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Technical Data Sheet

Permatex® Super Glue, Class 1

AAM Revised 09/02

PRODUCT DESCRIPTION

S.I.N.: 834-300

Permatex® Super Glue, Class 1 is a low viscosity, instant-bonding adhesive designed to bond close fitting surfaces quickly. Sets in seconds to form a permanent, transparent bond. Effective on rubber, glass, aluminum, ceramics, vinyl, alloys, plastics, metal and other non-porous surfaces. Conforms to MIL-A-46050C Type II, Class1; Commercial Item Description A-A-3097 Type II Class1.

PRODUCT BENEFITS

- Ready to use
- No mixing
- Permanent, transparent bond
- Fills gaps to .004"

TYPICAL APPLICATIONS

- Automotive trim
- Logos
- Knobs
- Gear shift logos
- Minor interior repairs

DIRECTIONS FOR USE

1. Protect the work surface against accidental spills, as cyanoacrylates can mark finishes and fabrics.
2. Clean and ensure a close fit on the surfaces to be bonded. Wiping wood with a damp cloth will increase bonding speed.
3. Apply the glue to one of the surfaces. Use sparingly, one square inch of surface area requires only one drop of glue.
4. Hold the surfaces to be bonded together for 15 to 30 seconds. No clamping is required, even on wood. DO NOT REPOSITION THE PARTS.
5. Replace the cap, and store the glue in a cool spot.
6. Allow the parts to cure overnight.

Adhesive Application

Optimum results with cyanoacrylate adhesives are obtained with the minimum quantity of adhesive needed to fill the joint. In general, one free falling drop spreads over one square inch. Apply firm pressure to mated surfaces until the adhesive sets.

Bond Durability

Bond durability is affected by surface conditions, bond areas, service temperature, environment and stress. Each application must be evaluated individually. Moisture and temperature resistance are dependent on the surfaces bonded.

For Cleanup

1. To remove Super Glue, use Super Glue Remover, acetone or nail polish remover that contains acetone.
2. To remove from hard surfaces such as Formica®, saturate a soft cloth or paper towel with the acetone and allow to rest on the spot for about 10 – 15 minutes. After the Super Glue is removed, a white or light colored spot may be left which is easily removed by applying vegetable oil or olive oil to the spot to restore the color.
3. Clean hands with acetone then use Permatex® brand hand cleaners.

PROPERTIES OF UNCURED MATERIAL

	Typical Value
Chemical Type	Ethyl cyanoacrylate
Appearance	Clear liquid
Odor	Sharp
Specific Gravity	1.05
Viscosity, cP	45
Flash Point, (COC) °F	>80

TYPICAL CURING PERFORMANCE

Permatex® Super Glue, Class 1 cures on exposure to moisture. Fixture time is 15 – 30 seconds and full cure within 24 hours. Temperature range of cured material is -65°F to +180°F.

GENERAL INFORMATION

This product is not recommended for use in pure oxygen and/or oxygen rich systems and should not be selected as a sealant for chlorine or other strong oxidizing materials.

For safe handling information on this product, consult the Material Safety Data Sheet, (MSDS).

ORDERING INFORMATION

Part Number	Container Size
49550	1.0 oz. bottle

STORAGE

Products shall be ideally stored in a cool, dry location in unopened containers at a temperature between 8° to 28°C (46° to 82°F) unless otherwise labeled. Optimal storage is at the lower half of this temperature range. To prevent contamination of unused product, do not return any material to its original container.

NOT FOR PRODUCT SPECIFICATIONS.

THE TECHNICAL DATA CONTAINED HEREIN ARE INTENDED AS REFERENCE ONLY.

PLEASE CONTACT PERMATEX, INC., TECHNICAL SERVICE DEPARTMENT FOR ASSISTANCE AND RECOMMENDATIONS FOR YOUR SPECIFIC APPLICATION.
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