

## ThreeBond 7797

Primer for Cyanoacrylate Instant Adhesive (Gold Series)

ThreeBond **7797** is an instantaneous adhesive primer for cyanoacrylate adhesive. It facilitates bonding and set time to hard-to-bond materials, such as polypropylene, polyethylene, polyacetal, PTFE and silicone rubber.

### 1. Features

- Improves adhesion to hard-to-bond materials
- Improve set time
- Dries quickly
- Applicable with all 1700 and 7700 series

### 2. Properties

Test	Results	Units
Colour	Clear yellow transparent	-
Specific gravity	0.67	-

### Set time

Test	Results		Units
	7784	7784 + 7797 primer	
Setting time			sec
PE	> 60	3	
PP	> 60	3	
POM	30	5	
PTFE	> 60	5	
Silicon rubber	> 60	3	

### Tensile strength

Test	Results	Units
PE	5.0*	MPa
PP	6.6*	MPa
POM	9.0*	MPa
PTFE	2.5*	MPa
Silicone rubber	0.3*	MPa

\*Material failure

### Shear strength

Materials	7784 + 7797 primer	7784	Units
PE	5.0*	0.3	MPa
PP	6.6*	1.2	MPa
PTFE	2.5	0.3	MPa
Steel	8.2	15.3	MPa
Aluminum	11.8	16.1	MPa
SUS	8.1	15.4	MPa
Brass	7.8	11.5	MPa
Copper	9.6	13.3	MPa
Nickel	6.3	15.7	MPa
Zinc chromate	3.0	8.0	MPa
Hard PVC	6.5*	4.4*	MPa
PC	5.8*	6.9*	MPa
Phenol	6.6*	10.8*	MPa
PA6	6.1*	7.5*	MPa
PA6,6	13.1*	12.0*	MPa
ABS	6.7*	6.3*	MPa
GE	14.6	18.8	MPa
PBT	11.5*	4.5	MPa
PET	9.3*	10.6*	MPa
PPO	2.8	6.8	MPa
PPS	4.6	2.5	MPa
HIPS	4.5*	4.4*	MPa
Acryl	4.6*	8.7*	MPa
Polyacetal	9.0*	1.3*	MPa
NR	0.4*	0.4*	MPa
CR	0.6*	0.6*	MPa
NBR	0.9*	0.8*	MPa
SBR	1.7	1.7*	MPa
EPDM	0.7	0.7	MPa
Silicone Rubber	0.3*	0.3*	MPa

\*Material failure

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**Tensile strength with TB products (MPa)**

TB Product Name	7784 + 7797primer	7784
1701	6.7*	0.5
1724D	5.2*	0.6
1747	7.1*	0.3
1757	6.7*	0.4
1773E	6.1*	0.9
1786	6.8*	0.9
7737	6.7*	0.3
7784	6.6*	1.2

\*Material failure

**Aging tests (MPa)**

Conditions		PE	PP	POM	PTFE	Silicone rubber
80°C	250h	4.7*	6.2*	3.0*	2.5	0.2*
60°C 95%	250h	4.6*	6.6*	2.6*	2.5	0.3*
Heat cycle - 40°C to 60°C	60 cycles	4.9*	6.6*	7.4*	2.5	0.2*

\*Material failure

Conditions	Temp.	PE	PP	POM	PTFE	Silicone rubber
Tap water	40°C	4.8*	6.3*	7.9*	2.5	0.3*
Engine Oil	40°C	4.9*	6.6*	7.9*	2.5	0.2*
Gasoline	25°C	4.2*	6.0*	8.6*	2.5	0.2*
Kerosene	25°C	4.6*	6.2*	7.6*	2.6	0.1*
Methanol	25°C	4.6*	6.6*	7.2*	2.6	0.3*

\*Material failure

**3. Handling**

- Before use, please refer to the safety data sheet.
- Prior to opening the container, let it reach room temperature to avoid condensation inside.
- To obtain optimal results, remove humidity, grease and other impurities from the surfaces to be assembled.

- Depending on the materials (dimensions and surface roughness), apply an appropriate and uniform amount of liquid gasket on the surface, then assemble rapidly.
- The product once transferred into another container should not be returned to the original one. Any excess product should be wiped out using a cloth.
- Keep the product in its original container tightly sealed and store it in a dark, dry and well ventilated place at **10 ~ 25°C**.

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