

# Permabond®

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

## Polyolefin Bonding Structural Acrylic Adhesives

Permabond TA4600 series bond untreated polyolefins such as polypropylene and polyethylene (including PP, PE, LDPE, HDPE, UHMW PE) and other difficult-to-bond plastics such as PTFE, PMMA, NYLON, EVA, Acetal, TPO, PBT, PU, etc.) as well as other substrates such as metals, wood, rubbers, and e-coated metals.

### Permabond® Polyolefin Bonders (TA4600 Series) Features and Benefits

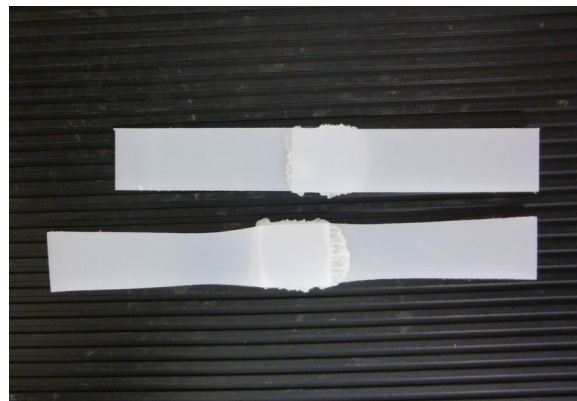
- No need to flame, corona, or plasma treat surfaces before bonding = cost and process saving
- Easy 1:1 mix ratio - can be manually applied or used with automatic dispensing equipment
- Non-hazardous for transport = easier shipping and storage
- Ideal for bonding a wide range of surfaces
- Cartridges with static mix nozzles for ease of dispensing - bulk available on request



chemical-concepts.com

**800.220.1966**

410 Pike Road • Huntingdon Valley, PA 19006



*Polypropylene lapshears bonded with TA4610 . The adhesive bond is so strong the plastic stretches, deforms, and fails before the bonded joint.*



*See product details on the next page.*

**Permabond®**  
Engineering Adhesives

# Polyolefin Bonding Structural Acrylic Adhesives

Grade	TA4605	TA4610	TA4611	TA4631
	Fastest	Longer Nozzle Life	No gap	Low Odor
<b>Appearance</b>	A: Off-white B: Almost colorless Mixed: Off-white	A: Off-white B: Almost colorless Mixed: Off-white	A: Translucent B: Transparent Mixed: Transparent	A: White B: White Mixed: White
<b>Gap</b>	Controlled	Controlled	No gap	Slight gap
<b>Viscosity @ 25°C</b>	Mixed: 125,000 cPs	Mixed: 210,000 cPs	Mixed: 21,500 cPs	Mixed: 21,500 cPs
<b>Mix Ratio</b>	1:1	1:1	1:1	1:1
<b>Fixture Time</b>	5-10 minutes	12-15 minutes	10-16 minutes	12 - 18 minutes
<b>Handling Time</b>	20-25 minutes	40-50 minutes	40-50 minutes	40-50 minutes
<b>Working Strength</b>	2-4 hours	6-8 hours	6-8 hours	6-8 hours
<b>Full Strength</b>	24 hours	24 - 36 hours	24 - 36 hours	24 - 36 hours
<b>Adhesion on Substrates</b>	Good on all substrates	Superior on PP	Widest adhesion latitude, superior metal-plastics	Superior on mixed substrates
<b>PP</b>	Excellent	Excellent	Excellent	Excellent
<b>PE</b>	Excellent	Excellent	Excellent	Excellent
<b>PTFE</b>	Good	Excellent	Excellent	Good
<b>PMMA</b>	Good	Good	Excellent	Good
<b>POM (acetal)</b>	Good	Good	Good	Excellent
<b>Nylon</b>	Fair	Fair	Excellent	Excellent
<b>Composites</b>	Good	Good	Good	Good
<b>Metal</b>	Good	Good	Excellent	Good
<b>Glass</b>	Good	Good	Good	Good
<b>Wood</b>	Good	Good	Good	Good
<b>Peel Strength</b>	Good	Good	Good	Fair
<b>Packaging</b>	10 x 50 ml Cartridges 6 x 400 ml Cartridges Bulk upon request	10 x 50 ml Cartridges 6 x 400 ml Cartridges Bulk upon request	15 x 25 ml Syringes 10 x 50 ml Cartridges 6 x 400 ml Cartridges Bulk upon request	15 x 25 ml Syringes 10 x 50 ml Cartridges 6 x 400 ml Cartridges Bulk upon request
<b>Service Temperature</b>	-55 to +100°C (-65 to +215°F)			

For full technical information, please refer to product data sheet.

• The Americas 732-868-1372 or 800-640-7599

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