Technisches Datenblatt

Produkt:	41
Hersteller:	PERMABOND ENGINEERING ADHESIVES
Warengruppe:	KLEBSTOFF
Artikelgruppe:	INITIATOR
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PERMABOND INITIATOR 41

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PERMABOND® Initiator 41

Initiator for Acrylic Adhesive

Technical Datasheet

Features & Benefits

- Brush on liquid
- Quick & easy to use
- Use with Permabond® Structural Acrylic (TA) adhesives

Description

Permabond® Initiator 41 is used in conjunction with Permabond TA (structural acrylic) adhesives as a no-mix resin and initiator system. Its solvent free formulation allows a long open time if required. Alternatively, parts can be bonded immediately after application (no need to wait for evaporation).

Physical Properties

Colour	Amber
Viscosity	70 mPa.s
Flashpoint	90°C
Specific Gravity	1.0
On-part life	30 minutes
Handling time 23°C (with Permabond® TA435)	Gap+:~0mm ***(0 in)*** <2 minutes 0.25mm ***(0.01 in)*** 10 minutes 0.5mm ***(0.02 in)*** 20 minutes

Storage & Handling

Storage Temperature	5 to 25°C
Shelf Life Stored in original unopened containers	12 months

Additional Information

Users are reminded that all materials, whether innocuous or not, should be handled in accordance with the principles of good industrial hygiene. Full information can be obtained from the Material Safety Data Sheet.

Directions for Use

- Surfaces should be clean, dry and grease-free prior to initiator application.
- Permabond® Initiator 41 should be applied either by wiping (using a clean cloth), spraying or brushing onto part. For best results it should be a thin even coating.
- Permabond® TA structural acrylic should be applied to the corresponding part.
- When the two parts marry, the adhesive is reacted and will cure. Parts should be clamped firmly and not disturbed for the duration of the handling time (as per table on the left).
- Excess initiator can be cleaned off using a suitable alcohol (such as isopropanol, acetone or MEK).
- For maximum bond strength, allow adhesive to cure for 24 hours at 23°C.
- Permabond® Initiator 41 is formulated to minimise attack and maximise performance on certain plastics. However, it is recommended that the product is tested for compatibility prior to use in production.

Do not mix Permabond® Initiator directly with large quantities of structural acrylic adhesive.

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