

Producing extremely rapid bonds between a wide variety of materials, including plastics, rubbers, metals, paper, card and leather, Permabond 791 is particularly suited to rapid assembly operations involving small components. Its low viscosity will allow penetration of porous materials where this is required or in some cases it may be applied after assembly of the components. It can easily be applied directly from the bottle or via automated dispensing equipment where speed and/or precision is required.

### Physical Properties

<b>Chemical Type</b>	Ethyl cyanoacrylate
<b>Colour</b>	Colourless
<b>Viscosity</b>	40 mPa.s
<b>Density</b>	1.06

### Typical Performance

<b>Gap Fill</b>		0.1mm
<b>Handling Time</b> <sup>†</sup>	Rubber	2 seconds
	Plastic	4 seconds
	Metal	7 seconds
<b>Full Strength</b>		24 hours
<b>Tensile Strength</b>	ASTM D-2095	20 MPa (steel)
<b>Service Temperature</b> *		-30 to +85°C

<sup>†</sup>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).

\*Higher temperatures may be endured for short periods, providing the parts are not unduly stressed.

### Surface Preparation

Surfaces should be clean, dry and grease-free before applying the adhesive. Permabond Cleaner A is recommended for the degreasing of most 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.

### Adhesive Application

■ 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 Permabond Cleaner A.

**NB:**

■ For difficult or porous surfaces, Permabond CSA activator is recommended.

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

### Storage and Handling

<b>Storage Temperature</b>	5 to 7°C
<b>Shelf Life</b> Stored in original unopened containers	12 months

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.

Contact Permabond:

Europe: Tel. +44 (0)1962 711661  
UK Helpline: 0800 975 9800  
Deutschland: 0800 10 13 177  
France: 0805 11 13 88  
info.europe@permabond.com

US: Tel. 00 1 732-868-1372  
Helpline: 800-640-7599  
info.americas@permabond.com  
Asia: Tel. 00 886 939 49 3310  
info.asia@permabond.com

[www.permabond.com](http://www.permabond.com)

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.