

### Features & Benefits

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

### Description

Permabond® TA439 is a two component structural acrylic adhesive designed primarily for bonding metals, ferrites, ceramics and some plastics. The typical fixture time of is 10-30 seconds. The fast fixture time of TA439 makes it an ideal adhesive for high speed production lines. This product provides high strength, tough, durable bonds with good impact resistance and performs well in drop tests.

TA439 is methacrylic acid free, this means it is suitable for use on sealed electric motors and will not cause corrosion to sensitive components. Use TA439 with Initiator 43.

### Physical Properties of Uncured Adhesive

Chemical composition	Urethane methacrylate
Appearance	Amber
Viscosity @ 25°C	800 - 1,200 mPa.s (cP)
Specific Gravity	1.03

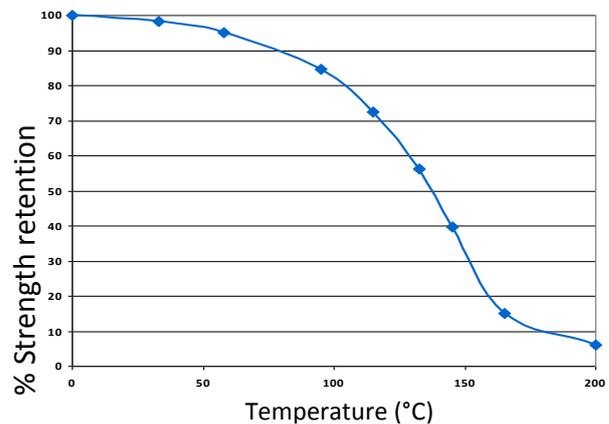
### Typical Curing Properties

Ratio of use	10 : 1.5 approximately
Maximum gap fill	Up to 0.5 mm (0.02 in)
Fixture time with initiator 43	10-30 seconds
Working strength	20-40 mins
Full cure	24 hours

### Typical Performance of Cured Adhesive

Shear strength (zinc)	12-18 N/mm <sup>2</sup> (2000-2300 psi)
Shear strength (steel)	20-25 N/mm <sup>2</sup> (2900-3600 psi)
Shear strength (steel to ferrite)	After 3 minutes: 4 N/mm <sup>2</sup> (600 psi) After 24 hours: >14 N/mm <sup>2</sup> (>2000 psi) (substrate failure)
Peel strength (ISO 4578)	45-90 N/25mm (10-20 PIW)
Tensile strength (DIN53288)	25-30 N/mm <sup>2</sup> (3600-4200 psi)
Impact strength (ASTM D-950)	10-20 KJ/m <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 kV/mm
Volume resistivity (ASTM D-257)	2 x 10 <sup>13</sup> Ohm.cm

### Temperature Resistance



TA439 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.

The information given and the recommendations made herein are based on our research and are believed to be accurate but no guarantee of their accuracy is made. In every case we urge and recommend that purchasers before using any product in full-scale production make their own tests to determine to their own satisfaction whether the product is of acceptable quality and is suitable for their particular purpose under their own operating conditions. THE PRODUCTS DISCLOSED HEREIN ARE SOLD WITHOUT ANY WARRANTY AS TO MERCHANTABILITY OR FITNESS FOR A PARTICULAR PURPOSE OR ANY OTHER WARRANTY, EXPRESS OR IMPLIED.

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.

## Environmental Resistance

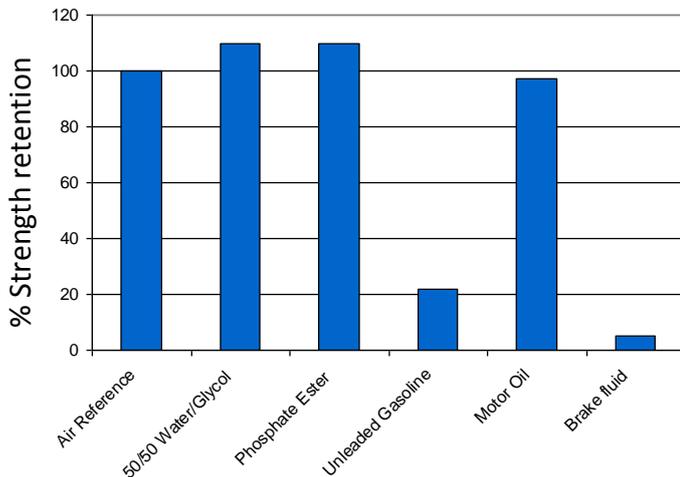
All values were generated on as received steel lap shears as described in ASTM D 1002.

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% *

\*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. Where aqueous washing systems are used to clean the surfaces before bonding, these aqueous washes can affect the cure and performance of the adhesive. 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. Use a suitable solvent (such as acetone or isopropanol) for the degreasing of 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.
- 2) Apply Initiator 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	12 months
Stored in original unopened containers	

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