

## DESCRIPTION

The PERMACOL 5663 is a fluid, solvent free, one component polyurethane adhesive, which cures under the influence of moisture. Cure speed is depending on the moisture of the substrate, humidity of the area, temperature and layer thickness. This adhesive is especially suitable for wood, rigid PVC, GFK, ABD, foamed polystyrene, PVC, PU, Aluminium, steel, RVS, galvanised steel, concrete, stone and combinations.

Technical details	
Colour	Light yellow brown
Viscosity	7.000 mPa.s
Density	1.10 g/cm <sup>3</sup>
Working temperature	15 to 20°C
Humidity working area	50%
Moist content wood	8-16%
Pot life	30-60 minutes
Pot life thin layer	20-25 minutes
Final strength after	24-48 hours
Temperature resistance	-30°C up to 80°C
Appliance	ca. 200g/m <sup>2</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. Only use in well ventilated areas. Smooth surfaces, such as metal and plastics, need to be roughened and free of dust. Make sure the substrates are clean and free from dust, water, grease, fingerprints, oil, etc. Apply the adhesive at one side with cartridge or spatula. One material needs to have an open structure or moist content. Press the 2 parts as soon as possible.

## BENEFITS

- Fast curing
- Shock resistant
- Flexible
- Water resistant
- No solvents
- RoHS and REACH compliant

## 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 at room temperature. 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. As from 24 August 2023 adequate training is required before industrial or professional use.

## PACKAGING

The PERMACOL 5663 is available in different kinds of cartridges and bottles.

## Legal Disclaimer

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