

Permabond Double Bubble will bond to a wide variety of surfaces such as wood, metal and ceramics, including many plastic and composite materials. It is ideal for bonding small components or for carrying out small repair jobs. Double Bubble cures rapidly to give a handling strength in approximately 5 minutes at room temperature.

Physical Properties

	Part A	Part B
Chemical Type	Epoxy Resin	Amine Hardener
Colour	Colourless	Colourless
Viscosity	55,000 mPa.s	7,000 mPas
Density	1.19	1.13

Typical Performance

Mix Ratio	By volume	1:1
Gap Fill		Up to 2mm
Usable Life	Mixed @ 20°C	3 minutes
Handling Strength		4-6 minutes
Working Strength		15-30 minutes
Full Strength		24 hours
Shear Strength	ASTM D-1002	14 MPa (steel)
Service Temperature*		-40 to +80°C

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

Surface Preparation

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

- Cut sachet to open.
- Squeeze contents of both sachet compartments onto mixing palette provided.
- Mix well, trying not to entrap air, apply adhesive to one side only.
- 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.
- Permabond Double Bubble will cure at temperatures as low as 0°C but care must be taken to ensure the surfaces are not coated with condensation.

Storage and Handling

Storage Temperature	5 to 25°C
Shelf Life Stored in original, unopened sachets	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.

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

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.