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Technical Data Sheet

Permatex® Plastic Welder

AAM Revised 04/18

PRODUCT DESCRIPTION

S.I.N.: 834-300

Permatex® Plastic Welder is a structural adhesive designed for general purpose bonding of a wide variety of materials. Plastic Welder form a tough, durable bond to most plastics, composites, ceramics, wood in any combination. Plastic Welder is a fast curing product with gelling of mixed adhesive in 5 – 6 minutes and fixturing in 9 – 10 minutes. NOTE: Plastic Welder will not bond most polyethylene or polypropylene plastics.

PRODUCT BENEFITS

- Sets in 5 minutes
- Requires no primers
- Room temperature cure
- Gap filling to 0.125 inch
- Bonds diverse substrates
- Water resistant
- Good chemical resistance

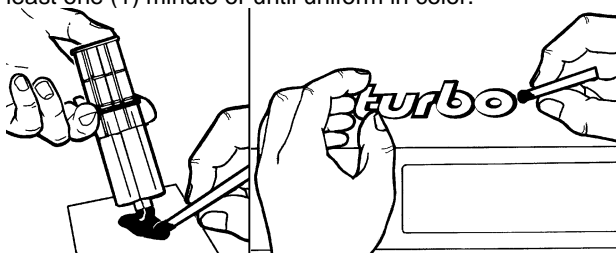
TYPICAL APPLICATIONS

To bond rigid materials including:

- ABS
- Fiberglass
- PVC
- Vinyl
- FRP
- Acrylic
- Glass
- Styrene
- Wood
- SMC

DIRECTIONS FOR USE

1. Protect work area from accidental spills.
2. Surface must be clean, dry and free of grease & oil.
3. Roughen surfaces with sandpaper or other abrasives.
4. Use a sharp blade to cut off the tips of both nozzles.
5. Depress plunger on syringe to dispense Part A and Part B. Thoroughly mix on a clean discardable surface for at least one (1) minute or until uniform in color.



6. Apply to surfaces being repaired. Assemble parts immediately. Remove excess adhesive immediately.
7. Allow bond to set for 9 – 10 minutes before moving.

For Cleanup

1. For any cleanup, use isopropyl alcohol before the material is allowed to dry.
2. Clean hands with Permatex® Fast Orange® hand cleaner or soap and water.

PROPERTIES OF UNCURED MATERIAL

	Typical Value
Chemical Type	Structural acrylic
Mix ratio	1 : 1
Appearance	
Part A	Natural
Part B	Amber
Odor	Acrid
Specific Gravity	0.94 – 1.0
Flash Point, TCC	51°F
Viscosity	Heavy syrup

CURING PROPERTIES

Working Time	5 - 6 minutes
Fixture Time	8 – 10 minutes
Final color	Off white - amber
Temperature range	-60°F to +250°F
Hardness	70D
Elongation	7%

GENERAL INFORMATION

This product is not recommended for use in pure oxygen and/or oxygen rich systems and should not be selected as an adhesive for chlorine or other strong oxidizing materials.

For safe handling information on this product, consult the Material Safety Data Sheet, (MSDS).

ORDERING INFORMATION

Part Number	Container Size
84115	5 min. Plastic Welder, 0.84 fl. oz. dual syringe, carded

STORAGE

Products shall be ideally stored in a cool, dry location in unopened containers at a temperature between 8° to 28°C (46° to 82°F) unless otherwise labeled. Optimal storage is at the lower half of this temperature range. To prevent contamination of unused product, do not return any material to its original container.

NOT FOR PRODUCT SPECIFICATIONS.

THE TECHNICAL DATA CONTAINED HEREIN ARE INTENDED AS REFERENCE ONLY.

PLEASE CONTACT PERMATEX, INC., TECHNICAL SERVICE DEPARTMENT FOR ASSISTANCE AND RECOMMENDATIONS FOR YOUR SPECIFIC APPLICATION.
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NOTE

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