

Permabond products are relied upon to increase quality, output, and improve efficiency when producing medical, surgical, and assistive devices. A global team of technical, sales, and distribution professionals is available to assist you in selecting the most appropriate standard or custom formulated product for your unique application.

Typical Substrates Bonded

Permabond® Adhesives for Medical Devices are Trusted on:

- Medical Disposable Devices
- Surgical Instruments
- Diagnostic Equipment
- Disposable Diagnostic Supplies
- Assistive Devices
- Prosthetics

ABS

Acrylic

Glass

HDPE

Polycarbonate

Polystyrene

PVC

Stainless Steel

and many more...

 **Chemical
Concepts**™
Our expertise is your solution.
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800.220.1966
410 Pike Road • Huntingdon Valley, PA 19006



Permabond® Medical Device Adhesives

Permabond manufactures a full line of adhesives. Samples of our most popular for medical device assembly are listed below. Contact Permabond for an adhesive recommendation or custom formulation for your unique application.

		Grade	Viscosity cP/ mPa	ISO10993-5	Typical Applications	Shear Strength Steel N/mm ² (psi)	Shear Strength Polycarbonate, PVC and ABS
Cyanocrylate (Instant Adhesive)	Set time is 5-30 seconds depending upon gap and substrate.	4C10	40	PASS [•]	Tube Set Bonding	18-22 (2,600-3,200)	Substrate Failure
		4C20	500	PASS [•]	Bonding Tips To Swabs	20-22 (2,900-3,200)	Substrate Failure
		4C30	1,500	PASS [•]	Gap Filling For Custom Tube Sets	20-22 (2,900-3,200)	Substrate Failure
		4C40	2,000	PASS [•]	Rubber Bumper Bonding	20-22 (2,900-3,200)	Substrate Failure
		731	150	PASS	Equipment View Panel Bonding	24-30 (3,500-4,400)	Substrate Failure
		820	100	PASS	High Temp. Resistant Bonding	19-23 (2,800-3,300)	Substrate Failure
		940	3-10	Not Yet Tested	Low Odor For Manual Application	16-20 (2,300-2,900)	Substrate Failure
		2011	Gel	Not Yet Tested	Name Plates To Housings	20-24 (2,900-3,500)	Substrate Failure
UV Adhesives	Set time is dependent upon intensity of light. Generally less than 2 seconds.	4UV80	150 [▲]	PASS	Plastic Bonding	NA	Substrate Failure
		UV630	250	PASS	Plastic Bonding	NA	Substrate Failure
Epoxy	Set time not available full cure in oven.	4ES70	2 rpm 40,000 20 rpm 17,500	Not Yet Tested	Needle Bonding	Needle pull out strength: 150-200N	NA

[•] USP Class VI reports also available

[▲] Other viscosities available see 4UV80HV viscosity 1,800-2,800 cP and 4UV80HH viscosity 8,000-12,000 cP

For full, up-to-date technical information and usage instructions, please refer to the TDS (Technical Data Sheet).

Contact Permabond

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The information given and the recommendations made herein are based on our experience and are believed to be accurate. No guarantee as to, or responsibility for, their accuracy can be given or accepted, however, and no statement herein is to be treated as a representation or warranty. In every case we urge and recommend that purchasers, before using any product, make their own tests to determine, to their own satisfaction, its suitability for their particular purposes under their own operating conditions. Always refer to current product technical data sheet for most recent and accurate technical information.

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