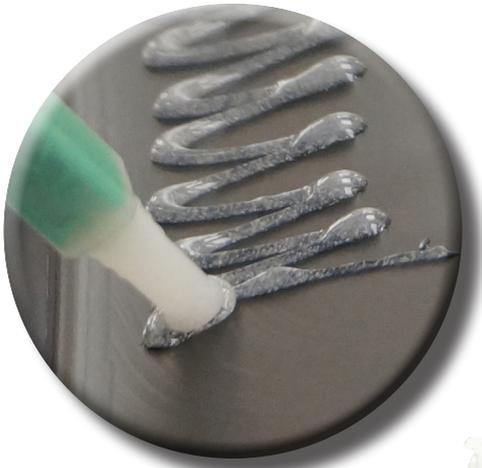


## Polyolefin Bonding Structural Acrylics

The Permabond TA46XX range has been developed to bond untreated polyolefin surfaces. These adhesives are ideal for bonding **polypropylene and polyethylene** - without the need to carry out costly surface pre-treatment before bonding. They can also be used to bond polyolefins to a wide variety of other substrate materials.



**Ideal for bonding:**

Composites

E- Coatings

EPDM

HDPE

LDPE

Most metals

Polyethylene

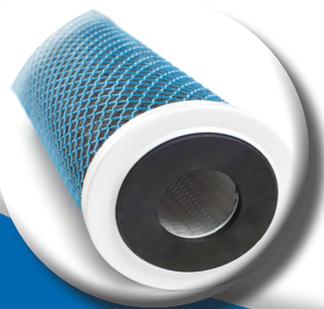
Polypropylene

PTFE

### Permabond® TA46XX range Features & Benefits

- Bonds low surface energy plastics
- No need to flame, corona or plasma treat surfaces before bonding = cost & process saving
- No primer required
- Ideal for bonding a wide range of surfaces
- Some strength on PTFE (Teflon)
- Easy 1:1 mix ratio - can be manually applied or used with automatic dispensing equipment
- Non-hazardous for transport = easier shipping & storage
- Full cure at room temperature
- Good impact strength
- Good chemical resistance

*Polypropylene lap shears bonded with TA4610 - the adhesive bond is so strong the plastic stretches, deforms and suffers failure before the joint.*



# Polyolefin Bonding Structural Acrylics

This table represents a small selection of Permabond adhesives. For more detailed technical information and product Safety Data Sheets, visit [www.permabond.com](http://www.permabond.com). To discuss your specific application requirements, call the Permabond Helpline and our technical advisors will recommend the best adhesive for you.

## Product Data

Grade	TA4605	TA4610	TA4611	TA4620**	TA4630	TA4631
Appearance	A: Off-white B: Almost colourless Mixed: Off-white	A: Off-white B: Almost colourless Mixed: Off-white	A: White B: Transparent Mixed: Off-white	A: Off white B: Colourless Mixed: Off-white	A: Black B: Transparent Mixed: Black	A: White B: White Mixed: White
Features	Fast cure. CoSHH friendly	Fast cure for large components	Smaller gap fill (no micro beads)	Slow cure for large surface areas	No odour*	No odour*, smaller gap fill (no micro beads)
Viscosity @ 25°C	Mixed: 125,000 mPa.s	Mixed: 210,000 mPa.s	Mixed: 21,500 mPa.s	Mixed: 125,000 mPa.s	Mixed: 210,000 mPa.s	Mixed: 21,500 mPa.s
Mix Ratio	1:1	1:1	1:1	1:1	1:1	1:1
Fixture Time	5-10 minutes	12-15 minutes	10-16 minutes	20-25 minutes	12-18 minutes	12-18 minutes
Handling Time	20-25 minutes	40-50 minutes	40-50 minutes	60-90 minutes	40-50 minutes	40-50 minutes
Working Strength	2-4 hours	6-8 hours	6-8 hours	24- 72 hours	6-8 hours	6-8 hours
Shear Strength	Polypropylene: >8 N/mm <sup>2</sup> SF* Polyethylene: >7 N/mm <sup>2</sup> SF*					
Service Temp	-55 to +100°C					
Packaging (Cartridges)	10 x 50ml	10 x 50ml	15 x 25ml & 10 x 50ml	10 x 50ml	10 x 50ml	15 x 25ml & 10 x 50ml
	6 x 400ml					
	Bulk on request					
Storage	5-25°C	5-25°C	5-25°C	2-7°C	5-25°C	5-25°C

SF\* = Substrate Failure / \*\*Please note: Full Cure takes 7 days. For full technical information, please refer to product data sheet / No odour\* = no perceptible odour detected by testing panel members



Distributor Stamp

Scan here or type "YouTube Permabond" in your chosen search engine; to watch our demo videos.



[www.permabond.com](http://www.permabond.com)  
[www.permabond.co.uk](http://www.permabond.co.uk)

- 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](mailto:info.europe@permabond.com)  
[info.americas@permabond.com](mailto:info.americas@permabond.com)  
[info.asia@permabond.com](mailto:info.asia@permabond.com)

Wessex Business Park  
Wessex Way  
Colden Common  
Winchester  
Hampshire  
SO21 1WP  
United Kingdom