

### Features & Benefits

- Adhesion to a wide variety of substrates
- Fast cure at room temperature
- No mix application
- High shear and peel strength
- Good impact strength
- High temperature resistance

### Description

**PERMABOND TA436** is a structural acrylic adhesive designed primarily for bonding metals, ferrites, ceramics and some thermoplastics. **Permabond TA436** is a no-mix system which obtains handling strength 1-3 minutes when the adhesive and the **Initiator 43** come in contact.

**Permabond TA436** offers high shear and impact resistant bonds and improved high temperature resistance.

### Physical Properties of Uncured Adhesive

Chemical composition	Modified acrylic (solvent free)
Appearance	Amber liquid
Viscosity @ 25°C	16,000 - 18,000 mPa.s (cP)
Density	1.1

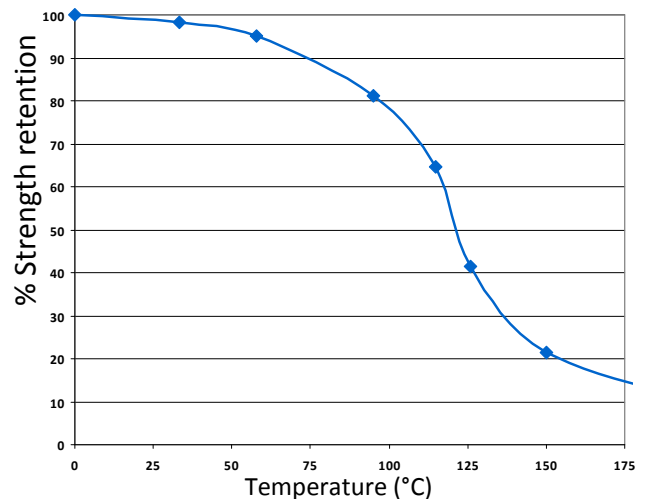
### Typical Curing Properties

Maximum gap fill	0.5 mm (0.02")
Handling time	1-3 minutes
Working strength	30-60 mins
Full cure	24 hours

### Typical Performance of Cured Adhesive

Shear strength (mild steel)	15-25 N/mm <sup>2</sup> (2200-3600 psi)
Peel strength (ISO 4578)	45-65 N/25mm (10-14 PIW)
Tensile strength (DIN53288)	25N/mm <sup>2</sup> (4350 psi)
Impact strength (ASTM D-950)	25 Nmm/mm <sup>2</sup>
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 kVmm
Volume resistivity (ASTM D-257)	2 x 10 <sup>13</sup> Ohm.cm

### Temperature Resistance



TA436 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 -55°C (-65°F) depending on the materials being bonded.

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No representative of ours has any authority to waive or change the foregoing provisions but, subject to such provisions, our engineers are available to assist purchasers in adapting our products to their needs and to the circumstances prevailing in their business. Nothing contained herein shall be construed to imply the non-existence of any relevant patents or to constitute a permission, inducement or recommendation to practice any invention covered by any patent, without authority from the owner of this patent. We also expect purchasers to use our products in accordance with the guiding principles of the Chemical Manufacturers Association's Responsible Care® program.

## Temperature Resistance

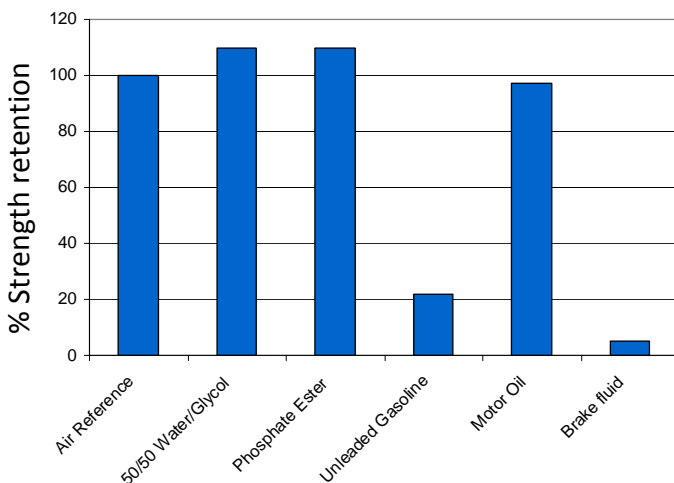
All values were generated on as received steel lap shears as described in ASTM D 1002.

Adhesive was cured at room temperature for 48 hours prior to environmental exposure. Test pieces were assembled with no induced gap and subjected to continuous exposure for 1000 hours at the testing temperature and then the shear strength was tested at room temperature.

1000 hours @	% strength retention
95°C	110% *
120°C	118% *
150°C	132% *
175°C	127% *
205°C	87%

\*The shear strength is higher the room temperature control because heating the adhesive causes it to become more rigid, resulting in a higher strength.

## Chemical Resistance



Specimens were immersed for 30 days at 85°C and tested at room temperature.

## Additional Information

This product is not recommended for use in contact with strong oxidizing materials.

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 Activator 43 to one surface.
- 3) Apply adhesive to the other surface.
- 4) Assemble the components using sufficient force to spread the adhesive thinly. Parts should be bonded immediately and within a maximum of two hours of applying the Initiator.
- 5) Maintain pressure until handling strength is achieved. The time required will vary according to the joint design and surfaces being bonded.
- 6) 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	12 months

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