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Technical Data Sheet

Permatex® Super Glue, Class 2 INDUSTRIAL

PRODUCT DESCRIPTION

S.I.N.: 834-300

Permatex® Super Glue, Class 2 is a medium viscosity, instant-bonding adhesive designed to bond close fitting surfaces quickly. Sets in seconds to form a permanent, transparent bond. It is specifically formulated for bonding metal surfaces. Conforms to MIL-A-46050C Type I, Class 2; Commercial Item Description A-A-3097 Type I, Class 2.

PRODUCT BENEFITS

- Rapid bonding
- Ready to use
- No mixing
- Permanent, transparent bond
- Fills gaps to .006"

TYPICAL APPLICATIONS

- Rapidly bonds a wide variety of materials, particularly suited for metals.

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 mineral 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	Methyl cyanoacrylate
Appearance	Clear to slightly hazy liquid
Odor	Sharp
Specific Gravity	1.09
Viscosity, cP	125
Flash Point, (COC) °F	>80

TYPICAL CURING PERFORMANCE

Under normal conditions, the surface moisture initiates the hardening process. Although full functional strength is developed in a relatively short time, curing continues for at least 24 hours before full chemical/solvent resistance is developed. 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
49650	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.

NOTE

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