

# PERMABOND® Initiator #5

## Structural Acrylic Activator

(for use with PERMABOND F246)



Ref. #: 121500PBIn#5  
Replaces #: 090700PBIn#5

### FEATURES & BENEFITS

- ◆ Nonflammable
- ◆ Solvent Free (100% Solids)
- ◆ Environmentally Friendly
- ◆ Flexible Initiator / Adhesive Ratio - Consistent Bond Strength
- ◆ User Friendly
- ◆ Requires No Drying Time

### GENERAL DESCRIPTION

PERMABOND Initiator #5 is a structural acrylic activator that is used to initiate the cure of F246 Structural Acrylic Adhesive. The activator is safe to use in production environments as it is nonflammable, and contains no solvents or VOC's. Because the product is solvent free, parts can be bonded immediately after the activator is applied to the bonding surface. No drying time is required. The activator has been specifically designed for use with the F246 Structural Acrylic Adhesive to obtain consistent adhesive strength and reduce the possibility of over-activation.

Initiator #5 can be sprayed, brushed, or wiped onto parts and can be easily applied manually or by dispensing equipment. PERMABOND's dispensing equipment group manufactures custom designed dispensing equipment for the initiator that is specific to each adhesive application.

### PHYSICAL PROPERTIES OF THE UNCURED ACTIVATOR

<u>Properties</u>	
Color	Amber
Mean Viscosity*, cP	100
Specific Gravity	0.98
Flash Point, °C (°F)	> 93 (200)
Solids, %	100
Approximate Ratio of Adhesive to Activator	15 to 1
Open Time, hours	24
Fixture Time of F246 with Initiator #5, seconds	30 – 60
Shelf Life stored at or below 27°C (80°F), months	12

Viscosity, Brookfield, 25°C (77°F) @ 20 rpm

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## **STORAGE & HANDLING**

PERMABOND Initiator #5 has a shelf life of one year when stored at or below 27°C (80°F). Do not freeze. Store in a cool place away from sparks, flame, excessive heat and sunlight.

The Initiator #1 contains reactive chemicals. It can cause skin irritation and dermatitis. The use of barrier creams, plastic gloves (nitrile rubber or Neoprene<sup>®</sup>), and an apron, in combination with good housekeeping, is usually sufficient to prevent accidental or chronic exposure. If skin contact occurs, the affected area should be washed with soap and water. Eye protection should be worn whenever the product is being used. Eye contact should be treated by thoroughly washing the affected area with water, followed by immediate medical attention. Adequate ventilation is necessary to prevent the prolonged inhalation of vapors.

**Initiator #5 and F246 Adhesive should not be mixed in large quantities, as a vigorous chemical reaction will occur generating a significant amount of heat and vapors.**

Unreacted initiator can be cleaned up using acetone, isopropanol, or MEK.

Please read the MSDS for more information on safe handling of the initiator.

**FOR INDUSTRIAL USE ONLY. KEEP OUT OF REACH OF CHILDREN**