

## Crystal Clear Plastic Bonding Range

Permabond offers a range of clear, colourless adhesives suitable for a wide range of applications where a high-quality, aesthetic appearance is vital. Adhesives offer a practical alternative to solvent welding plastic substrates, giving an "invisible" bond, safer handling, better stress distribution and greater freedom of choice in bonding dissimilar materials. Bond strength is very high and normally exceeds the actual strength of the substrate materials.

Typical applications where Permabond Crystal Clear adhesives can be used include:

- Point of sale items
- Display stands
- Cabinets
- Shopfitting
- Signage
- Literature racks
- Menu holders
- Architectural applications
- LEDs, lenses and lighting



Ideal for bonding:

- Acrylic
- Composites
- Glass
- HIPS
- Metals
- Perspex®
- PET & PET-G
- Plexiglas®
- PMMA
- Polycarbonate
- Polystyrene
- SAN

+Many more materials

### Crystal Clear Products

	94X Range	TA4204 & TA4205	UV630 & UV640	UV632 & UV648	ET530	ET515	MS359 CLEAR
<b>Description</b>	Low-bloom, low odour cyanoacrylates for instant bonding. Cure off any excess with CSA-NF activator.	2-part 1:1 mix ratio structural acrylic adhesives. Use with static mixing nozzles or bead-on-bead.	Single part UV curable adhesives. Particularly suitable for bonding polycarbonate.	Single part UV curable adhesives. Particularly suitable for bonding acrylic and PET.	2-part epoxy resin and hardener. Low viscosity - ideal for potting.	2-part epoxy resin and hardener. 1:1 mix ratio. Flexible. Use with static mixing nozzles.	Single part moisture cure MS-Polymer. Slow setting and flexible.
<b>Viscosity @ 25°C</b>	940: 3-10 mPa.s 941: 10-20 mPa.s 943: 90-110 mPa.s 947: 900-1500 mPa.s	Both products are thixotropic gels	UV630: 200-300 mPa.s UV640: Thixotropic	UV632: 200-400 mPa.s UV648: Thixotropic	400-700 mPa.s	12,000-22,000 mPa.s	Non-sagging paste
<b>Cure</b>	Cures to handling strength in seconds in a closed joint.	Fixture time: TA4204: 1-2 mins TA4205: 3-4 mins	Seconds (depends on UV light output and thickness of substrate)	Seconds (depends on UV light output and thickness of substrate)	Pot life: 60-150 mins Handling time: 8-12 hours at 23°C	Pot life: 10-20 mins Handling time: 20-30 mins at 23°C	Skin-over: 10-20 mins Cure rate: 3-4mm every 24 hours
<b>Packaging</b>	15 x 20g bottles 10 x 50g bottles 1 x 500g bottle	10 x 50ml cartridges 6 x 400ml cartridges Bulk on request	10 x 50ml bottles 10 x 250ml bottles 1 x 2 ltr bottle	10 x 50ml bottles 10 x 250ml bottles 1 x 2 ltr bottle	1 x 1 kg tin A or B 1 x 5 kg tin A or B Bulk on request	10 x 50ml cartridges 6 x 200ml cartridges 6 x 400ml cartridges	24 x 290ml cartridges
<b>Storage</b>	2-7°C	2-7°C	5-25°C	5-25°C	5-25°C	5-25°C	5-25°C

For full technical information, please refer to product data sheet



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