

Permabond®

Adhesive for Metal Fabrication

ISO 9001:2015 Certified
"Our Science ... Your Success"

Advances in adhesive technology allow designers to eliminate mechanical fasteners and welding without sacrificing structural integrity or strength. Driving factors for specifying adhesives are increasing strength and durability of products while reducing costs.

Fasteners and spot welding can create stress concentration points. Adhesives distribute stress across the entire bond joint increasing the resistance to fatigue while preventing corrosion. Flexible adhesives absorb stress caused by flexing, vibration, impact, and thermal expansion, further reducing fatigue.

Permabond® Adhesive Features & Benefits

- Increase strength
- Increase durability
- Reduce costs
- Reduce weight
- Distribute stress
- Increase fatigue resistance
- Absorb stress
- Reduce vibration noise
- Prevent corrosion
- Improve aesthetics
- Increase assembly speed
- Reduce production costs
- Join dissimilar materials such as metals, plastics, and composites

Ideal for bonding:

Aluminum

Bronze

Copper

Ferrite

Gold

Lead

Nickel

Platinum

Rare earth

Silver

Stainless steel

Steel

Titanium

Various alloys

Wrought iron

Zinc

As well as bonding:

Composite

Glass

Plastic

Rubber



chemical-concepts.com

800.220.1966

410 Pike Road • Huntingdon Valley, PA 19006



Permabond®
Engineering Adhesives

Permabond Adhesives for Fabrication

Description/Application	Product	Technology	Temperature Resist		Viscosity cP= mPa.s	Gap fill mm (in) when bonding	Fixture time	Shear Strength Grit Blasted Steel N/mm ² (psi)
Removable threadlocker	MM115	Anaerobic	-54°C (-65°F)	150 °C (300 °F)	1,300 cP Thixotropic	0.15 (0.006)	10 mins	10 (1,450)
Permanent threadlocker	HM128	Anaerobic	-54°C (-65°F)	150 °C (300 °F)	500 cP	0.15 (0.006)	15 mins	17 (2,500)
Retaining compound	HM162	Anaerobic	-54°C (-65°F)	200 °C (390 °F)	1,000 cP	0.2 (0.008)	5 - 8 mins	28 - 31 (4,000 - 4,500)
Bonding prior to paint bake	ET5401	2-Component Epoxy with heat cure	-40°C (-40°F)	140°C (285°F)*	Thixotropic Paste	5.0 (0.20)	60 - 90 mins	20 - 30* (2,900-4,400)*
Fast, clear, excellent general purpose epoxy	ET500	2-Component Epoxy	-40°C (-40°F)	80°C (175°F)	18,000 cP	2.0 (0.08)	5 - 8 mins	12 - 18 (1,700 - 2,600)
FDA Compliant formulation for food contact	ET5147	2-Component Epoxy	-40°C (-40°F)	120°C (250°F)	Thixotropic Paste	2.0 (0.08)	16 hrs @ 23°C 30 mins @ 60°C	18 - 20 (2,600 - 2,900)
Ideal for high temperature resistant metal bonding	ES5504	Heat Cure Epoxy	-40°C (-40°F)	275°C (525°F)	Paste	2.0 (0.08)	N/A	18 - 22 (2,600 - 3,200)**
No sag or flow during cure	ES569	Heat Cure Epoxy	-40°C (-40°F)	180°C (355°F)	375,000 cP	5.0 (0.20)	N/A	27- 41 (4,000 - 6,000)
Surface activated with Initiator 43	TA436	Structural Acrylic	-54°C (-65°F)	150°C (300°F)	20rpm: 25,000 2.5rpm: 60,000 cP	0.5 (0.02)	1 - 3 mins	15 - 25 (2,200 - 3,600)
Use as single component or with initiator 41 for increased cure speed.	TA437	Structural Acrylic	-54°C (-65°F)	200°C (390°F)	20rpm: 40,000 2.5rpm: 130,000	0.5 (0.02)	5 - 10 mins or 20-30 secs with Initiator 41	14 - 20 (2,000 - 3,000)
Use with Initiator 46, very high strength	TA4246	Surface Activated Methyl methacrylate	-40°C (-40°F)	120°C (250°F)	28,000 cP	0.5 (0.02)	2 - 4 mins	33 - 35 (4,800 - 5,100)
Two component, thixotropic, non-sag.	TA4810	2 component Methyl methacrylate	-40°C (-40°F)	120°C (250°F)	175,000 cP	2.0 (0.08)	20 - 30 mins	21 - 28 (3,000 - 4,000)
Transparent, cures very soft, Shore A 50, no read through	MS359 Clear	MS Polymer	-40°C (-40°F)	100°C (212°F)	Non-sag, Paste	potting	skin over time 10 - 20 mins	2 - 3 (290 - 430)
Non-sag, strong bonds to metal, plastic, and composite. Cured material remains soft and flexible, no read through.	MT3821	Modified epoxy	-40°C (-40°F)	120°C (250°F)	Thixotropic Paste	5.0 (0.20)	60 - 90 mins	4 - 7 (600 - 1,000)
Extended pot life allows covering large areas.	PT328	2- Component Urethane	-40°C (-40°F)	120°C (250°F)	5250 cP	5.0 (0.20)	pot life 15 - 20 mins	12 - 18 (1,700 - 2,600)
The Original! General purpose metal bonding	910	Cyanoacrylate	-54°C (-65°F)	90°C (195°F)	80 cP	0.15 (0.006)	10 -15 secs	23 - 29 (3,300-4,200)
Ideal for bonding metal name tags and labels to fabricated housings and equipment.	2011	Cyanoacrylate	-54°C (-65°F)	120°C (250°F)	Thixotropic Gel	0.5 (0.02)	5 - 10 secs	20 - 24 (2,900 - 3,500)

*Heat cure increases temperature resistance to values stated

**Aluminum

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

Above is only a small sampling of products. If you don't see the exact product you are looking for, or need more in depth technical information, Permabond's technical team would be more than happy to help. Contact us at info.americas@permabond.com or 800- 714- 0170.

www.permabond.com

- **US Helpline - 800-640-7599**
- **UK - 0800 975 9800**
- **Asia + 86 21 5773 4913**
- **General Enquiries +44(0)1962 711661**
- **Deutschland 0800 101 3177**
- **France 0805 111 388**

info.europe@permabond.com
info.americas@permabond.com
info.asia@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 data sheet for most recent and accurate technical information.

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