

## Three Bond 7784 Cyanoacrylate Adhesive - Ultra Rapid Setting Type

### Product Outline

Three Bond 7784 is a medium viscosity high performance industrial grade cyanoacrylate adhesive. It is suited for most general purpose applications, hardens in seconds at room temperature and demonstrates strong bonds to metals, most plastics and rubbers.

### Features

- Ultra rapid setting due to high monomer purity.
- Improved temperature and humidity performance.
- Improved bonding strength for difficult to bond substrates such as EPDM, polyacetal and acidic surfaces.

### Typical Properties

Property		Result
Viscosity at 25°C		160 mPa·s
Set time (23°C x 50 % RH)	Nitrile rubber	2 sec
	Steel	3 sec
	PC	10 sec
	PBT	7 sec
	Balsa	3 sec
Shear strength (23°C x 50 % RH x 24h)	Steel	15 MPa
	PBT	5 MPa
Effective temperature range		-50 +120°C

### Directions For Use

- For optimum bonding remove grease, dirt and other impurities from the fitting faces.
- The best results are obtained when bonding the parts at 23°C x 40 ~ 80 % RH. A lower humidity slows the curing process, a higher humidity accelerates the curing process but can weaken the bond strength.
- In the case of difficult to bond substrates such as polyethylene or polypropylene, apply primer Three Bond 7797 on the fitting faces and allow to dry (adhere within 1h).
- In the case of difficult bonding conditions where cure speed is long due to large gaps or low relative humidity, apply Activator Three Bond 1796B on one of the fitting faces and allow to dry (adhere within 1h).
- Apply a thin coat of adhesive on one of the fitting faces ( $\approx 5 \text{ mg/cm}^2$ ) and join the parts immediately, position correctly and fix them under slight pressure. The thinner the adhesive is applied, the higher the adhesion obtained.

### Handling Precautions

- Danger! Bonds skin and eyes in seconds.
- Three Bond cyanoacrylate adhesives have been proven to be safe to handles as long as normal hygienic practices are observed.
- Use in a well-ventilated area, avoid contact with skin and eyes.
- Refer to the product MSDS for further details.
- Use and keep out of the reach of children.

### Storage

- Shelf life 12 months. Keep the product in its original container, tightly closed and store it in a dark, dry, sufficiently ventilated and cool place, refrigeration to 5°C provides optimum storage stability.

### Packaging

- 20g bottle.