Technical Data Sheet
Version 3. 04/2023

Permatex® Zip Grip® GPE 15

Description: A single component low viscosity, fast setting, cyanoacrylate adhesive

Intended Use: Industrial Use: Ideal for fast setting bonds for rubber bonding applications

Features:
Easy to apply
Fixtures in seconds
Permanent
Enhanced toughness to peel and shock loads
Highly resistant to aging and weathering
Rubber Bonder

Limitations: Suitability of product is determined by the end user for their application and process.

Typical Physical Properties:

Technical data should be considered representative or typical only and should not be used for specification purposes.

Cured 7 Days @ 75°F (24°C)	Typical Values	Standard Tests
Adhesive Tensile Shear	3,200 psi (22 MPa)	Adhesive Tensile Shear ASTM D 1002
Coefficient of Thermal Expansion (x10-6)	126 in/in.°F (227 cm/cm.°C)	Coef. of Thermal Expansion ASTM D 696
Dielectric Constant	5.4 @ 1 Kc	Dielectric Constant ASTM D 150
Dielectric Strength	294.6 volts/mil (11.6 kV/mm)	Volume Resistivity , ohm/cm ASTM D 149
Flashpoint	185°F (85°C)	Dielectric Strength, volts/mil ASTM D 149
Full Cure	24 hours	
Melting Point	329°F (165°C)	
Refractive Index	1.49	
Service Temperature Range	-65°F to 200°F (-54°C to 93°C)	
Solubility	Nitromethane, Acetone,	
Volume Resistivity	5.3E-14 ohm/cm	

Uncured Properties @ 72°F (23°C)	
Base	Ethyl cyanoacrylate
Color	Colorless liquid
Cure Speed	5-10 sec. (Steel); 3-5 sec. (Plastics): <2 sec.
Gap Filling	0.005 in. (0.13 mm)
Military Specification	Mil--A-46050C Type II Class 1
Shelf Life	1 year
Specific Gravity	8.85 lb/Gal (1.06 g/cm3)
Viscosity	15 cP

Surface Preparation: Clean surface by solvent-wiping any deposits of heavy grease, oil, dirt, or other contaminants. Surface can also be cleaned with industrial cleaning equipment such as vapor phase degreasers or hot aqueous baths.

---- CLEANING METHODS ----

STEEL:
Vapor degrease or cold-solvent clean (Sand blasting or other preparation is not typically required).

ALUMINUM:
Abrade with Scotch-Brite™ abrasive pads or steel wool, then clean with solvent.

RUBBER:
Wipe clean with isopropyl alcohol or solvent.

PLASTICS:
Lightly abrade shiny, smooth surfaces, then solvent-wipe with suitable solvent such as 1,1,1-trichloroethane, acetone, or VM&P naptha. Non-shiny surfaces need only be solvent-wiped.

Mixing Instructions: Mixing is not applicable to this product.

Application Instructions:
1. Apply adhesive directly from bottle (approximately 0.006 g/in2 (0.93 mg/cm2) is sufficient).
2. Press surfaces together
3. Hold tightly for a few seconds

ADDITIONAL PRODUCT INFORMATION
- Cyanoacrylates generally fixture in a few seconds on most smooth, close-fitting substrates.
- They cure best at room temperature 72°F (22°C)
- Heat does NOT accelerate the cure of Cyanoacrylates
- The gap of the bond line will affect set speed. Smaller gaps tend to increase the speed.
- Activators can be applied to improve set speed but may also impair overall performance

Storage: Store in a cool, dry place.

Compliances: CID A-A-3097, Type II Class 1
USP VI / ISO 10993

Chemical Resistance: Chemical resistance is calculated with a 7 day, room temp. cure (30 days immersion) @ 75°F (24°C)

1,1,1-Trichloroethane	Excellent
Gasoline (Unleaded)	Excellent
Hydrochloric 10%	Poor
Motor Oil	Excellent
Sodium Hydroxide 10%	Poor

Precautions: **FOR INDUSTRIAL USE ONLY:** Please refer to the appropriate **S**afety **D**ata **S**heet prior to using this product.

Warranty: ITW Performance Polymers will replace any material found to be defective. Because the storage, handling and application of this material is beyond our control, we can accept no liability for the results obtained.

Order Information:

Item No.	**Package Size**
70213	1/3 oz. bottle

Contacts:

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