

Permabond®

Composite Bonding Adhesives

ISO 9001 Certified
"Our Science ... Your Success"

Permabond offers a wide range of different adhesive technologies for bonding composites. Whether you require a rapid cure in seconds or several hours to assemble parts, Permabond can help you find a bonding solution.

Permabond® Adhesive Features & Benefits

Existing Permabond adhesive users already enjoy many of the following benefits over mechanical fasteners:

- Cost savings
- Component weight reduction
- Improved stress distribution
- Improved appearance
- Faster manufacturing process
- Eliminates pre-drilling & prevents leaks
- Helps prevent corrosion
- Wider choice of substrate materials
- Better noise and vibration absorption
- Low shrinkage - no show-through marks

Ideal for bonding:

ABS

Acrylic

Alucobond

Aluminium

Carbon Fibre

Ceramic & Stone

Composite

Ferrite

FRP & GRP

Glass

Laminate

Nylon

Phenolic

Polycarbonate

Polyethylene*

Polypropylene*

Polystyrene

SMC

Steel

Wood

Zinc

+Many more materials

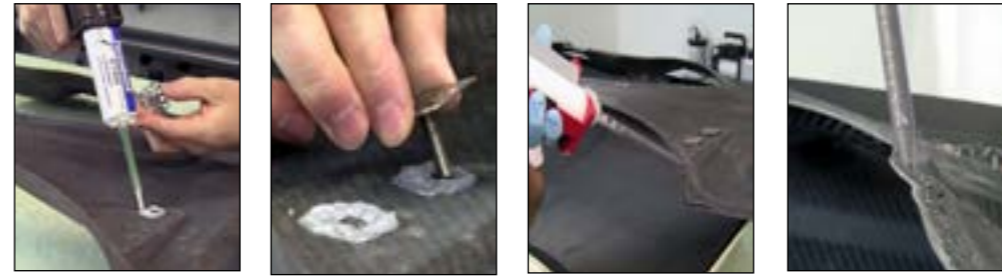
*Special grades only on untreated



Permabond
Engineering Adhesives

Permabond Adhesives for Composites

Here is a small selection of our most popular adhesive grades suitable for use in a range of composite bonding applications. If you can't see exactly what you require, please contact our technical advisors with information about your application and your particular requirements and we will make a recommendation. The Permabond team provides support through the design phase, sample trials and production line integration. Whether you require technical support, custom formulations or small batch production, please contact us.



Permabond two part epoxy is used to bond fasteners to a carbon fibre car bonnet and Permabond PT326 bonds the 2 skins of a carbon fibre car bonnet together.

Composite Bonding Product Data

Technical Information	737	ES569	ET515	ET5401	ET5428	ET5429	MT382	MT3821	PT326	PT328	TA4246	TA4210	TA4810	
Features	Toughened, impact resistant single part cyanoacrylate.	Thick epoxy paste, ideal for bonding carbon fibre where vertical application or gap filling is required.	Flexible epoxy with excellent impact and vibration resistance. Ideal for use on sensitive composites (such as foams).	High temperature resistant epoxy. Ideal for applications where clamping or jiggling during heat cure is not possible.	Toughened epoxy with rapid strength development.	Toughened epoxy ideal for applications where high temperatures may be experienced.	Low viscosity, self levelling, soft, slightly flexible modified epoxy product.	Highly flexible modified epoxy adhesive with a Shore A hardness of 50.	2-Part polyurethane adhesive ideal for bonding composites such as carbon fibre and interior trim	As PT326 but with longer pot life.	Toughened, rapid cure, good adhesion to a wide variety of surfaces.	Toughened, gap filling, 1:1 mix ratio, easy to apply. Ideal for bonding clips, hinges and brackets.	Toughened, gap filling, 1:1 mix ratio, easy to apply. Ideal for bonding clips, hinges and brackets.	
Colour	Black	Black	Clear / colourless	Grey	Charcoal-black or cream version available*	Charcoal black	Charcoal black	Charcoal black	Grey	Grey	Amber	Cream	Cream	
Viscosity (mPa.s = cP)	2,000-4,000	250,000-500,000 Thixotropic Paste	Mixed: 12,000-22,000	Thixotropic paste	Thixotropic paste	Thixotropic paste	Mixed: 13,000-30,000	Thixotropic paste	Mixed: 3,500-7,000	Mixed: 3,500-7,000	28,000	Mixed: 45,000	Mixed: 175,000	
Maximum gap fill (mm) in	(0.5) 0.02	(5.0) 0.2	(2.0) 0.08	(5.0) 0.2	(5.0) 0.2	(5.0) 0.2	(0.5) 0.02	(5.0) 0.2	(5.0) 0.2	(5.0) 0.2	(0.5) 0.02	(4.0) 0.16	(2.0) 0.08	
Handling time (steel)	15-20 sec.	Full strength 60 minutes at 150°C	20-30 min.	60-90 min.	30-45 min.	6-10 hrs	105-120 min.	60-90 min.	60-90 min.	90-120 min.	2-4 min.	30-35 min.	20-30 min.	
Full strength (cured at 23°C)	24 hours		72 hours	4-7 days	24-48 hrs	72 hrs	72 hrs	>72 hrs	4-5 days	4-5 days	24 hrs	24 hrs	24 hrs	
Shear strength (MPa) psi	Steel	(19-23) 2,800-3,300	(27-41) 4,000-6,000	(8-12) 1,200-1,750	(20-30) 2,900-4,350*	(18-22) 2,600-3,200	(18-22) 2,600-3,200	(4-7) 600-1,000	(4-7) 600-1,000	(12-20) 1,700-2,900	(12-18) 1,700-2,600	(33-35) 4,800-5,100	(23-25) 3,300-3,600	(21-28) 3,000-4,000
	FRP-glass polyester	N/A	(3-5) 400-700	(6-8) 900-1,200*	(6-9) 900-1,300	(7-10) 1,000-1,450	(5-7) 400-700	(5-7) 400-700	(5-7) 400-700	(5-7) 400-700	(5-7) 400-700	(6-8) 600-1,200	(5-7) 400-700	(4-6) 600-900
	FRP-glass epoxy	(9-11) 1,300-1,600	(4-6) 600-900	(19-23) 2,800-3,300*	(24-28) 3,500-4,000	(14-18) 2,000-2,600	(5-7) 400-700	(5-7) 400-700	(12-14) 1,700-2,000	(12-14) 1,700-2,000	(9-11) 1,300-1,600	(9-11) 1,300-1,600	(13-15) 1,900-2,200	
	Carbon fibre	(10-12) 1,450-1,700	(4-6) 600-900	(22-24) 3,200-3,500*	(20-38) 2,800-5,500	(20-37) 2,900-5,400	(6-8) 600-1,200	(6-8) 600-1,200	(9-11) 1,300-1,600	(9-11) 1,300-1,600	(18-22) 2,600-3,200	(14-16) 2,000-2,300	(9-11) 1,300-1,600	
Peel strength (N/25mm) PIW	(40-60) 9-13	(100-120) 22-26	(70-90) 16-20	(140-160) 31-35*	(150-250) 33-55	(150-230) 33-51	(140-160) 31-36	(140-160) 31-36	(150-170) 33-38	N/A	(150-180) 33-40	(200-300) 44-67	(70-90) 15-20	
Service temperature range (°C)*F	(-55 to +120) -65 to +250	(-40 to +180) -40 to +356	(-55 to +100) -65 to 215	(-40 to +140,180 peak) -40 to +284, 356 peak	(-40 to +120) -40 to +250	(-40 to +120) -40 to +250	(-40 to +120) -40 to +250	(-40 to +120) -40 to +250	(-40 to +120) -40 to +250	(-40 to +120) -40 to +250	(-40 to +120) -40 to +250	(-40 to +120) -40 to +250	(-40 to +120) -40 to +250	
Availability	Worldwide	Worldwide	Worldwide	Worldwide	Worldwide	Worldwide	Worldwide	Worldwide	Worldwide	Worldwide	Worldwide	Europe, Middle East	Americas	

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

* Product cured at 80°C for 1 hour.

Permabond bonds composites in many industry sectors:

- Aerospace
- Automotive
- Boat Building
- Buildings
- Buses
- Partitioning
- Shopfitting
- Sports Equipment
- Street Furniture
- Trains & Trams
- Wind Turbines



Application: Bonding marble honeycomb panels



- Bonding thin marble sections to honeycomb composite for use as worksurfaces in kitchens and bathrooms on yachts, motor homes, caravans and aeroplanes.
 - If colour-matched product is required, Permabond's chemists can produce custom formulations.
- Adhesive used: Permabond ET5429



Application: Bonding aircraft seat trays

Bonding ABS, plastic laminate and aluminium seat tray construction together. ET515 was selected due to its excellent impact and vibration resistance, quick cure and most importantly it doesn't attack any of the sensitive substrate materials.

Benefits of Permabond ET515

- Rapid-curing
- Non-flammable
- Flexible, good impact resistance
- Easy application process
- Clear appearance gives an aesthetically good finish.

Adhesive used: Permabond ET515

Permabond®

Composite Bonding Adhesives

ISO 9001 Certified
"Our Science ... Your Success"

Adhesives for • Design • Manufacturing • Assembly • Maintenance • Repair & Overhaul

Permabond's history of developing and manufacturing engineering adhesives spans four decades and three continents. Today, Permabond Engineering Adhesives Ltd (Europe & Asia) and Permabond LLC (Americas) provide technological solutions to engineers all over the world, with offices and facilities in America, Asia and Europe.

ISO 9001:2008



- **Technical** – Our chemists and technicians are available to provide application assistance, custom formulation, in-house prototype testing, joint product development programs and much more.

- **Training** – Permabond's knowledgeable sales group will provide your staff with the information they need to maximize the efficiencies, cost savings, and safety benefits Permabond products generate.

- **Sales** – From preliminary project appraisals and product needs assessments through to process reliability analysis, Permabond's knowledgeable sales group will support you from product concept through to production.

This brochure contains information on our most popular products, if you don't see exactly what you need, or would like assistance in selecting the best product for your application, please contact us:

www.permabond.com

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Distributor Stamp

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 datasheet for most recent and accurate technical information.