

### Features & Benefits

- Adhesion to a wide variety of substrates
- Fast cure at room temperature
- Easy to apply through static mixer nozzle
- High shear and peel strength
- Good impact strength
- Good chemical resistance

### Description

**PERMABOND TA4300** is a 2-part, 1:1 toughened acrylic adhesive. Its toughening makes it ideal for bonding dissimilar materials where differential thermal expansion and contraction could be an issue. It cures rapidly at room temperature and has good gap filling properties. It is ideal for use on a variety of metals and gives particularly high bond strength on aluminium surfaces.

### Physical Properties of Uncured Adhesive

	TA4300 A	TA4300B
Chemical composition	Methyl methacrylate	Methyl methacrylate
Appearance	Off-white	Brown
Viscosity @ 25°C	Thixotropic paste	Thixotropic paste
Density	1.05	1.05

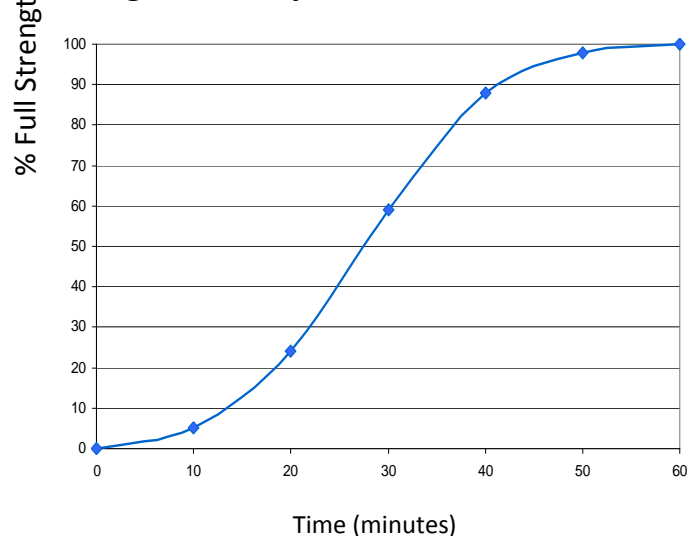
### Typical Curing Properties

Ratio of use	1 : 1
Maximum gap fill	2 mm (0.08 in)
Handling time	5 - 10 minutes
Working strength	15 - 30 minutes
Full cure	24 hours

### Typical Performance of Cured Adhesive

Shear strength (mild steel)	20-22 N/mm <sup>2</sup> (2900-3200 psi)
Peel strength (ISO 4578)	150-180 N/25mm (33-40 PIW)
Tensile strength (DIN53288)	22-24N/mm <sup>2</sup> (3200-3500 psi)
Coefficient of thermal expansion (ASTM D-696)	80 x 10 <sup>-6</sup> 1/K
Thermal conductivity (ASTM C-177)	0.1 W/(m.K)
Dielectric constant (ASTM D-150)	4.6 MHz
Dielectric strength (ASTM D-149)	30-50 kV/mm
Volume resistivity (ASTM D-257)	2 x 10 <sup>13</sup> Ohm.cm

### Strength Development

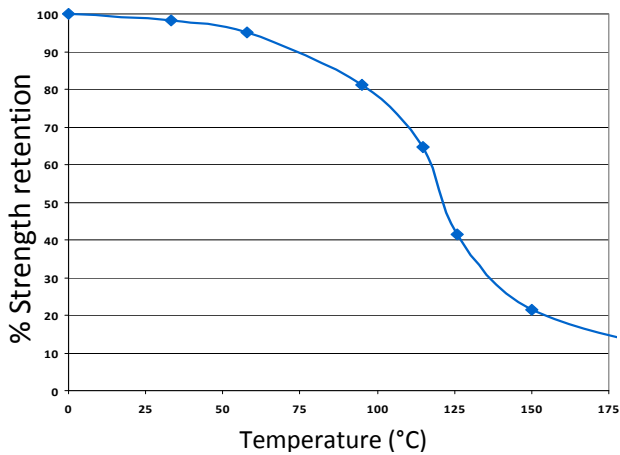


Graph shows typical strength development of bonded components at 23°C. An increase of 8°C in temperature will halve the cure time. Lower temperatures will result in a slower cure time.

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## Temperature Resistance



TA4300 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 -40°C (-40°F) depending on the materials being bonded.

## Adhesion to Various Substrates

ABS	2.8 MPa
Aluminium	20 MPa
Galvanised steel	2.8 MPa
High impact polystyrene	<1 MPa
Mild steel	21 MPa
Nylon	2.6 MPa
Perspex	5.2 MPa
Polycarbonate	3.5 MPa (substrate failure)
Stainless steel	19 MPa
Zintec	11 MPa

## 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 material safety data sheet (MSDS).

Users are reminded that all materials, whether innocuous or not, should be handled in accordance with the principles of good industrial hygiene.

## 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 prior to bonding.
- 2) Apply a thin bead of adhesive pre-mixed through a static mixer nozzle.
- 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 hours for adhesive to fully cure. Accelerated cure times may be achieved by heating.

## Storage & Handling

Storage Temperature	5 to 25°C (41 to 77°F)
Shelf Life Stored in original unopened containers	6 months, 12 months if refrigerated

### Contact Permabond:

**Europe:** Tel. +44 (0)1962 711661  
 UK Helpline: 0800 975 9800  
 Deutschland: 0800 10 13 177  
 France: 0805 11 13 88  
 info.europe@permabond.com

**US:** Tel. +1 732-868-1372  
 Helpline: 800-640-7599  
 info.americas@permabond.com  
**Asia:** Tel. +86 21 5773 4913  
 info.asia@permabond.com

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

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