

Permabond TA436 is a two-component structural acrylic adhesive. It is a no-mix system which cures in 1-3 minutes when the resin and activator come into contact. It is suitable for bonding metals, ceramics, glass, wood, hard plastics and is highly resistant to impact, peeling and tensile stresses.

Physical Properties

	TA436A	Activator 43
Chemical type	Urethane methacrylate	Methacrylate ester
Colour	Amber	Green
Viscosity	17,000 mPa.s	5-10 mPa.s
Flashpoint	87°C	87°C
Density	1.1	1.0
Ratio of use	Not critical; approximately 100:15	

Typical Performance

Gap fill		Up to 0.5mm
Fixture time		1-3 minutes
Working strength		30-60 minutes
Full strength		24 hours
Shear strength	DIN 53283	25 MPa (steel)
Peel strength	ISO4578	5 N/25mm
Tensile strength	DIN 53288	25 MPa
Impact strength	ASTM D-950	25 Nmm/mm ²
Coefficient of thermal expansion	ASTM D-696	80 x 10 ⁻⁶ 1/K
Thermal conductivity	ASTM C-177	0.1 W/m ² K
Dielectric constant	ASTM D-150	4.6 Mhz
Dielectric strength	ASTM D-149	30-50 KVmm
Volume resistivity	ASTM D-257	2 x 10 ¹³ Ohm.cm
Service temperature*		-30 to +150°C

*Higher temperatures may be endured for short periods providing the parts are not unduly stressed.

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.

Adhesive Application

- Surfaces must be clean, dry and grease-free prior to bonding.
- Apply TA436 to one surface and Activator 43 to the other.
- Assemble parts.
- Maintain pressure until handling strength is achieved. The time required will vary according to the joint design and surfaces being bonded.
- Allow 24 hours for adhesive to fully cure. Accelerated cure times may be achieved by heating.

Storage and Handling

Storage Temperature	+5 to 25°C
Shelf Life Stored in original unopened containers	12 months (in containers smaller than 1 litre size)

Users are reminded that all materials, whether innocuous or not, should be handled in accordance with the principles of good industrial hygiene. Full information can be obtained from the Material Safety Data Sheet.

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