

# Permabond®

## Polyurethane Adhesives

ISO 9001:2015 Certified  
"Our Science ... Your Success"

Permabond polyurethane adhesives have been developed to meet the growing demands of industrial engineers. Polyurethanes form resilient bonds to a variety of substrates. Products are available with different set times to suit production requirements. These black adhesives provide virtually invisible bonds on black leather, carbon fibre and rubber. Polyurethanes are ideal for many bonding applications including bonding composites, plastics and leather in the automotive industry. Products are available with long working life to allow use on large bonding and potting areas.

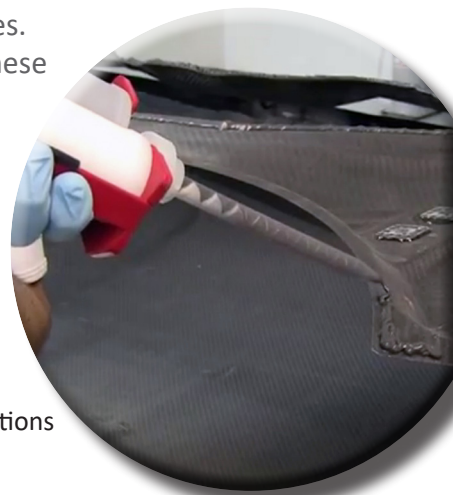
### Permabond® PT321/PT326/PT328 Features & Benefits

- Various set times for large & small parts
- Adhesion to a wide range of substrates
- Ideal for bonding dissimilar materials
- High shear and peel strength
- Ease of application
- Ideal for composite bonding
- Excellent impact resistance
- No primer needed
- Excellent resistance to harsh environmental conditions

#### Product Data

Grade	PT321	PT326	PT328
Key feature	Fast, Strong	Moderate Pot Life	Extended Pot Life
Colour Part A	Black	Black	Black
Colour Part B	Cream	Cream	Cream
Viscosity Part A cP (mPa.s)	4,000-8,000	4,000-8,000	4,000-8,000
Viscosity Part B cP (mPa.s)	3,000-6,000	3,000-6,000	3,000-6,000
Specific Gravity Part A	1.25	1.25	1.25
Specific Gravity Part B	1.45	1.45	1.45
Mix Ratio	1:1	1:1	1:1
Bond Gap Fill	5mm	5mm	5mm
Pot Life	1 - 1.5 min	4 - 7 min	15 - 20 min
Handling Strength	10 - 15 min	60 - 90 min	90 - 120 min
Full Strength cured @ 23	24 hours	4-5 days	4-5 days
Full Strength cured @ 90°C	30 min	30 min	30 min
Hardness	D 70 - 80	D 65 - 75	D 60 - 75
Elongation	<10%	<15%	<20%
Shear Strength Grit Steel	18 - 25 N/mm <sup>2</sup>	12 - 20 N/mm <sup>2</sup>	12 - 18 N/mm <sup>2</sup>
Tensile Strength	20 - 25 N/mm <sup>2</sup>	16 - 25 N/mm <sup>2</sup>	15 - 25 N/mm <sup>2</sup>
Temperature Range	-40 to +120 °C	-40 to +120 °C	-40 to +120 °C

For full technical information, please refer to product data sheet



Ideal for bonding:

- Carbon Fibre
- FRP
- Glass
- Leather
- Metals
- Plastics
- Rubber
- Wood

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**Permabond®**  
Engineering Adhesives

