

## DESCRIPTION

The PERMACOL 2245 A/B is a fast curing 2-component adhesive. This product is a somewhat flexible and gap filling adhesive. Used for application of the following materials: metals, ceramics, glass, stone, wood and rigid plastics.

The adhesive cures at room temperature, so full cure takes place at 20°C and even at temperatures below zero degrees Celsius. The curing time will increase at temperatures below 20°C.

Technical details	
Mixing ratio	A : B = 1 : 1 (weight)
Pot life	5 min at 20°C
Curing time	10 min at 20°C
Final strength after	Ca. 12 hrs at 20°C or 30 minutes at 80°C
Viscosity A-component	8.500 mPa.s at 23°C
Viscosity B-component	33.500 mPa.s at 23°C
Application	100-200 gr/m <sup>2</sup> depending on roughness of surface.
Colour	Beige
Temperature resistance	-30°C up to +120°C

## USAGE INSTRUCTIONS

Make sure the substrates are clean and free from dust, water, grease, fingerprints, oil, etc. Use the double syringe with a dispensing gun.

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.

## BENEFITS

- Water resistant
- Resistant to oil, grease and acids
- Impact resistant
- Gap filling
- 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 frost free and dry. See packaging for the expiration date. Shelf life: 12 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 2245 A/B is available in different kinds of cartridges.

## Legal Disclaimer

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