



Permatex® Zip Grip® GPE 3

Description:	A low-viscosity, moisture-curing, general purpose instant adhesive for tight-fitting parts		
Intended Use:	Industrial Use: Bonding rubber weatherstripping, fixturing rubber gaskets, splicing o-rings, repairing plastics and metals		
Features:	Fixtures in seconds Permanent Easy to apply Highly resistant to aging and weathering		
Limitations:	Suitability of product is determined by the end user for their application and process. Not recommended for use on glass due to substrate weakness		
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	3200 psi (22 MPa)	Coef. of Thermal Expansion ASTM D 696
	Coefficient of Thermal Expansion (x10-6)	120 in/in.°F (216 cm/cm.°C)	Dielectric Strength, volts/mil ASTM D 149
	Dielectric Constant	5.4 @ 1KHz	Adhesive Tensile Shear ASTM D 1002
	Dielectric Strength	294.6 volts/mil (11.6 kV/mm)	Dielectric Constant ASTM D 150
	Flashpoint	185°F (85°C)	Volume Resistivity , ohm/cm ASTM D 149
	Melting Point	> 329°F (165°C)	
	Peel Strength	2 pli (0.35 N/mm)	
	Refractive Index	1.49	
	Service Temperature Range	-65° to 200°F (-54° 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.	
	Full Cure	24 hrs	
	Gap Filling	0.003 in (0.076 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	3 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							
Chemical Resistance:	Rating chemical resistance is not necessary for this product.							
Precautions:	FOR INDUSTRIAL USE ONLY: Please refer to the appropriate <u>Safety Data Sheet</u> 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:	<table><tr><td><u>Item No.</u></td><td><u>Package Size</u></td></tr><tr><td>70145</td><td>2 gm</td></tr><tr><td>70144</td><td>14 gm</td></tr></table>	<u>Item No.</u>	<u>Package Size</u>	70145	2 gm	70144	14 gm	
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