

LONG OPEN TIME ACRYLIC - TA4213



Permabond TA4213 is a two-part structural adhesive designed for applications requiring extended working time alongside rapid strength development after assembly.

With an open time of up to 20 minutes, it enables the precise application of long beads across large panels and assemblies, making it ideal for transportation industry applications, signage and other large-scale bonding operations.

Despite its long open time, TA4213 cures rapidly once parts are brought together, quickly developing handling strength and reducing clamp times. This unique balance of workability and fast cure supports efficient assembly processes without compromising bond performance.

TA4213 features a smooth, thixotropic consistency for easy dispensing with excellent non-slump characteristics, allowing use on vertical surfaces and in gap-filling applications. Its integrated adhesion promotion technology means it can bond through oily surfaces or oxide layers, minimising the need for extensive surface preparation. Suitable for bonding a range of metals and composites, TA4213 provides a versatile and reliable solution for demanding industrial environments.

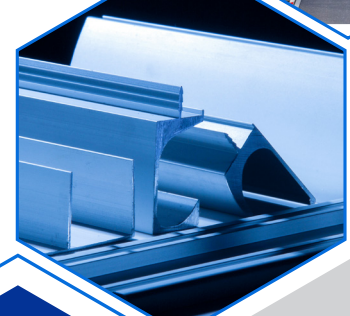


KEY FEATURES:

- ▶ Long open time for large assemblies and precise positioning
- ▶ Rapid strength development once parts are joined
- ▶ High structural bond strength across a range of substrates
- ▶ Excellent performance on metals and composites, ideal for bonding dissimilar materials
- ▶ Highly thixotropic for controlled application and minimal slump
- ▶ Ideal for vertical surfaces and gap-filling applications
- ▶ 1:1 mix ratio for easy, accurate dispensing
- ▶ Strong adhesion with minimal surface preparation required
- ▶ Excellent resistance to harsh environmental conditions
- ▶ Replaces welding or mechanical fasteners

IDEAL FOR BONDING:

- Aluminium
- Galvanised steel
- Mild steel
- PMMA
- Polycarbonate
- PVC
- Stainless steel
- GRP, FRP and other composite materials!





DESCRIPTION

The following technical data for Permabond TA4213 is a guideline and does not constitute a specification. For full technical information, please refer to the technical data sheet, available at permabond.com. Please contact Permabond to discuss your bonding project.

	TA4213
Description	Methyl methacrylate adhesive
Appearance	Cream
Features	Long open time, fast strength development once parts are joined.
Mixed Viscosity @ 25°C (77°F)	2rpm: 215,000 mPas (cP) / 20rpm: 51,000 mPas (cP)
Max gap fill	5mm (0.2 in)
Shear Strength	2014 Aluminium* 23-27 N/mm ² Mild steel* 25-28 N/mm ² Mild steel** 21-23 N/mm ² Stainless steel* 25-33 N/mm ² Galvanised Zinc 13-19 N/mm ² PMMA*** 5-7 N/mm ² PVC 7-8 N/mm ² Polycarbonate 2-4 N/mm ²
Hardness	60 Shore D
Open Time @ 23°C	20 minutes
Working Strength @ 23°C	1 hour
Full cure @ 23°C	24 hours
Service temperature	-40 to 150°C
Storage temperature	2 to 7°C (35 to 44°F)
Packaging	50ml & 400ml cartridges, bulk on request

*Grit-blasted, **De-greased, ***Substrate failure

Authorised distributor stamp:

tewipack
klebetechnik

tewipack Uhl GmbH
Industriestraße 15 info@tewipack.de
D-75382 Althengstett T +49 (7051) 9297 0
www.tewipack.de shop.tewipack.de

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