

ThreeBond

THREE BOND EUROPE S.A.S

1743



DESCRIPTION

ThreeBond 1743 is an one-part, ready-to-use, solvent free cyanoacrylate adhesive which cures very rapidly at room temperature, used for post application.

APPLICATION

Bond plastics, metal, rubber, ceramic, porcelain ...

UNCURED PRODUCT PROPERTIES

CARACTERISTICS	VALUES	UNITS
Appearance	incolor	
Viscosity	100	mPa.s
Density	1.07	

POLYMERISATION

. Set time depends on bonding thickness, surface finish, temperature and ambient humidity.
Full physical properties are achieved after 12 hours at 20°C.

	Set time (s)	Temperature	Relative humidity
NBR	15	23°C	50%

CURED PRODUCT PROPERTIES

CARACTERISTIC	VALUES	UNITS
Shear strength Fe/fe (24h after bonding)	12	MPa

TEMPERATURE LIMITATIONS

Bonds made with ThreeBond 1743 can be exposed to temperature between -60 and +80°C for long periods without reduction of strength at room temperature. Within this limits the strength will remain at least 50% of the strength at room temperature. Prolonged exposure above this range can cause permanent loss of strength.

SOLVENT RESISTANCE

ThreeBond 1743 has sufficient resistance to most commonly-used solvents in most bonding applications. The resistance to different solvents depends mainly on the substrates and temperatures involved. Care should be take in applications with immersion in water. Bonds on some plastics are hardly affected by water below 40°C. In most cases it's best to test the adhesive in the presumed application before production.

ASSOCIATED PRODUCTS

PRIMER

For adhesion on polypropylene, polyethylene, polyacetal and EPT rubber pre-treatment with ThreeBond 1797 primer is recommended. Wipe or brush primer not more than two time on the surface. Leave primer at least 10 min. to dry. Bond strength may be affected using too much primer. Life on part of this primer is one hour.

ACTIVATOR.

TB 1796B.is used to reduce set time.Wipe or brush it only on one part to bond. Wait for about 1 minute (never more than 2 min).

CLEANER

TB17F024 : can be used for cured or uncured product cleaning.

TYPICAL ASSEMBLY PROCEDURE

CLEANING

For high strength the surface must be clean and dry. Cleaning with alcohol, trichlorethane, acetone, Methylene chloride or MEK will be satisfactory for most surfaces.

. APPLYING PRODUCT

Apply a drop of ThreeBond 17F-030 to one of the surfaces directly from the container by avoiding excess of adhesive. Apply approximately 5mg/cm².

. ASSEMBLY

Assemble rapidly after applying adhesive. Light contact pressure is needed to prevent movement. Adhesion will be achieved within seconds.

CURING

Cure speed and final strength depends on the humidity of the atmosphere and on the surface. The optimum relative humidity is 60%. Where cure speed is inadequate, e.g. with large gaps, ThreeBond activator 1796B may be used. Use of this activator can cause reduction of final strength, testing is recommended.

SHELF LIFE

Packaging	Shelf life (months)	In the original container 25°C
20g	12	
50g	12	
500g	12	
20kg	12	