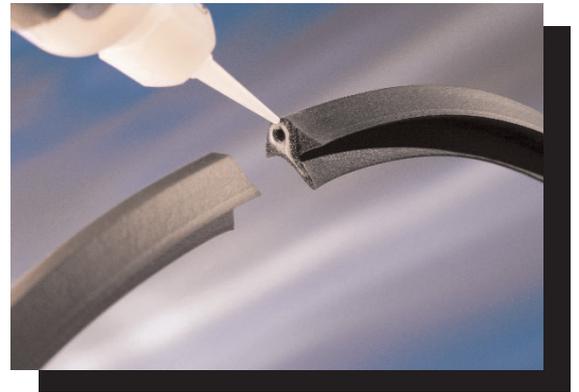


240 (C4) Cyanoacrylate Adhesive

Permabond 240 (previously Permabond C4) has been specially developed to provide a slower cure than most cyanoacrylates. This allows time for accurate alignment of parts where this is critical or to enable the assembly of somewhat larger components. In addition, its high viscosity makes it particularly suitable for use on foamed rubber or semi porous materials such as leather and wood.



240 is ideal for larger or semi porous components

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

Summary:
High viscosity
High strength
For a variety of substrates

PHYSICAL PROPERTIES

Colour	Colourless
Viscosity	2200 mPa.s
Chemical Type	Ethyl Cyanoacrylate
Density	1.05

TYPICAL PROPERTIES

Handling Time	15-55 seconds
Full Strength	24 hours
Tensile Strength	25 MPa
Temperature Range	-30 to +85°C
Maximum Gap Fill	0.375 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).

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Engineering Adhesives

Permabond 240

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 240