



# Permatex<sup>®</sup> Zip Grip<sup>®</sup> GPE 30

<b>Description:</b>	A single component low viscosity, general purpose cyanoacrylate adhesives for tight fitting parts.		
<b>Intended Use:</b>	Industrial Use: Ideal for bonding pre-assembled parts, rubber and leather. Product designed to set and adhere rapidly to inactive surfaces rapidly to inactive surfaces		
<b>Features:</b>	<b>Easy to apply</b> <b>Fixtures in seconds</b> <b>Permanent</b> <b>Bonds to inactive surfaces</b> <b>All purpose [low viscosity]</b>		
<b>Limitations:</b>	Suitability of product is determined by the end user for their application and process.		
<b>Typical Physical Properties:</b>	Technical data should be considered representative or typical only and should not be used for specification purposes.		
	<b>Cured 7 Days @ 75°F (24°C)</b>	<b>Typical Values</b>	<b>Standard Tests</b>
	Adhesive Tensile Shear	3,200 psi (22MPa) [steel/steel]	Adhesive Tensile Shear ASTM D 1002
	Coefficient of Thermal Expansion (x10-6)	126 in/in.°F (227cm/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° to 200°F (-54° to 93°C)	
	<b>Uncured Properties @ 72°F (23°C)</b>		
	Base	Ethyl cyanoacrylate	
	Color	Colorless liquid	
	Cure Speed	5-12 sec. (Steel); 5-13 sec. (Plastics): <6 sec	
	Gap Filling	0.004" (0.1 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	30 cP	
<b>Surface Preparation:</b>	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 ---- <b>STEEL:</b> Vapor degrease or cold-solvent clean (Sand blasting or other preparation is not typically required). <b>ALUMINUM:</b> Abrade with Scotch-Brite™ abrasive pads or steel wool, then clean with solvent. <b>RUBBER:</b> Wipe clean with isopropyl alcohol or solvent. <b>PLASTICS:</b> Lightly abrade shiny, smooth surfaces, then solvent-wipe with suitable solvent such as 1,1,1-trichloroethane, acetone, or VM&P naphtha. Non-shiny surfaces need only be solvent-wiped.		
<b>Mixing Instructions:</b>	Mixing is not applicable to this product.		
<b>Application Instructions:</b>	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		
	<b>ADDITIONAL PRODUCT INFORMATION</b> - 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:** Chemical resistance is calculated with a 7 day, room temp. cure (30 days immersion) @ 75°F (24°C)

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

**Precautions:** **FOR INDUSTRIAL USE ONLY:** Please refer to the appropriate Safety Data Sheet 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:**

<u>Item No.</u>	<u>Package Size</u>
70350	1 oz. bottle

**Contacts:**

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