

DESCRIPTION

The PERMACOL 2032 series are one component epoxy adhesives which cure at elevated temperatures.

These adhesives can be used for metal, plastic and ceramic substrates.

Type	Viscosity (D=30/s 23°C)
2032	30.000 mPa·s
2032/651	5.000 mPa·s

Technical details	
Basis	Epoxy
Colour	Amber
Density	1.20 g/cm ³
Volume resistance	1.5×10 ¹⁴ Ω·cm
Hardness	85 shore D
Temperature resistance	-40°C up to 140°C
Curing time	3 min at 150°C
	6 min at 125°C
	10 min at 110°C
	30 min at 100°C
	60 min at 90°C
Minimum curing temperature	90°C
Tensile Strength	125 kg/cm ³ (Steel-Steel)

Curing recommendations

Make sure the substrates are clean and free from dust, water, grease, fingerprints, oil, etc. Metals are to be sanded to remove the oxide layer before cleaning. The standard curing conditions are 3 minutes at 150°C or 6 minutes at 125°C. In practice the oven time might need to be longer to allow the substrate to heat up.

Do not return used glue in the packaging to avoid contamination.

CLEANING

BENEFITS

- Moisture resistant
- Resistant to higher temperatures
- Fast curing
- High solvent and humidity resistance
- RoHS und REACH compatible

At room temperature, the remaining uncured adhesive can be removed and cleaned by means of solvents as Ethanol, Acetone, Isopropanol (IPA) or MEK.

Cured adhesives must be removed mechanically. We advise to heat up the adhesive bond over 100°C. At this temperature, the adhesive dot will become softer and the component can easily be removed using torsion.

STORAGE

Store in its original packaging between -18°C to 20°C. Avoid exposure to high humidity and sunlight. Do not open the package while the adhesive is cold. Remove the adhesive from the fridge at least two hours before use. See packaging for the expiration date. Shelf life: 6 months at -18°C or 1 months at 20°C.

SAFETY

Use protective gloves to avoid direct contact with the skin. Check the Material Safety Data Sheet for specific safety information.

PACKAGING

The PERMACOL 2032-series can be supplied in all dispenser-specific syringes, tins and pots.

Legal Disclaimer

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