

Permabond 4C30

PROVISIONAL TECHNICAL INFORMATION SHEET

Permabond cyanoacrylates are single component adhesives which polymerize rapidly when pressed into a thin film between components. Strong bonds may be developed extremely fast making Permabond 4C30 an ideal choice for high-speed production lines for increased productivity. Permabond 4C30 is suitable for a wide range of applications on many of the plastic*, rubber and metal materials used in the medical device industry. The cured material passes USP Class VI and cytotoxicity requirements.

PHYSICAL PROPERTIES LIQUID ADHESIVE		PHYSICAL PROPERTIES CURED ADHESIVE	
Base Compound	Ethyl Cyanoacrylate	Appearance	Colourless
Appearance	Colourless transparent	Softening Point	150-170°C
Viscosity @25°C	1500 mPa.s (cPs)	Hardness, Shore D	85
Specific Gravity	1.05	Dielectric Strength	10,000 volts/mm (250 volts/mil)
Flash Point	82°C (181°F)	Service Temperature	-62 to +80°C
Shelf Life @2-4°C	6 months	Water Absorption	<2%
		Elongation	<5%
		USP Class VI	Pass
		Cytotoxicity	Pass

PERFORMANCE PROPERTIES		
Handling Time	Steel	15-50 seconds
	Nitrile Rubber	15-40 seconds
	Phenolic	15-40 seconds
Lap Shear Strength	Steel	14MPa (1800 psi)
	Aluminium	8MPa (1000 psi)
	Styrene	1MPa (150 psi) substrate failure
	PVC	3.6MPa (525 psi) substrate failure
Impact Strength		4 – 9.5 Nm (3-7 ft lb)

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.

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 the 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 recommendation to practice any invention covered by any patent, without authority from the owner of this patent. We also expect purchasers to use our products in accordance with the guiding principles of the Chemical Manufacturers Association's Responsible Care[®] program.

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<http://www.permabond.com>

DIRECTIONS FOR USE:

The surfaces should be clean and dry. Apply a small drop of the adhesive to one of the surfaces, join together and hold or clamp for 15-60 seconds. Do not disturb or realign the joint until the adhesive has reached handling strength. Temperature, humidity and specific surfaces being bonded can affect actual handling times.

HANDLING:

Cyanoacrylates will bond skin and eyes in seconds. Contact with skin and eyes should be avoided. Use in well ventilated area. Full information may be obtained from the Material Safety Data Sheet (MSDS)

STORAGE:

Between 2-4°C. Refrigerated product should be allowed to warm to room temperature before opening to prevent condensation causing premature hardening of the adhesive.

- This product is not generally suitable for use on polypropylene, polyethylene or silicone components unless they have been subjected to special surface treatments.