

# Technical data sheet

## PERMACOL 3510-series



### DESCRIPTION

The PERMACOL 3510 series are optically clear UV-curing adhesives especially designed for bonding PMMA (acrylic glass / perspex / plexiglass). The monomer of this adhesive is methyl-methacrylate (MMA). During curing PMMA is formed. So by using this adhesive PMMA is bonded with PMMA. This results in a very strong bond.

Technical details	
Chemical type	Methyl-methacrylate
Components	One component
Color	Clear
Viscosity 3510-1	70 mPas
Viscosity 3510-2	750 mPas
Specific gravity	0,95 g/cm <sup>3</sup>
UV-wavelength	320 – 400nm

### USAGE INSTRUCTIONS

Can be cured with low intensity UV-A lamps. Curing time depends on the spectrum and intensity of the lamp and the layer-thickness of the adhesive. Curing time for a thin layer with a low intensity UV-A light or direct sunlight is about 5-10 minutes for the 3510-1 and 3-8 minutes for the 3510-2.

Maximum bonding strength is reached a couple of hours after curing. Higher intensity UV-lamps will speed up the curing process. Curing with UV-LED lamps is not recommended.

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Make sure the substrates are clean and free from dust, water, grease, fingerprints, oil, ect. Use isopropanol to clean the substrates.

### BENEFITS

- Bonds PMMA GS and XT
- Optically clear
- Capillary (3510-1), gap-filling (3510-2)
- 100% solids, no solvents
- Curable with low intensity UV-light
- RoHS and REACH compliant

### STORAGE

Store in its original packaging below 20°C. Allow the adhesive to warm up to room temperature before use. This product is light sensitive. Avoid direct exposure to daylight and artificial lighting. See packaging for the expiration date. Shelf life: 12 months.

### SAFETY

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

### PACKAGING

The PERMACOL 3510 series are available in different kinds of cartridges and bottles