

ONEBOND INSTANT ADHESIVE 737

Description

The ONEBOND 737 is a high viscosity instant adhesive based on ethyl cyanoacrylate. Designed for bonding plastic and rubber together or with metal. ONEBOND 737 is toughened to withstand shock and vibrations. The slow fixture time allows adjustment of parts during assembly.

Typical physical properties

Composition:	ethyl cyanoacrylate
Colour:	black
Viscosity (+25°C - mPa s):	500 - 1500
Specific weight (g/ml):	1,06
Maximum gap to fill:	200 microns
Shelf life @+25°C:	6 months in original unopened packaging

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>
Plastics	
* PVC:	30
* Phenolic Resin:	25
* ABS:	25
* Polycarbonate:	60
Metals	
* Steel:	35
* Aluminium:	20
Various substrates	
* Neoprene/NBR:	5

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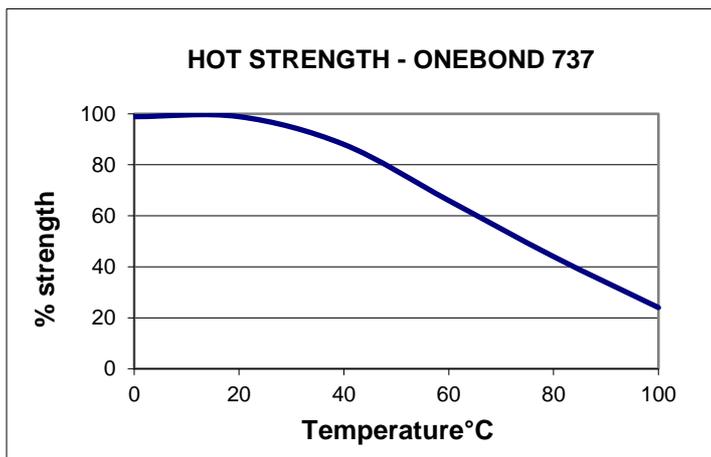
Proprieties of cured material (typical)

Shear strength ISO 4587 (N/mm²):

Steel:	25
Aluminium:	20
ABS:	6
PVC:	5
Phenolic:	6
Polycarbonate:	7

Environmental resistance

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



Chemical resistance

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	Good	Good	Good
Alcohol	25	Excellent	Excellent	Discret
Gasoline	25	Excellent	Discret	Discret
Relative humidity 90%	40	Discret	Discret	Low
Refrigerating gases	25	Good	Good	Good

* 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.