

## DESCRIPTION

PERMACOL 3000 are strong and fast setting methyl methacrylate adhesives, suitable for bonding a wide variety of materials such as: metals (steel, aluminum, copper, zinc and its alloys, such as ferrite.) Plastics such as ABS, polystyrene, hard PVC, ABS, polycarbonate, polyphenylenoxide (PPO), polyester moldings, MDF and, glass, ceramics, pottery, and combinations thereof, without extensive pre-treatment.

PERMACOL	3000	3000-30
Open time (20°C, minutes)	5-7	10-12
Gel time (20°C, minutes)	10-12	18-20
Curing time (20°C, minutes)	60	60

## USAGE INSTRUCTIONS

Cleaning the substrate is not always necessary because the adhesive itself acts as a degreasing agent. But cleaning the substrates from excessive dust, water, oil, ect. will result in a better bonding. Use isopropanol to clean the substrates.

Place the cartridge into a dispenser gun. Remove the cap from the syringe. Dispense a small amount from the syringe until adhesive is flowing from both sides of the cartridge (do not use this for adhesion). Connect the mixer. Dispense and discard the first mL of adhesive. Begin applying adhesive to the substrate. Do not use these adhesives at temperatures below 5°C.

Shear strength according to ASTM D1002	
Steel	30 N / mm <sup>2</sup>
Aluminium	27 N / mm <sup>2</sup>
Polycarbonate	13 N / mm <sup>2</sup>
ABS	8 N / mm <sup>2</sup>

## BENEFITS

- Fast curing
- Flexible
- Shock resistant
- Water resistant
- Resistant to oils and acids
- RoHS and REACH compliant

Technical details	
Chemical type	Methacrylic
Components	Two components (1:1)
Color	Cream white
Viscosity	Thixotropic paste
Hardness (Shore D)	70-75
Gap filling	10 mm
Density	0,97 kg/L
Temperature range	-55°C – 120°C

## STORAGE

Store in its original packaging below 25°C. See packaging for the expiration date. Shelf life: 12 months.

## SAFETY

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

## PACKAGING

These 2-component adhesive systems are available in a convenient 50ml dual syringe-packaging that ensures that the components continue to be mixed into equal parts.

## Legal Disclaimer

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