

## HIGH TEMPERATURE ADHESIVE - 825

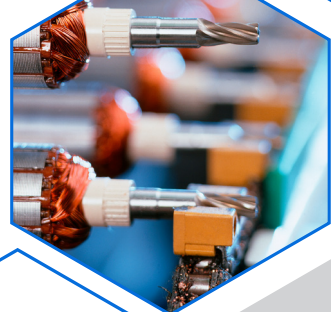
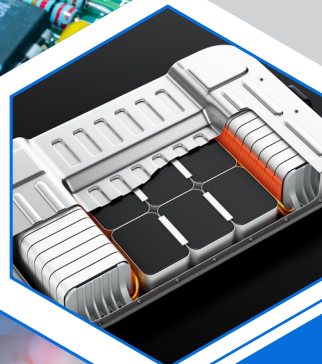


**Permabond 825 is a cyanoacrylate adhesive designed to withstand high temperatures without the need for a post-cure.**

A low viscosity, modified ethyl cyanoacrylate with excellent adhesion to a wide variety of metals and plastics, Permabond 825 features patented technology allowing it to withstand up to 200°C. In addition, it offers excellent strength retention during thermal ageing.

Unlike other cyanoacrylates, Permabond 825 withstands high temperatures without a secondary heat cure. Avoiding this secondary process results in time and cost savings and makes 825 ideal for high-speed production lines.

The adhesive cures in seconds at room temperature by reacting with moisture present on the surfaces to be bonded. It's very easy to dispense, requires no mixing and has a good safety profile, being 100% solvent-free.



### KEY FEATURES:

- ▶ High temperature resistance (up to 200°C)
- ▶ No secondary heat/post-cure required
- ▶ High strength after thermal ageing
- ▶ Thermal stability with gap up to 0.15mm
- ▶ Low viscosity
- ▶ Rapid curing
- ▶ 100% reactive - no solvents
- ▶ Easy to use - no mixing

### IDEAL FOR BONDING:

- |                   |                 |                        |
|-------------------|-----------------|------------------------|
| • ABS             | • HDPE          | • PVC                  |
| • Acrylic         | • LDPE          | • Stainless Steel      |
| • Aluminium       | • Mild Steel    |                        |
| • Certain rubbers | • Phenolic      | • <i>And many more</i> |
|                   | • Polycarbonate |                        |

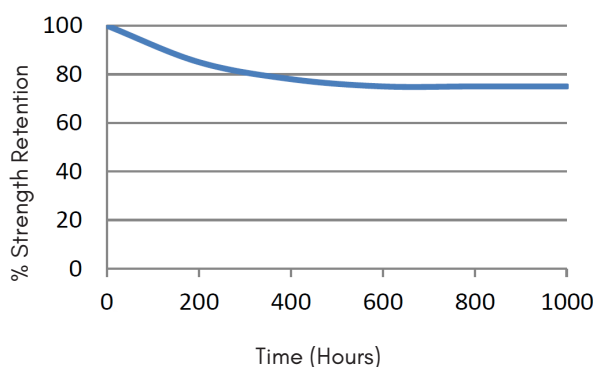


## DESCRIPTION

The following technical data for Permabond 825 is a guideline and does not constitute a specification. For full technical information, please refer to the technical data sheet, available at [www.permabond.com](http://www.permabond.com). Please contact Permabond to discuss your bonding project.

	825
Description	Heat resistant modified ethyl cyanoacrylate
Appearance	Colourless
Features	Withstands up to 200°C, high strength during thermal ageing
Viscosity	100-150 mPas
Max. gap fill	0.15mm
Fixture time	Between 5 and 60 seconds, depending on the substrate
Full Strength	24 hours
Service Temperature	200°C
Storage temperature	Between 2 and 7°C
Packaging	20g & 500g bottles, Bulk on request

### Thermal Ageing at 180°C



### What is thermal ageing, and why does it matter?

Thermal ageing refers to the gradual change in a material's physical or chemical properties due to long-term exposure to elevated temperatures. When an adhesive is repeatedly heated or held at high temperature, its internal structure can slowly degrade. This leads to loss of performance, such as reduced strength, brittleness, and discoloration. Permabond 825 however retains excellent strength when exposed to high temperatures for long periods, as the table opposite shows.

#### Authorised distributor stamp:

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