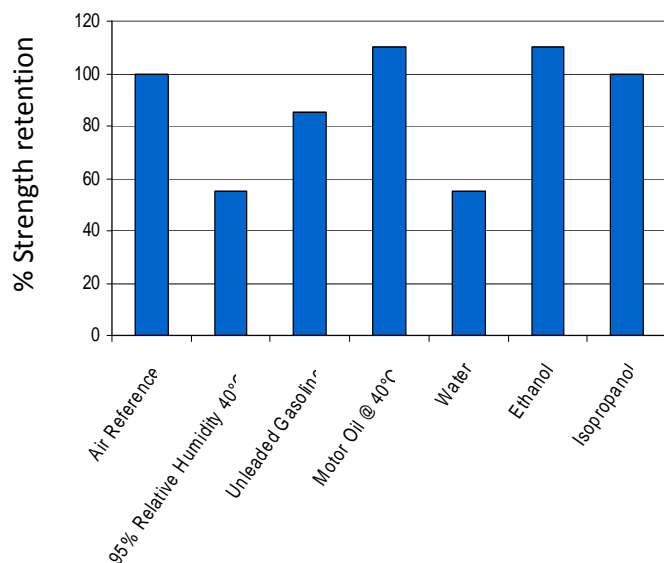
"Hot strength" shear strength tests performed on mild steel. 24hr cure at room temperature and conditioned to pull temperature for 30 minutes before testing.

105 can withstand higher temperatures for brief periods (such as for paint baking and wave soldering processes) providing the joint is not unduly stressed. The minimum temperature the cured adhesive can be exposed to is -55°C (-65°F) depending on the materials being bonded.

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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## Chemical Resistance



Specimens were immersed for 1000 hours at 22°C (unless otherwise stated)

## Additional Information

This product is not recommended for use in contact with strong oxidizing materials and polar solvents although will withstand a solvent wash without any bond strength deterioration. Users are reminded that all materials, whether innocuous or not, should be handled in accordance with the principles of good industrial hygiene. Full information can be obtained from the Material Safety Data Sheet.

## Surface Preparation

Surfaces should be clean, dry and grease-free before applying the adhesive. Use a suitable solvent (such as acetone or isopropanol) for the degreasing of surfaces. Some metals such as aluminium, copper and its alloys will benefit from light abrasion with emery cloth (or similar), to remove the oxide layer.

## Directions for Use

- 1) Apply the adhesive sparingly to one surface (usually 1 drop is sufficient).
- 2) Bring the components together quickly and correctly aligned.
- 3) Apply sufficient pressure to ensure the adhesive spreads into a thin film.
- 4) Do not disturb or re-align until curing is achieved, normally in a few seconds.
- 5) Any surplus adhesive can be removed with a suitable solvent.

### NB:

For difficult or porous surfaces using a Permabond activator is recommended.

If bonding polypropylene, polyethylene, PTFE or silicone, prime first with Permabond Polyolefin Primer.

## Storage & Handling

|  |                       |
|--|-----------------------|
| Storage Temperature                                  | 2 to 7°C (35 to 45°F) |
| Shelf Life<br>Stored in original unopened containers | 12 months             |

Allow adhesive to reach room temperature before opening bottle to prevent condensation inside the bottle which can reduce shelf life.

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