



### Features & Benefits

- 💧 Thixotropic gel
- 💧 Flexible, soft material
- 💧 High elongation
- 💧 Easy to apply and dispense
- 💧 Contains no solvent

### Description

**PERMABOND® 748** is a flexible cyanoacrylate adhesive, exhibiting improved peel strengths when compared to other grades. It has excellent impact and vibration resistance, and is suitable for bonding dissimilar materials which could be subject to thermal shock or thermal cycling. 748 is ideal for use on flexible or semi porous surfaces. It can also be used to bond silicone when used in conjunction with Permabond Polyolefin Primer (POP).

### Physical Properties of Uncured Adhesive

Chemical composition	Cyanoacrylate
Appearance	Colourless thixotrope/gel
Viscosity @ 25°C	20 rpm: 2000-8000 mPa.s (cP) 2rpm: 30,000-50,000 mPa.s (cP)
Specific gravity	1.1

### Typical Curing Properties

Maximum gap fill	0.5 mm <b>0.02 in</b>
Fixture / handling time* (0.3 N/mm <sup>2</sup> shear strength is achieved)	NBR Rubber: 2-5 secs PC: 10-20 secs Silicone (+POP Primer): 2-5 secs Acrylic: 30-50 secs ABS: 3-6 secs PVC: 30-50 secs Steel: 2-5 secs Aluminium: 2-5 secs
Full strength	24 hours

\*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) or Permabond QFS 16.

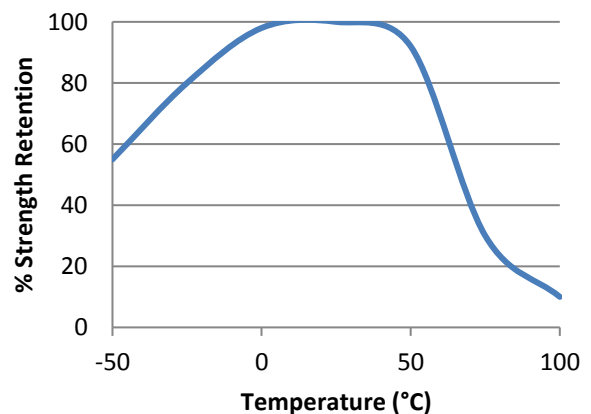
### Typical Performance of Cured Adhesive

Shear strength* (ISO4587)	Steel 8-12 N/mm <sup>2</sup> ( <b>1200-1700 psi</b> ) Aluminium 2-5 N/mm <sup>2</sup> ( <b>290--725 psi</b> ) PC 5-7 N/mm <sup>2</sup> ( <b>725-1000 psi</b> ) Acrylic 2-4 N/mm <sup>2</sup> ( <b>290-600 psi</b> ) ABS 2-4 N/mm <sup>2</sup> ( <b>290-600 psi</b> ) PVC 2-4 N/mm <sup>2</sup> ( <b>290-600 psi</b> )**SF
Hardness (ISO868)	~30 Shore D
Elongation at break (ISO37)	50-80%

\*Strength results will vary depending on the level of surface preparation and gap.

\*\*SF = Substrate failure

### Hot Strength



"Hot strength" shear strength tests performed on mild steel. 24hr cure at room temperature and conditioned to pull temperature for 30 minutes before testing.

748 can withstand higher temperatures for brief periods (such as for paint baking and wave soldering processes) providing the joint is not unduly stressed. The minimum temperature the cured adhesive can be exposed to is -55°C (-65°F) depending on the materials being bonded.

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## Additional Information

This product is not recommended for use in contact with strong oxidizing materials and polar solvents although will withstand a solvent wash without any bond strength deterioration. 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 Safety Data Sheet.

**This Technical Datasheet (TDS) offers guideline information and does not constitute a specification.**

## Surface Preparation

Surfaces should be clean, dry and grease-free before applying the adhesive. Use a suitable solvent (such as acetone or isopropanol) for the degreasing of 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.

## Directions for Use

- 1) Apply the adhesive sparingly to one surface.
- 2) Bring the components together quickly and correctly aligned.
- 3) Apply sufficient pressure to ensure the adhesive spreads into a thin film.
- 4) Do not disturb or re-align until sufficient strength is achieved, normally in a few seconds.
- 5) Any surplus adhesive can be removed with Permabond CA solvent, nitromethane or acetone.

### NB:

For difficult or porous surfaces using a Permabond activator is recommended. If bonding polypropylene, polyethylene, PTFE or silicone, prime first with Permabond Polyolefin Primer (POP).

### Video Links

Surface preparation:

<https://youtu.be/8CMOMP7hXjU>



Cyanoacrylate directions for use:

<https://youtu.be/PiPzutdRmsk>



## Storage & Handling

Storage Temperature	2 to 7°C (35 to 45°F)
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Allow adhesive to reach room temperature before opening bottle to prevent condensation inside the bottle which can reduce shelf life.

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