

Permabond ET536 is a structural, room-temperature curing, epoxy adhesive that will bond to a wide variety of surfaces such as wood, metal, ceramics and many plastic and composite materials. It exhibits good resistance to petrol, oils and water and has an extended cure-time making it more suitable for larger applications or batch production processes. Its thixotropic "non-slump" nature make it suitable for gap filling or for vertical application.

Physical Properties

| | ET536A | ET536B |
|----------------------|-------------|--------------------|
| Chemical Type | Epoxy Resin | Polyamide Hardener |
| Colour | White | Black |
| Viscosity | Soft paste | Soft paste |
| Density | 1.2 | 1.02 |

Typical Performance

| | | |
|-----------------------------|--------------|----------------|
| Mix Ratio | By volume | 1:1 |
| Gap Fill | | Up to 5mm |
| Usable Life | Mixed @ 20°C | 30 minutes |
| Working Strength | | 1 hour |
| Full Strength | | 72 hours |
| Shear Strength | ASTM D-1002 | 24 MPa (steel) |
| Shore D Hardness | | 78 |
| Service Temperature* | | -40 to +80°C |

*Higher temperatures may be endured for short periods providing the parts are not unduly stressed.

Surface Preparation

Contact Permabond:

Europe: Tel. +44 (0)1962 711661
UK Helpline: 0800 975 9800
Deutschland: 0800 10 13 177
France: 0805 11 13 88
info.europe@permabond.com

US: Tel. 00 1 732-868-1372
Helpline: 800-640-7599
info.americas@permabond.com
Asia: Tel. 00 886 939 49 3310
info.asia@permabond.com

www.permabond.com

Surfaces should be clean, dry and grease-free before applying the adhesive. Permabond Cleaner A is recommended for the degreasing of most surfaces. Some metals such as aluminium, copper and its alloys will benefit from light abrasion with emery cloth (or similar), to remove the oxide layer.

Adhesive Application

- If dispensing from a cartridge, ensure back pistons are level before using the adhesive. Attach static mixing nozzle and apply using a dispensing gun.
- For bulk application, ensure the resin and hardener are thoroughly mixed and in the correct proportion.
- Apply the adhesive to one surface and avoid entrapping air.
- Assemble parts applying sufficient pressure to ensure the adhesive spreads to cover the entire bond area.
- Use a jig / clamp to prevent parts moving during cure.
- It is advisable not to disturb the joint until the adhesive is fully cured.

Storage and Handling

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

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.

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.