

**Permabond ET510**  
**Technical Information Sheet**

**2 PART EPOXY ADHESIVE**

**Description**

Permabond ET510 will bond to a wide variety of surfaces such as wood, metal, ceramics and many plastic and composite materials. It is a semi flexible structural adhesive and has good resistance to water, petrol and most oils .

**Physical properties**

	<b>ET510A</b>	<b>ET510B</b>
Chemical composition	Epoxy Resin	Polyamide Hardener
Appearance	Colourless	Amber
Viscosity (25°C - mPa.s)	23,000	35000
Density	1.2	1.0
Shelf life	12 months	12 months
Storage Temperature	5 to 25°C	5 to 25°C

**Cured Properties**

Mix Ratio	1:1 by volume
Gap Fill	Typically up to 2mm
Handling Time	15-25 minutes
Working Strength	40- 60 minutes
Full Cure	5 days
Shear Strength	18 MPa
Peel Strength	85 N/25mm
Hardness	60 Shore D
Elongation at break	30%
Temperature Range	-40 to +80°C

**Handling and Safety**

Users are reminded that all materials, whether innocuous or not, should be handled in according to 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 before applying the adhesive and the use of **Permabond Cleaner A** is recommended.

Place cartridge in dispensing gun, remove end cap and attach appropriate mixing nozzle. Apply the mixed adhesive to one surface, assemble the components and allow to cure.

Do not mix up more adhesive than can be applied within the usable life of the product.

The information given and the recommendations made herein are based on our experience and are believed to be accurate. No guarantee as to, or responsibility for, their accuracy can be given or accepted, however, and no statement herein is to be treated as a representation or warranty. In every case we urge and recommend that purchasers, before using any product, make their own tests to determine, to their own satisfaction, its suitability for their particular purposes under their own operating conditions.