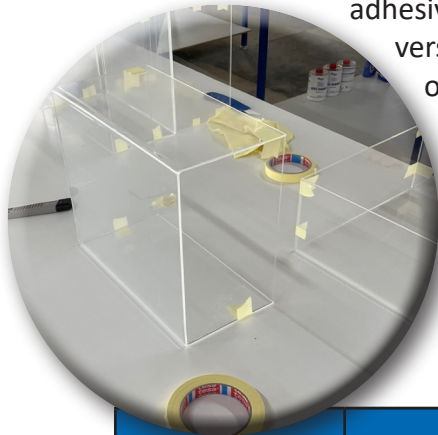


# Permabond®

## Adhesives for signage & displays

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

Permabond's chemists have formulated a range of high-performance adhesives suitable for use within the signage, shopfront and point of sale display industry. These specialist adhesives incorporate superb aesthetic appearance, ease of use, versatility and environmental resistance required for indoor and outdoor signs and displays. Adhesives offer sign manufacturers and POS display manufacturers many advantages. By not using mechanical fasteners, assemblies can be kept lightweight and keep their integral strength (no need to drill holes and risk cracking substrates). They can also be sealed 100% to prevent moisture ingress.



Ideal for bonding:

ABS

Acrylic

Aluminium composite

Composite

Glass

HIPS

Metals

Perspex

PET-G

Plexiglass

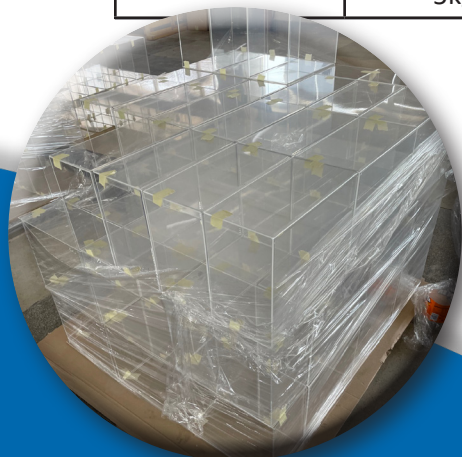
Polycarbonate

Polystyrene

+ many more materials

### Benefits of Permabond Structural Acrylic adhesives:

	TA4204	TA4205
Description	1:1 mix ratio pre-mix acrylic (can be used with mixing nozzles or bead-on-bead). High strength structural adhesive with rubber toughening. Excellent environmental resistance.	1:1 mix ratio pre-mix acrylic. Longer nozzle life than TA4204. High strength structural adhesive with rubber toughening. Excellent environmental resistance.
Appearance	Clear, transparent	Clear, transparent
Viscosity	55,000 mPa.s	A: 67,000 mPa.s ; B: 3,000 mPa.s
Gap fill	3mm	1mm
Fixture time	1-2 minutes	6-8 minutes
Handling time	5-10 minutes	8-10 minutes
Working strength	20-25 minutes	25-30 minutes
Shear strength	Acrylic: 4-5 N/mm <sup>2</sup> SF* Aluminium (gritblasted) 15-17 N/mm <sup>2</sup> Polycarbonate: 2-4 N/mm <sup>2</sup> Glass to aluminium: 13-14 N/mm <sup>2</sup>	Steel: 19-21 N/mm <sup>2</sup> Aluminium: 18-20 N/mm <sup>2</sup> PMMA: 3-5 N/mm <sup>2</sup> ABS: 5-7 N/mm <sup>2</sup> Polyester GRP: 7-9 N/mm <sup>2</sup> Epoxy FRP: 3-5 N/mm <sup>2</sup>
Peel strength	50 N/25mm	100-200 N/25mm
Storage	2-7°C	2-7°C
Packaging	10 x 50ml dual cartridges 6 x 400ml dual cartridges 5kg, 25kg and 180kg bulk	10 x 50ml dual cartridges 6 x 400ml dual cartridges Bulk on request



### Features of Permabond Structural Acrylic Adhesives:

- Rubber toughened, high impact resistance, peel strength and vibration resistance
- Suitable for joining dissimilar materials –e.g. glass to metal, plastics to metals etc.
- A range of viscosities to suit –products available for gap fill & vertical application
- Excellent environmental resistance and 100% seal against humidity
- Fast cure at ambient temperature
- Crystal clear, high clarity
- Contain no solvents

# Adhesives for signage & displays

## Benefits of Permabond UV-Curing Adhesives:

	UV639	UV649	UV6302
Description	Versatile UV curing adhesive for bonding PET, acrylic, polycarbonate, glass, metals.	Plastic bonding gel. Suitable for vertical applications or where gap fill is required.	Ultra-low viscosity wicking grade for post-assembly application – ideal for replacing solvent welding to give a much more visually pleasing joint.
Appearance	Clear, colourless	Clear, colourless	Clear, colourless
Viscosity	1200-1800 mPa.s	Thixotropic gel	60-100 mPa.s
Fixture time** <small>Low powered 4mW/cm<sup>2</sup> lamp</small>	PMMA: 5 sec Polycarbonate: 10 sec	Acrylic: 10 sec	Polycarbonate: 25-30 sec Rigid PVC: 5-7 sec PMMA: 4-5 sec
Elongation at break (ISO037)	>220%	>70%	100-150%
Tensile strength	20 N/mm <sup>2</sup>	15 N/mm <sup>2</sup>	12 - 20 N/mm <sup>2</sup>
Hardness (ISO868)	35 - 45 Shore D	50 - 65 Shore D	50 - 65 Shore D
Storage	5 to 25°C	5 to 25°C	5 to 25°C
Packaging	10 x 50ml bottles 10 x 250ml bottles Bulk on request	10 x 50ml tubes 10 x 250ml tubes Bulk on request	10 x 50ml bottle 10 x 250ml bottles Bulk on request

\*\* faster cure times can be achieved with higher powered lamps.



## Features of Permabond UV Adhesives:

- Low viscosity wicking grade suitable for post assembly application – ideal for replacing solvent welding
- A range of viscosities to suit – products available for gap fill and vertical application
- Ideal for joining dissimilar materials – e.g. glass to metal, plastics to metals etc.
- Crystal clear, non-yellowing
- Instant cure under UV light
- Contain no solvents



The technical data featured here for Permabond adhesives for signage is a guideline and does not constitute a specification. For full technical information, please refer to the technical data sheet, available at [www.permabond.com](http://www.permabond.com).

### Authorised distributor stamp:

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klebetechnik



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The information given and the recommendations made herein are based on our experience and are believed to be accurate. No guarantee as to, or responsibility for, their accuracy can be given or accepted, however, and no statement herein is to be treated as a representation or warranty. In every case we urge and recommend that purchasers, before using any product, make their own tests to determine, to their own satisfaction, its suitability for their particular purposes under their own operating conditions. Always refer to current product technical datasheet for most recent and accurate technical information.