PERMABOND® TA4522
Toughened Acrylic Adhesive
Provisional Technical Datasheet

Features & Benefits
- Excellent adhesion to plastics
- Fast cure at room temperature
- Easy to dispense
- High shear and peel strength
- Low odour
- Low viscosity
- Non-flammable

Description
PERMABOND® TA4522 is a low-odour 2-part, 1:1 toughened acrylic adhesive. It can be used to bond a wide variety of materials including plastics, GRP, ceramics, wood, metal and other substrates. It is convenient to use in an easy-to-dispense cartridge with mixing nozzle or can be applied bead-on-bead* without static mixer. This product’s non-aggressive formulation helps minimize the chance of stress cracking in sensitive plastics.

Physical Properties of Uncured Adhesive

<table>
<thead>
<tr>
<th></th>
<th>TA4522 A</th>
<th>TA4522 B</th>
</tr>
</thead>
<tbody>
<tr>
<td>Chemical composition</td>
<td>Urethane methacrylate</td>
<td>Urethane methacrylate</td>
</tr>
<tr>
<td>Colour</td>
<td>White</td>
<td>Green/Blue</td>
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<tr>
<td>Mixed colour</td>
<td>Green</td>
<td></td>
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<tr>
<td>Viscosity @ 25°C</td>
<td>20 rpm: 3,000-6,000 mPa.s (cP)</td>
<td>20 rpm: 3,000-6,000 mPa.s (cP)</td>
</tr>
<tr>
<td>Specific gravity</td>
<td>1.1</td>
<td>1.1</td>
</tr>
</tbody>
</table>

Typical Curing Properties

- Ratio of use: 1:1
- Maximum gap fill: 0.5 mm (0.02 in) with nozzle 0.2 mm (0.008 in) bead on bead
- Nozzle life @23°C: 4-7 minutes
- Fixture / handling time (0.3 N/mm² shear strength is achieved) @23°C: 10-15 minutes*
- Tack free time**: <12 hours
- Full cure @23°C: 24-48 hours

*If applying bead-on-bead, fixture time and strength performance may be variable depending on the application.

**To achieve a tack-free finish, a static mixing nozzle should be used.

Typical Performance of Cured Adhesive

<table>
<thead>
<tr>
<th></th>
<th>PVC: 4-5 N/mm² (580-730 psi)</th>
<th>Polycarbonate: 4-6 N/mm² (580-870 psi)</th>
<th>PMMA: 2-3 N/mm² (290-440 psi)</th>
<th>Polyamide: 2-3 N/mm² (290-440 psi)</th>
<th>ABS: 2-3 N/mm² (290-440 psi)</th>
<th>Phenolic: 3-6 N/mm² (440-870 psi)</th>
<th>Steel: 21-23 N/mm² (3000-3300 psi)</th>
<th>Aluminium: 14-16 N/mm² (2000-2300 psi)</th>
</tr>
</thead>
<tbody>
<tr>
<td>Shear strength</td>
<td>(ISO4587)*</td>
<td></td>
<td></td>
<td></td>
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<td></td>
<td></td>
</tr>
<tr>
<td>Hardness (ISO868)</td>
<td>70-75 Shore D</td>
<td></td>
<td></td>
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</tr>
</tbody>
</table>

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

Graph shows typical strength development of bonded components at 23°C. Curing at higher or lower temperatures may affect cure speed.

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Surface Preparation
Surfaces should be clean, dry and grease-free before applying the adhesive. Permabond Cleaner A is recommended for the degreasing of most 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.
2) Either:
   a) Apply a thin bead of adhesive pre-mixed through a static mixer nozzle.
   b) Alternatively, apply bead on bead – one bead of adhesive on top of the other
   c) Or, apply A component to one side and B component to the other
Applying adhesive side by side is not advisable as this may not achieve adequate mixing.
3) Assemble components and clamp.
4) Maintain pressure until handling strength is achieved. The time required will vary according to the joint design and surfaces being bonded.
5) Allow 24-48 hours for adhesive to fully cure.

Additional Information
This product is not recommended for use in contact with strong oxidizing materials. This product may affect some thermoplastics and users must check compatibility of the product with such substrates.
Information regarding the safe handling of this material may be obtained from the Safety Data Sheet.

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.

Storage & Handling

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

Video Links
Surface preparation: https://youtu.be/8CMOMP7hXjU
Structural acrylic directions for use: https://youtu.be/edvBe4iYNCY

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**Hot Strength**

“Hot strength” shear strength tests performed on mild steel. Product fully cured at room temperature and conditioned to pull temperature for 30 minutes before testing.

TA4522 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 -55°C (-65°F) depending on the materials being bonded.

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