

ONEBOND ULTRA GLUE 793

Description

The ONEBOND ULTRA GLUE 793 is a general purpose, medium viscosity instant adhesive based on ethyl cyanoacrylate. Surface insensitive, it is perfect for bonding acidic substrates such as leather, wood and paper. Also suitable for bonding metals, rubber, and polar plastics. In high humidity the nozzle of the bottle may become clogged. To avoid this, ONEBOND cyanoacrylate bottles have anti-clogging nozzles. For bonding PP, PE and PTFE, ONEBOND PLASTIC PRIMER PE/PP is required.

Typical physical Properties

Composition:	Ethyl cyanoacrylate
Colour:	Clear/ colorless
Viscosity (+25°C - mPa s):	80 – 150
Specific weight (g/ml):	1,06
Maximum gap to fill:	150 microns
Shelf life @+25°C:	18 months in original unopened packaging

Typical curing Properties

<u>Substrate</u>	<u>Fixture Time</u>
PMMA	5 s
ABS	15 s
POLYCARBONATE	15 s
STEEL	5 s
ALUMINIUM	15 s
EPDM	50 s
BEECH WOOD	20 s

- 1: These are typical values and should not be construed as specifications.
- 2: Curing conditions: +23°C and 50% Room Humidity.
- 3: Curing speed can be accelerated at higher temperature and higher humidity.

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Proprieties of cured material (typical)

The table below includes the lap shear strength (ISO 4587) of ONEBOND 793 on different substrates.

<u>Substrate</u>	<u>Shear strength</u>
PMMA	11
ABS	13
POLYCARBONATE	13
STEEL	18
BEECH WOOD	10

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- 2: Curing conditions: +23°C and 50% Room Humidity.
- 3: Curing speed can be accelerated at higher temperature and higher humidity.

Directions for use

Instant bond adhesives are 'cyanoacrylates' which cure in seconds at room temperature on a number of substrates, including metal, wood, rubber, leather, plastic, cork, ceramics, and many others, making them ideal for small repairs and industrial assembly applications. Cyanoacrylates have poor adhesion to low surface energy plastics such as polyethylene, polypropylene and Teflon. The curing reaction is triggered by moisture on the substrate. In dry conditions, the curing rates will be slow or impossible and if moisture is present, once cured, they degrade slowly.

Use gloves to minimise skin contact with the adhesive. Do not use solvents or thinners to clean the hands. Remove all surface contaminants from the parts such as oxide, oil, grease, dust any other contaminants that can affect adhesion with a suitable cleaner such as isopropyl alcohol and allow drying before applying the adhesive.

Apply the desired amount of adhesive on one of the substrates to be bonded. The components must be assembled quickly. This is an instant adhesive that does not allow any repositioning. Applying constant pressure over the bond line is recommended until the fixture time is reached. The fixture time is influenced by the application temperature and the bonding thickness: the hardening reaction speed increases with the temperature and decreases with the amount of material applied. Wait 24 hours until the adhesive is fully cured before subjecting the parts to mechanical stress.

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Storage

	Unit	
Recommended temperature	°C	5 – 25
Storage stability / Shelf life	Months	18
1: Stored in the original sealed containers at the recommended temperature in a dry place.		

Packaging

Bottle 3 g – 20 pieces per box – 66254427356 – FR, ES, PT, IT, PL, TK

Bottle 5 g – 20 pieces per box – 66254427359 – FR, ES, PT, IT, PL, TK

Bottle 5 g – 20 pieces per box – 17000015198 – EN, SE, NO, DK, FI

Bottle 20 g – 10 pieces per box – 78072764203 – EN, SP, PT, IT, TK

Bottle 20 g – 10 pieces per box – 78072764204 – EN, FR, NL, DE, PL

Bottle 20 g – 10 pieces per box – 78072769384 – PL, EN, FI, DK, SE, NO

Bottle 20 g – 10 pieces per box – 78072769449 – EN, HU, CZ, RO & CRO/SRB/BiH

Bottle 50 g – 10 pieces per box – 78072774567 – EN, FR, NL, DE, PL, SP, PT, IT, TK

Bottle 50 g – 10 pieces per box – 78072774571 – PL, EN, FI, DK, SE, NO, HU, CZ, RO & CRO/SRB/BiH

Bottle 500 g – 6 pieces per box – 66254431289 – EN, FR, NL, DE, PL, SP, PT, IT, TK

Safety Considerations

Safety Data Sheets (SDS) are available from OneBond. SDS include information regarding the physical, health, and environmental health hazards, safety precautions, for products handling, storing and disposal. SDS are available in the language of the country or area of destination and may include locally applicable health and safety regulations. SDS are updated regularly and can be downloaded from www.onebondadhesives.com. OneBond encourages users to review the up-to-date SDS before handling or using any product.

Customer Notice

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.