

# Technical data sheet

## PERMACOL® 5450



### DESCRIPTION

The PERMACOL 5450 A/B is a polyurethane casting resin, which can be used for casting electrical switches and components. Can be used for casting LED-profiles.

This casting resin cures at room temperature, so full cure takes place at 20°C.

This product is suitable for different colours. From crystal clear, diffuse and smoky black.

Technical details	
Mixing ratio	A : B = 1 : 1 (weight)
Viscosity A-component	300 mPa.s (D=30/s 23°C)
Viscosity B-component	250 mPa.s (D=30/s 23°C)
Viscosity mixture	300 mPa.s (D=30/s 23°C)
Application temperature	+15°C
Pot life	30 min with 200ml at 20°C
Cure time	2 hr with 200ml at 20°C
Full strength after	24 hr with 200ml at 20°C
Peak exotherm	65°C with 200ml at 20°C
Colour mixture	Crystal clear
	Diffuse
	Smoky black
Hardness	75 shore A
Temperature resistance	-30°C up to +100°C
Density A-component	1.10 g/cm <sup>3</sup>
Density B-component	1.15 g/cm <sup>3</sup>

### 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. The pot life is depending on the volume that is mixed. Larger volumes have a shorter pot life and reach a higher exothermal temperature.

### BENEFITS

- Crystal clear
- Multiple colours possible
- Solvent free
- Very low shrinkage
- RoHS und REACH compatible

During the mixing and pouring of the resin, bubbles may enter the product. These can be removed by mixing under reduced pressure or with a heat gun after pouring. Make sure that the heat gun is only used on the bubbles, not to heat the product.

### 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. Make sure that cartridges are stored standing upright. 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 5450 series are available in different kinds of cartridges.

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