PERMABOND® MS359 CLEAR
MS Polymer Adhesive
Technical Datasheet

Features & Benefits
- Free from solvents, isocyanates, silicones and PVC compounds, non-corrosive
- Cures at room temperature
- No mixing required
- Crystal clear
- Can be painted after curing
- Suitable for a variety of substrates
- Primer free
- Easy to apply
- Versatile – weather resistant

Description
PERMABOND® MS359 CLEAR is a single-part, moisture curing MS polymer adhesive. It is ideal for use on a wide variety of substrate materials including metals, glass and composites. It is ideal for exterior construction applications as it has excellent resistance to weathering, is non-yellowing and produces a discreet, aesthetically pleasing bond.

Physical Properties of Uncured Adhesive

<table>
<thead>
<tr>
<th>Property</th>
<th>Value</th>
</tr>
</thead>
<tbody>
<tr>
<td>Chemical composition</td>
<td>MS-Polymer</td>
</tr>
<tr>
<td>Appearance</td>
<td>Clear, thixotropic paste</td>
</tr>
<tr>
<td>Viscosity @ 25°C</td>
<td>5rpm: 800,000-1,500,000 mPa.s (cP)</td>
</tr>
<tr>
<td></td>
<td>1rpm: 3,200,000-4,200,000 mPa.s (cP)</td>
</tr>
<tr>
<td>Specific gravity</td>
<td>1.1</td>
</tr>
</tbody>
</table>

Typical Curing Properties

<table>
<thead>
<tr>
<th>Property</th>
<th>Value</th>
</tr>
</thead>
<tbody>
<tr>
<td>Curing mechanism</td>
<td>Humidity</td>
</tr>
<tr>
<td>Skin over time</td>
<td>10-20 minutes</td>
</tr>
<tr>
<td>Cure rate</td>
<td>Approx. 4mm / 24 hours</td>
</tr>
</tbody>
</table>

Typical Performance of Cured Adhesive

<table>
<thead>
<tr>
<th>Property</th>
<th>Value</th>
</tr>
</thead>
<tbody>
<tr>
<td>Shear strength (ISO4587)</td>
<td>Steel: 2-3 MPa (290-440psi)</td>
</tr>
<tr>
<td></td>
<td>Aluminium: 2-3 MPa (290-440psi)</td>
</tr>
<tr>
<td></td>
<td>Zinc: 2-3 MPa (290-440psi)</td>
</tr>
<tr>
<td></td>
<td>PVC: 2-3 MPa (290-440psi)</td>
</tr>
<tr>
<td></td>
<td>Polycarbonate: 1-1.5 MPa (150-220psi)</td>
</tr>
<tr>
<td></td>
<td>Polystyrene: 1-1.5 MPa (150-220psi)</td>
</tr>
<tr>
<td></td>
<td>Wood: 2-3 MPa (290-440psi)</td>
</tr>
<tr>
<td>Tensile strength (ISO37)</td>
<td>0.7-1.5 MPa (100-200psi)</td>
</tr>
<tr>
<td>Elongation at break (ISO37)</td>
<td>80-100%</td>
</tr>
<tr>
<td>Hardness (ISO868)</td>
<td>40-50 Shore A</td>
</tr>
</tbody>
</table>

*Strength results will vary depending on the level of surface preparation and gap.

Hot Strength

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<table>
<thead>
<tr>
<th>Temperature (°C)</th>
<th>% Strength Retained</th>
</tr>
</thead>
<tbody>
<tr>
<td>0</td>
<td>100</td>
</tr>
<tr>
<td>50</td>
<td>50</td>
</tr>
<tr>
<td>100</td>
<td>20</td>
</tr>
<tr>
<td>150</td>
<td>0</td>
</tr>
</tbody>
</table>
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"Hot strength" shear strength tests performed on mild steel. Fully cured then conditioned to pull temperature for 30 minutes before testing. MS359 CLEAR can withstand higher temperatures for brief periods (such as for paint baking and wave soldering processes) providing the joint is not unduly stressed. The minimum temperature the cured adhesive can be exposed to is -40°C (-40°F) depending on the materials being bonded.

The information given and the recommendations made herein are based on our research and are believed to be accurate but no guarantee of their accuracy is made. In every case we urge and recommend that purchasers before using any product in full-scale production make their own tests to determine to their own satisfaction whether the product is of acceptable quality and is suitable for their particular purpose under their own operating conditions. THE PRODUCTS DISCLOSED HEREIN ARE SOLD WITHOUT ANY WARRANTY AS TO MERCHANTABILITY OR FITNESS FOR A PARTICULAR PURPOSE OR ANY OTHER WARRANTY, EXPRESS OR IMPLIED.

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Additional Information

This product is not recommended for use in contact with strong oxidizing materials.

Information regarding the safe handling of this material may be obtained from the safety data sheet (SDS).

Users are reminded that all materials, whether innocuous or not, should be handled in accordance with the principles of good industrial hygiene.

This Technical Datasheet (TDS) offers guideline information and does not constitute a specification.

Surface Preparation

Surfaces should be clean, dry and grease-free before applying the adhesive. Use a suitable solvent (such as acetone or isopropanol) for the degreasing of surfaces. Some metals such as aluminium, copper and its alloys will benefit from light abrasion with emery cloth (or similar), to remove the oxide layer.

Directions for Use

1) Surfaces must be clean, dry and grease-free prior to bonding.
2) Use a caulking gun to dispense adhesive directly from cartridge.
3) If it is hard to extrude, warming the cartridge will reduce the viscosity and allow easier dispensing.
4) The adhesive can be spread with a spatula if required.

Video Links

Surface preparation:
https://youtu.be/8CMOMP7hXjU

MS Polymer directions for use:
https://youtu.be/mie4Oqq4wtM

Other Products Available

Anaerobics
- Thread lockers
- Thread sealants
- Gasket makers
- Sealants / retainers

Cyanoacrylates
- Instant adhesives
- For rapid bonding of metals, plastics, rubber and many other materials

Epoxies
- Two-part room temperature cure adhesives
- Single-part heat cure adhesives
- Modified Technology (MT) flexible grades available

MS-Polymers
- Single-part, moisture-curing, flexible sealants

Polyurethanes
- Two-part room temperature curing adhesives

Toughened Acrylics
- Rapid curing, high strength structural adhesives

UV Light Cured Adhesives
- Glass / plastic bonding
- Optically clear
- Non-yellowing

Storage & Handling

| Storage Temperature | 5 to 25°C (41 to 77°F) |

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