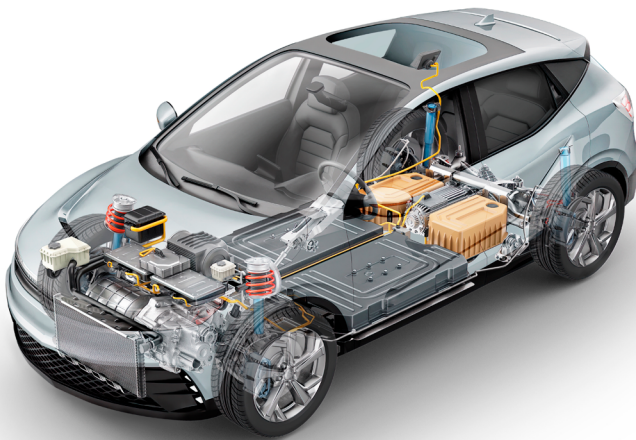
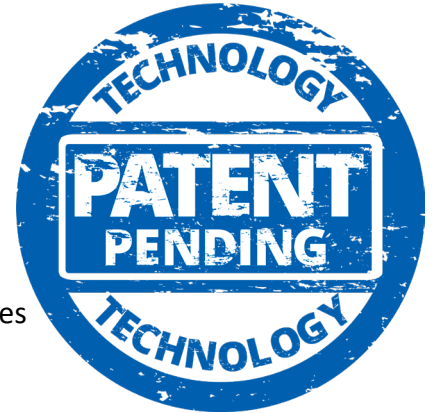


Permabond TA4660 - Nylon Bonder

Permabond TA4660 is a two-part structural adhesive ideal for bonding filled and unfilled nylon. No primer or surface pretreatment is needed to form bonds that exceed the strength of the nylon. This 2:1 mix ratio, low odor, room temperature curing adhesive also bonds metals.

Permabond® TA4660 Features & Benefits

- Cutting-edge technology – patent pending
- High-strength adhesion to filled and unfilled nylon
- Great adhesion to metals such as steel and aluminum
- Excellent chemical and thermal resistance
- Full cure at room temperature
- Packaged in cartridges – easy to dispense and mix via mixing nozzle
- Tough – handles thermal expansion & contraction between dissimilar surfaces



Permabond® TA4660 is Ideal for:

- Automotive housings
- EV battery pack sealing
- Electronics, sensors
- Profile, pultrusion & stiffener bonding
- Sports equipment manufacture

Ideal for bonding:

Aluminum

Glass-filled nylon

Nylon 6

Nylon 6,6

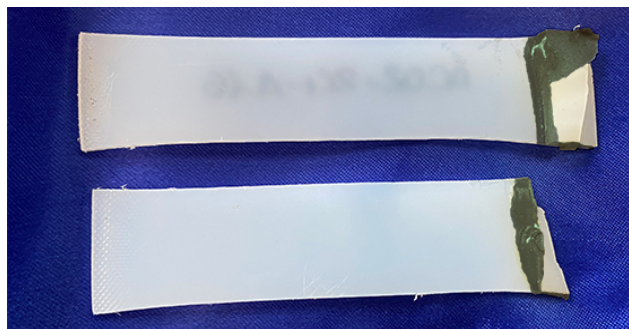
Mild steel

+ many more



Product Data: Page 2

Permabond TA4660



The image above shows the adhesive bond is so strong that the nylon deforms and breaks.



	TA4660
Description	Two-part structural adhesive designed for use on filled & unfilled nylon surfaces
Appearance	A side: Yellow / B side: Black / Mixed: Green-black
Mix Ratio	2:1
Gap fill (max)	1 mm (0.04 in)
Features	Excellent adhesion to nylon / Full cure at room temperature / Microbeads for a controlled bond line / No primer required / Low odor / Good temperature resistance
Pot life	5 minutes
Fixture time	25 minutes
Handling time	90 minutes
Working strength	2 hours
Full strength	48 hours
Shear strength	PA6: >10 N/mm ² (>1450 psi) Substrate Failure PA6,6: >6 N/mm ² (>870 psi) Substrate Failure PA6 30% GF: 14-18 N/mm ² (2030-2610 psi) Mild Steel to PA6,6: >10 N/mm ² (>1450 psi) Substrate Failure Aluminium to PA6,6: >10 N/mm ² (1450 psi) Substrate Failure
Tensile strength	20 N/mm ² (2900 psi)
Elongation	11%
Temperature	-40 to +120°C (-40 to + 250°F)
Packaging	10 x 50ml pack of cartridges / 6 x 400ml pack of cartridges

The above technical data for Permabond TA4660 is a guideline and does not constitute a specification.
Additional technical information can be found on the technical data sheet on www.permabond.com.

www.permabond.com

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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 datasheet for most recent and accurate technical information.