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Technical Data Sheet

Permatex® Super Glue

INDUSTRIAL

PRODUCT DESCRIPTION

Permatex® Super Glue is a one-component, solvent-free, low viscosity instant adhesive based on cyanoacrylate resin. It is fast setting and cures at room temperature.

PRODUCT BENEFITS

- Ready to use
- No mixing
- Sets in seconds
- Permanent, transparent bond
- Fills gaps to .004"
- Non-flammable
- Adheres metals, alloys, plastics, vinyl, rubber and ceramics

TYPICAL APPLICATIONS

Bonding of plastics, metals and rubber.

DIRECTIONS FOR USE

1. Both surfaces must be smooth, clean, dry and free of oil, grease, etc.
 2. USE EXTREME CARE WHEN OPENING. Hold bottle upright, pointing away from face. Remove nozzle.
 3. Apply adhesive to one surface, about one drop per square inch. Spread evenly.
 4. Immediately place the second surface in contact with the first surface and press together.
 5. Keep light pressure on surfaces for 15 seconds or until bond sets.
 6. Allow to completely harden, for best results, overnight.
- NOTE: Not suitable for untreated polyethylene or polypropylene products.

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 upon 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, 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 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	Cyanoacrylate Resin
Appearance	Colorless liquid
Odor	Mild Pungent
Specific Gravity	1.06
Viscosity. Brookfield LVF, Spindle 1, 30 rpm, 25C, cP	20 - 60
Flash Point, (TCC) °F	>200

TYPICAL CURING PERFORMANCE

Permatex® Super Glue cures on exposure to moisture. Fixture time is defined as the number of seconds after assembly when a joint develops a tensile shear strength of 14 PSI (0.1N/mm²) 22°C, 50% relative humidity according to ASTM D1002.

Performance of Permatex® Super Glue on substrates is as follows:

Substrate	Fixture Time, seconds
Steel (degreased)	5 – 10
G10 Epoxy Glass	5 – 10
Aluminum	5 – 10
Wood (Oak)	40 - 60

All surfaces were cleaned with isopropyl alcohol. Fixture times and strengths can vary with different grades of materials.

PERFORMANCE OF CURED MATERIAL

Tensile shear strength, ASTM D1002, PSI

Steel*	1800 – 2400
G10 Epoxy Glass	2200 – 2800
Aluminum*	1200 – 1600
Wood (Oak)	1100 - 1600

* Sand-blasted surface

Temperature range, °F (°C) -65 to + 180(-53 to +82)

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
49450	1.0 oz. bottle
82190	2 g tube, 1-pack carded

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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