

# Permabond®

## Adhesives for EV charging points

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

Permabond offers a range of adhesives suitable for use in the manufacture of electric vehicle charging points. This is a fast-growing industry with a wide variety of adhesive needs including potting, threadlocking, sealing, conformal coatings and gasketing, among others. There is a fair degree of crossover between AC and DC charging station adhesive applications.



Permabond anaerobics, threadlockers and structural acrylic adhesives are all suitable for the various applications required in these charging points. Adhesives help to reduce costs in EV charging point manufacturing (especially for the more expensive, public DC charging units) all the while increasing end product strength, durability and environmental resistance.



### Permabond® Adhesives for EV charging Features & Benefits

- Great adhesion to many substrates
- High temperature and impact resistance
- Ideal for bonding dissimilar materials
- Various levels of flexibility
- Fast curing
- Fire retardant on request

#### Ideal for:

- Potting EV charger connectors
- PCB conformal coatings
- Various threadlocking applications
- Gasketing EV charger housing
- Cable management

Ideal for bonding:

ABS

Acrylic

Aluminium

Brass

Carbon  
Fibre

FRP Glass

Nylon

Polycarbonate

PP

PE

PVC

Steel (Mild  
& Stainless)

Zinc

+ many more  
materials

# EV Charging Product Data

The following technical data for Permabond EV charging point adhesives 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). Our experienced worldwide trained distributor network means no matter where in the world you are located, Permabond representatives can be called upon to assist you with your bespoke applications.

	MT382	ET54391	HH131	A1042	LH197	TA4611	825
Chemistry	Modified 2-part epoxy	2-part epoxy	Anaerobic Threadlocker	Anaerobic Threadlocker	Anaerobic Gasketmaker	Structural Acrylic	Cyanoacrylate
EV charging application	Potting EV charging cable wiring/housing	EV charger potting applications	Sealing nuts, screws and bolts for permanent fixture	Locking and sealing metal parts that may need to be disassembled/ repaired	Gasketsealing	Bonding plastic charger housing	Bonding of motors, many high-heat bonding applications
Appearance	A: Black B: Amber Mixed: Charcoal	A: White B: Brown	Red	Blue	Green	A: Translucent B: Clear Mixed: Pale Yellow	Clear
Viscosity @ 25 C	A: 25,000 - 45,000 mPa.s B: 300 - 600 mPa.s	A: 30,000 mPa.s B: 1,000 mPa.s	2rpm: 23,000 mPa.s 20rpm: 7,500 mPa.s	2rpm: 8,000 mPa.s 20rpm	2rpm: 50,000 mPa.s 20rpm: 20,500 mPa.s	A: 20,000 - 30,000 mPa.s B: 10,000 - 15,000 mPa.s	100-150 mPa.s
Heat Resistance	Up to 150°C	Up to 150°C	Up to 230°C	Up to 150°C	Up to 150°C	Up to 100°C	Up to 200°C
Handling Time	105-120 minutes	@23°C: 5 hours @60°C: 20 mins	15 minutes	5 minutes	20 minutes	40 - 50 minutes	10-20 seconds (Steel) 5-10 seconds (NBR) 10-15 seconds (Buna N Rubber) 5-10 seconds (Phenolic) 10-20 seconds (HDPE) 40-60 seconds (LDPE)
Full Strength	≥ 72 hours	@ 23°C ≥ 24 hours @60°C ≥ 1 hour	24 hours (M10 steel)	24 hours (M10 steel)	24 hours (M10 steel)	24 - 36 hours	24 hours
Packaging	10x50ml 6x400ml + nozzles	50ml cartridges 400ml cartridges 5kg tins 25kg tins	10x50ml 4x250ml oval bottle 5x200ml	10x10ml 10x50ml 5x200ml	10x50ml oval 10x75ml	10x50ml 15x25ml 6x400ml	1x500g 15x20g
Storage	5 - 25°C	5 to 25°C	5 - 25°C	5 - 25°C	5 - 25°C	2 - 7°C	2 to 7°C

Authorised distributor stamp:



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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.