

### Features & Benefits

- 🔥 Low odour acrylic
- 🔥 Excellent adhesion on plastics, metals and composites
- 🔥 Excellent adhesion on nylon/polyamides
- 🔥 No primers required
- 🔥 High toughness
- 🔥 Fast cure at room temperature

### Description

**PERMABOND® TA4550** is a 2-part, 2:1 low odour, acrylic adhesive. It was developed for structural bonding of nylon/polyamide without the need for any primers or additional surface treatment, such as plasma. TA4550 is also good for bonding plastics, composites and metals. It cures rapidly at room temperature and is thixotropic (non-slump). The adhesive is highly toughened, which makes it suitable for applications involving impact and vibration.

### Physical Properties of Uncured Adhesive

	TA4550 A-side	TA4550 B-side
Chemical composition	Acrylic	Acrylic
Colour	Clear, colourless	Green
Viscosity @ 25°C	100,000 mPa.s (cP) Thixo	100,000 mPa.s (cP) Thixo
Specific gravity	1.0	1.0

### Typical Curing Properties

Ratio of use	2 : 1
Maximum gap fill	5 mm (0.2 in)
Pot life (10g mixed) @23°C	3 minutes
Fixture time (0.1 N/mm <sup>2</sup> shear strength is achieved) @23°C	5-6 minutes
Working strength @ 23°C	2 hours
Full cure @23°C	24 hours

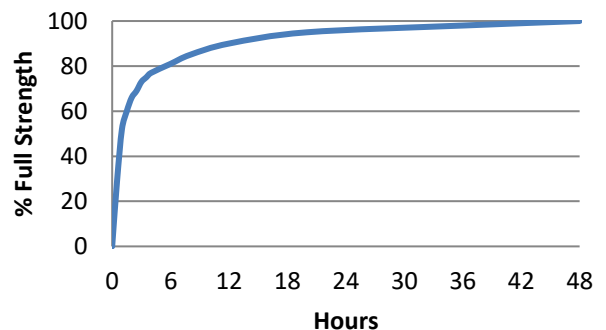
### Typical Performance of Cured Adhesive

Shear strength† (ISO4587)	PA6: >6 N/mm <sup>2</sup> (>870 psi) SF * PA6,6: >6 N/mm <sup>2</sup> (>870 psi) SF * PMMA: >4 N/mm <sup>2</sup> (>580 psi) SF * PVC: >6 N/mm <sup>2</sup> (>870 psi) SF * Polycarbonate: 3-5 N/mm <sup>2</sup> (435-725 psi) ABS: 5-7 N/mm <sup>2</sup> (725-1015 psi) PET: 3-5 N/mm <sup>2</sup> (435-725 psi) PET-G: >5 N/mm <sup>2</sup> (>725 psi) SF * Polyester GRP: >6 N/mm <sup>2</sup> (>870 psi) SF * Epoxy FRP: 19-22 (2755-3191 psi) Carbon Fibre: 22-25 (3191-3626 psi) Stainless Steel: 27-30 N/mm <sup>2</sup> (3916-4351 psi) Aluminium: 24-28 N/mm <sup>2</sup> (3481-4062 psi) Mild Steel: 24-28 N/mm <sup>2</sup> (3481-4062 psi) Aluminium-PA6,6: >6 N/mm <sup>2</sup> (>870 psi) SF * Mild Steel-PA6,6: >6 N/mm <sup>2</sup> (>870 psi) SF *
Peel strength (aluminium) (ISO4578)	250-270 N/25mm (57-62 PIW)
Impact strength (ASTM D-950)	24 kJ/cm <sup>2</sup>
Hardness (ISO868)	60-65 Shore D
Tensile strength (ASTM D638)	11 MPa
Elongation at break (ASTM D638)	140%
Water absorption (24h at 25°C)	1.7%

\*Substrate failure was observed.

†Nature of surface, surface preparation, glue-line thickness, thickness of substrates, pull speed, batch variation, cure time and temperature will all affect the shear strength measurement.

### Strength Development



Graph shows typical strength development of bonded components at 23°C. Curing at higher or lower temperatures may affect cure speed.

The information given and the recommendations made herein are based on our research and are believed to be accurate but no guarantee of their accuracy is made. In every case we urge and recommend that purchasers before using any product in full-scale production make their own tests to determine to their own satisfaction whether the product is of acceptable quality and is suitable for their particular purpose under their own operating conditions. THE PRODUCTS DISCLOSED HEREIN ARE SOLD WITHOUT ANY WARRANTY AS TO MERCHANTABILITY OR FITNESS FOR A PARTICULAR PURPOSE OR ANY OTHER WARRANTY, EXPRESS OR IMPLIED.

No representative of ours has any authority to waive or change the foregoing provisions but, subject to such provisions, our engineers are available to assist purchasers in adapting our products to their needs and to the circumstances prevailing in their business. Nothing contained herein shall be construed to imply the non-existence of any relevant patents or to constitute a permission, inducement or recommendation to practice any invention covered by any patent, without authority from the owner of this patent. We also expect purchasers to use our products in accordance with the guiding principles of the Chemical Manufacturers Association's Responsible Care® program.

## Additional Information

This product is not recommended for use in contact with strong oxidizing materials. This product may affect some thermoplastics and users must check compatibility of the product with such substrates.

Information regarding the safe handling of this material may be obtained from the safety data sheet (SDS). Users are reminded that all materials, whether innocuous or not, should be handled in accordance with the principles of good industrial hygiene.

**This Technical Datasheet (TDS) offers guideline information and does not constitute a specification.**

## Storage & Handling

Storage Temperature	5 to 25°C (41 to 77°F)
---------------------	------------------------

## Surface Preparation

Surfaces should be clean, dry and grease-free before applying the adhesive. Surfaces may have traces of mold release agent present – wipe with isopropanol (IPA) solvent and allow to fully evaporate before bonding. If bonding to metal: some metals such as aluminium, copper and its alloys will benefit from light abrasion with emery cloth (or similar) to remove the oxide layer.

## Directions for Use

- 1) Surfaces must be clean, dry and grease-free prior to bonding.
- 2) Apply a thin bead of adhesive pre-mixed through a static mixer nozzle.
- 3) Assemble components and clamp.
- 4) Maintain pressure until handling strength is achieved. The time required will vary according to the joint design and surfaces being bonded.
- 5) Allow 24 hours for adhesive to fully cure.

NB: Adhesive outside of a closed joint (i.e. excess material) will cure more slowly and may feel soft due to air contact. Adhesive inside the joint will cure solid.

## Video Links

Surface preparation:

<https://youtu.be/8CMOMP7hXjU>



Structural acrylic directions for use:

<https://youtu.be/YVeKBCVhYo>



[www.permabond.com](http://www.permabond.com)

- UK: 0800 975 9800
  - General Enquiries: +44 (0)1962 711661
  - US: 732-868-1372
  - Asia: + 86 21 5773 4913
- [info.europe@permabond.com](mailto:info.europe@permabond.com)  
[info.americas@permabond.com](mailto:info.americas@permabond.com)  
[info.asia@permabond.com](mailto:info.asia@permabond.com)

The information given and the recommendations made herein are based on our research and are believed to be accurate but no guarantee of their accuracy is made. In every case we urge and recommend that purchasers before using any product in full-scale production make their own tests to determine to their own satisfaction whether the product is of acceptable quality and is suitable for their particular purpose under their own operating conditions. THE PRODUCTS DISCLOSED HEREIN ARE SOLD WITHOUT ANY WARRANTY AS TO MERCHANTABILITY OR FITNESS FOR A PARTICULAR PURPOSE OR ANY OTHER WARRANTY, EXPRESS OR IMPLIED.

No representative of ours has any authority to waive or change the foregoing provisions but, subject to such provisions, our engineers are available to assist purchasers in adapting our products to their needs and to the circumstances prevailing in their business. Nothing contained herein shall be construed to imply the non-existence of any relevant patents or to constitute a permission, inducement or recommendation to practice any invention covered by any patent, without authority from the owner of this patent. We also expect purchasers to use our products in accordance with the guiding principles of the Chemical Manufacturers Association's Responsible Care® program.