

## DESCRIPTION

The PERMACOL 5132 and 5133 A/B are polyurethane systems which can be used as casting resin and adhesive. These products can bond substrates such as: various plastics, polyurethane, concrete, wood, metal and polystyrene. These adhesives cure at room temperature, so full cure takes place at 20°C. The pot life of the product is depending on the volume. Larger volumes have a shorter pot life.

Type	Viscosity Mixture (D=30/s 23°C)
5132 A/B	6.000 mPa.s
5133 A/B	7.500 mPa.s

Technical details	
Mixing ratio	A : B = 100 : 25 (weight)
Pot life	1 hr at 20°C
Curing time	30 min at 70°C
	1 hr at 06°C
	2 hrs at 50°C
	4 hrs at 40°C
	24 hrs at 20°C
	72 hrs at 5°C
Application temperature	5°C to 30°C
Colour mixture	Brown
Hardness	80 shore D
Density	1.45 g/cm <sup>3</sup>
Temperature resistance	-30°C up to +100°C
Application quantity	200-300 g/m <sup>2</sup>

## USAGE INSTRUCTIONS

Make sure the substrates are clean and free from dust, water, grease, fingerprints, oil, etc. Weigh the components according to the mixing ratio and mix until a homogeneous colour is reached. After the mixing, the product is ready to be used.

## BENEFITS

- Seawater resistant
- Very low shrinkage
- Solvent free
- Resistant to temperature fluxes
- Resistant to oil, grease and acids

Shear Strengths	
Hard PVC	80 kg/cm <sup>2</sup>
PMMA	82 kg/cm <sup>2</sup>
Polystyrene	20 kg/cm <sup>2</sup>
ABS	45 kg/cm <sup>2</sup>
Nylon (PA)	30 kg/cm <sup>2</sup>
Polycarbonate	36 kg/cm <sup>2</sup>
Delrin (PC)	28 kg/cm <sup>2</sup>
Teflon (PTFE)	10 kg/cm <sup>2</sup>
Wood	50 kg/cm <sup>2</sup>
Aluminium	70 kg/cm <sup>2</sup>
Steel	72 kg/cm <sup>2</sup>

## CLEANING

Uncured adhesive can be removed and cleaned by means of solvents as Ethanol, Acetone, Isopropanol (IPA) or MEK. Cured adhesives must be removed mechanically.

## STORAGE

Store in its original packaging frost free and dry, preferably between 10°C and 20°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.

As from 24 August 2023 adequate training is required before industrial or professional use.

## PACKAGING

These adhesives are available in different kinds of cans.

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