

# Technical data sheet

## PERMACOL 3522



### DESCRIPTION

The PERMACOL 3522 is flexible, fast curing, optically clear thermally curing adhesive. This product has a very good adhesion to many materials such as metals, glass and various plastics.

Technical details	
Chemical type	Methacrylic
Components	One component
Color	Clear - colourless
Viscosity	3500 mPas
Hardness (Shore A)	55
Curing temperature	120°C
Curing time	3 minutes

### USAGE INSTRUCTIONS

Can be cured in 3 minutes at 120°C. This excludes the time it takes for the substrate to warm up to the curing temperature. Do not cure at temperatures >130°C, this will result in yellowing of the product. Make sure the substrates are clean and free from dust, water, grease, fingerprints, oil, ect. Use isopropanol to clean the substrates.

### BENEFITS

- Fast curing
- Optically clear
- Flexible
- Water resistant
- 100% solids, no solvents
- RoHS and REACH compliant

### STORAGE

Store in its original packaging between 0°C to 10°C. Allow the adhesive to warm up to room temperature before use. Avoid direct exposure to sunlight. 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.

### PACKAGING

The PERMACOL 3522 is available in different kinds of cartridges and bottles

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