

ONEBOND INSTANT ADHESIVE 793

Description

General purpose, surface insensitive medium viscosity instant adhesive based on ethyl cyanoacrylate. Insensitive to acidic surfaces, it is recommended for bonding of leather, wood and metals. Proven temperature strength up to +120°C with peaks for short times up to +150°C.

Typical physical properties

Composition:	modified ethyl cyanoacrylate
Colour:	clear
Viscosity (+25°C - mPa s):	80 - 150
Specific weight (g/ml):	1,06
Maximum gap to fill:	150 microns
Shelf life @+25°C:	12 months in original unopened packaging
Temperature range:	-50°C/+120°C

Typical curing properties

Curing rate depends on the substrate used, on the gap, on the temperature and on the environmental humidity.

<u>Substrate</u>	<u>Fixture Time (seconds)</u>
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Woods

* Fir	45 - 90
* Balsa	2 - 5
* Teak	5 - 20
* Baywood	10 - 30
* Pine	5 - 20
* Oak	90 - 180
* Chipboard	30 - 90

Plastics

* PVC	2 - 10
* Phenolic Resin	2 - 10
* ABS	2 - 10

Metals

* Steel	5 - 20
* Aluminium	2 - 10
* Zinc	10 - 20

Various substrates

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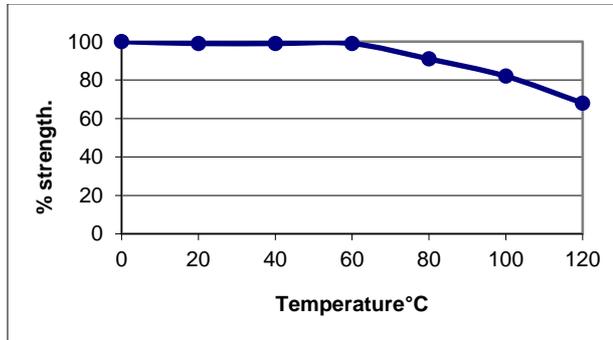
* Neoprene/NBR	< 5
* Fabric	2 - 20
* Leather	5 - 15
* Ceramic	5 - 30
* Paper	1 - 5

Proprieties of cured material (typical)

Tensile strength ISO 6922 (N//mm ²):	15 - 25
Shear strength ISO 4587 (N//mm ²):	15 - 20
Refraction index n ²⁰ D:	similar to glass
Electrical resistivity DIN 53482 (Ω mm):	>10 ¹⁵
Dielectric strength ASTM D 149 (kV/mm):	25
Dielectric constant DIN 53483 (1MHz):	5,2

Environmental resistance

The graph below shows the mechanical strength of the product (%) vs. temperature.
Specimen steel - ISO 4587



Typical physical properties

Aged at indicated temperature under conditions below after 24 hours from polymerization.
Specimen steel - ISO 4587

Substance	°C	Resistance after 100 h	Resistance after 500 h	Resistance after 1000 h
Motor oil	40	Excellent	Excellent	Excellent
Alcohol	25	Excellent	Excellent	Excellent
Gasoline	25	Excellent	Excellent	Excellent
Relative humidity 90%	40	Discret	Low	Low
Refrigerating gases	25	Excellent	Excellent	Excellent

* For information on resistance with other chemicals, contact Onebond Technical Service

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Directions for use

1. Clean and degrease all surfaces with acetone or isopropyl alcohol and allow drying before applying the adhesive.
2. Use the proper bottle to apply the adhesive, avoiding the usage of improper tools. Bring the components together quickly and correctly aligned (fast curing does not allow any repositioning).
3. Apply sufficient pressure for a few seconds to fix the components and clamp them until they are completely fixed.
4. Wait 24-72 hours until full cure before any mechanical stress.

Warnings

This adhesive is not approved for usage neither with pure nor with gaseous oxygen.

Storage

We recommend to store product in a cool and dry place at temperature non exceeding +20°C. For better and enhanced shelf life, keep product in a refrigerator at +2°C/+7°C. To avoid contaminations do not refill containers with used product. For more information on applications, storage and handling contact Onebond Technical Service.

Safety, handling and disposal

Consult the Safety Data Sheet before use.

Note

The data contained herein, obtained in Onebond laboratories, are given for information only; if specifics are required, please contact Onebond Technical Department. Onebond ensures abiding quality of supplied products according to its own specifics. Onebond cannot assume responsibility for the results obtained by others which methods are not under Onebond control. It is user's responsibility to determine suitability for user's purpose of any product mentioned herein. Onebond disclaims all warranties expressed or implied, including warranties of merchantability or fitness for a particular purpose, arising from sale or use of Onebond products. Onebond specifically disclaims any liability for consequential or incidental damages of any kind, including lost profits.