

# Permabond®

## 3D90 3D Print Infiltrant

ISO 9001:2008 Certified  
 "Our Science ... Your Success"

Introducing Permabond 3D90 cyanoacrylate for strengthening and sealing 3D printed models produced via granular 3D printing methods.

### Permabond® 3D90 Features & Benefits

- Ultra-low viscosity and delayed cure speed allows good depth of penetration into parts
- Alkoxyethyl formulation is low odour and minimises powdery white residue on surfaces
- Low odour makes it suitable for use in dip baths for large parts
- Solvent-free formulation helps minimise workplace hazard
- Adds extra strength and significantly improves printed part performance and durability
- Fills voids and porosities
- Moisture cure mechanism - no need for measuring and mixing, UV lamp or oven to cure adhesive
- Easy to apply either as "on the spot" coating or in a dip bath
- Suitable for use on simple or complex, large or small parts
- Clear, colourless appearance
- Tack-free finish

### Product Data

<b>Appearance</b>	Clear, Colourless
<b>Viscosity @ 25°C</b>	4 mPa.s
<b>Handling Time</b>	10-15 seconds (Steel)
	20-30 seconds (PVC)
	20-30 seconds (Phenolic)
	20-30 seconds (ABS)
<b>Shear Strength</b>	Steel: 16-20 N/mm <sup>2</sup>
	Aluminium: 8-9 N/mm <sup>2</sup>
	Zinc: 8 N/mm <sup>2</sup>
	ABS: >6 N/mm <sup>2</sup> (SF)
	PVC: 5 N/mm <sup>2</sup>
	Polycarbonate: >5 N/mm <sup>2</sup>
Phenolic: 4 N/mm <sup>2</sup>	
<b>Impact Strength</b>	3-5 kJ/m <sup>2</sup>
<b>Hardness</b>	85 Shore D
<b>Dielectric Strength</b>	25 kV/mm
<b>Dielectric Constant</b>	3 @ 1 MHz
<b>Packaging</b>	500g
	2kg
	Bulk 20kg
<b>Storage</b>	2-7°C

SF=Substrate Failure

For full technical information, please refer to product data sheet



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**Permabond®**  
 Engineering Adhesives