

## DESCRIPTION

The PERMACOL 5198 A/B series are polyurethane adhesives which can be applied for binding, repair and fill materials as: metals, plastics, mineral substrates, wood and fire resistant building boards. These adhesives cure at room temperature, so full cure takes place at 20°C. At higher temperatures the adhesive will have a shorter pot life and cure time.

## BENEFITS

- Suitable for outside applications
- Solvent free
- Very low shrinkage
- Resistant to temperature fluxes
- Resistant to oil, grease and acids

Type	Pot life (at 23°C)	Curing time (at 23°C)	Final strength after (at 23°C)
5198-3	ca. 1.5 min	ca. 3 min	ca. 24 hrs
5198-5	ca. 5 min	ca. 20 min	ca. 24 hrs
5198-7	ca. 7 min	ca. 30 min	ca. 24 hrs
5198-10	ca. 10 min	ca. 30 min	ca. 24 hrs
5198-15	ca. 15 min	ca. 45 min	ca. 24 hrs
5198-30	ca. 20 min	ca. 60 min	ca. 24 hrs
5198-60	ca. 60 min	ca. 180 min	ca. 24 hrs

Technical details	
Mixing ratio	A : B = 1 : 1 (weight, volume)
Viscosity A-component	17.000 mPa.s (D=30/s 23°C)
Viscosity B-component	17.500 mPa.s (D=30/s 23°C)
Minimum application temperature	15°C
Colour mixture	Slight yellow
Hardness	70 shore D
Temperature resistance	-30°C up to +100°C
Shear Strengths	
Steel – Steel	72 kg/cm <sup>2</sup>
Aluminium – Aluminium	68 kg/cm <sup>2</sup>
Hard PVC – Hard PVC	80 kg/cm <sup>2</sup> *
ABS – ABS	45 kg/cm <sup>2</sup> *
PMMA – PMMA	82 kg/cm <sup>2</sup>
* means material breakage	

## USAGE INSTRUCTIONS

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. Weigh the components according to the mixing ratio and mix until a homogeneous colour is reached, or use a double syringe and static mixer. 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.

## 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. See packaging for the expiration date. Shelf life: 6 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

The PERMACOL 5198 series are available in different kinds of cartridges.

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