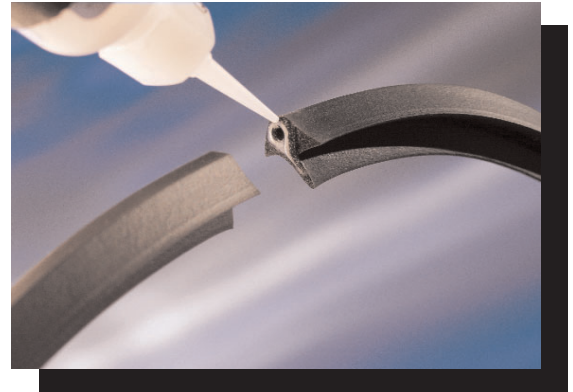


101 (C1) Cyanoacrylate Adhesive

Permabond 101 (previously Permabond C1) was developed primarily for the bonding of rubber material to enable the manufacture of 'O' rings, gaskets etc. where a rapid cure is required and bond areas are generally small. With a viscosity similar to water, it can also be applied after assembly of the components where parts need to be accurately aligned and/or adjusted prior to bonding.



101 is ideal for post-assembly application

- Single part room temperature curing
- Bonds well to plastics and rubbers
- Solvent free
- Quick curing
- No mixing required

Summary:
Very low viscosity
High strength
For plastics and rubber

PHYSICAL PROPERTIES

Colour	Colourless
Viscosity	2 mPa.s
Chemical Type	Ethyl Cyanoacrylate
Density	1.05

TYPICAL PROPERTIES

Handling Time	7-40 seconds
Full Strength	24 hours
Tensile Strength	20 MPa
Temperature Range	-30 to +85°C
Maximum Gap Fill	0.025 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).

TEMPERATURE RESISTANCE

Thermal resistance is excellent between -30 and 85°C. Heating causes the adhesive to soften but strength is regained on cooling, provided 85°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 12 months from the date of despatch from Permabond.

Please also read the Material Safety Data Sheet. Users are reminded that all materials, whether innocuous 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 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.

The information given and the recommendations made herein are based on our experience and are believed to be accurate. No guarantee as to, or responsibility for, their accuracy can be given or accepted, however, and no statement herein is to be treated as a representation or warranty. In every case we urge and recommend that purchasers, before using any product, make their own tests to determine, to their own satisfaction, its suitability for their particular purposes under their own operating conditions.

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Permabond 101