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Technical Data Sheet

Permatex® Plastic Bond

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PRODUCT DESCRIPTION

Permatex® Plastic Bond is a two part, hand kneadable, putty type industrial strength epoxy in stick form. Contrasting grey and white colored materials are mixed together to form a uniform off-white color to indicate thorough mixing. After 3 hours, Plastic Bond can be drilled, sanded, sawed, machined or painted and it is resistant to water and most solvents. Plastic Bond is also NSF approved for use with repairs that are exposed to potable water. **Permatex® Plastic Bond is not intended for bonding Polyethylene and Polypropylene.**

PRODUCT BENEFITS

- Easy to use
- No heating required
- Sets in 25 minutes
- Cures and useable in 3 hours
- Good moisture resistance
- Safe for repairs that come in contact with drinking water
- Withstands moderate temperatures
- Cured material will not shrink
- Non-flammable
- Contains no solvents or VOC's

Bonds to most plastics including:

- PVC
- ABS
- CPVC
- Fiberglass
- Vinyl
- Many Hard and Semi-Flexible Plastics
- **Plastic Bond does not bond Polyethylene and Polypropylene Plastics**

DIRECTIONS FOR USE

1. Before starting, make sure your work area is protected from accidental spills. Surfaces must be clean, dry and free of grease and oil. **Note: Wear impervious gloves when mixing or handling uncured Plastic Bond.**
2. Roughen smooth surfaces to be repaired with sandpaper or mechanically.
3. Cut off required amount of epoxy stick and knead with fingers to a uniform color. This should take no longer than two minutes. **Note: After mixing, Plastic Bond has a 10 minute work life.**
4. Apply to the surface to be repaired. Force into cracks or holes to be filled. Excess material can be removed, before it is cured, with a tool wetted with clean water.
5. On wet or damp surfaces, work material into area forcefully and hold in place until adhesion begins. Do

not use hands to hold in place as heat is given off during cure.

6. After 10 minutes, the epoxy will harden.
7. After 3 hours, the cured material can be drilled, sanded, sawed, machined or painted.

For Cleanup

1. Cleanup must be completed before the product has cured. Use acetone or mineral spirits for project/tool cleanup.
2. Clean hands with Permatex® Fast Orange® hand cleaners.

PROPERTIES OF UNCURED MATERIAL

	Typical Value
Chemical Type	Epoxy and mercaptan resins
Appearance	grey outside, white inside
Odor	Slight mercaptan
Specific Gravity (mixed)	1.6 g/ml
Flash Point, SCC, °F	>200
Mix Ratio	1:1
Tensile Strength, steel	350 psi

TYPICAL CURING PERFORMANCE

Permatex® Plastic Bond has a set up time of 25 minutes, functionally cures in 3 hours, and fully cures in 24 hours.

TYPICAL ENVIRONMENTAL RESISTANCE

Temperature Resistance	Typical Values
Continuous, °F Maximum	-40°F to 250°F
Intermittent, °F Maximum	-40°F to 300°F

Chemical / Solvent Resistance

This product retains effective properties when in contact with water, hydrocarbons, ketones, alcohols, esters, halocarbons, aqueous salt solutions, and dilute acids and bases.

GENERAL INFORMATION

This product is not recommended for use in pure oxygen and/or oxygen rich systems and should not be selected as an adhesive for chlorine or other strong oxidizing materials.

For safe handling information on this product, consult the Material Safety Data Sheet, (MSDS).

ORDERING INFORMATION

Part Number	Container Size
84330	2 oz. Plastic Bond with vial, carded

NOT FOR PRODUCT SPECIFICATIONS.

THE TECHNICAL DATA CONTAINED HEREIN ARE INTENDED AS REFERENCE ONLY.

PLEASE CONTACT PERMATEX, INC., TECHNICAL SERVICE DEPARTMENT FOR ASSISTANCE AND RECOMMENDATIONS FOR YOUR SPECIFIC APPLICATION.
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STORAGE

Products shall be ideally stored in a cool, dry location in unopened containers at a temperature between 8°C and 28°C (46°F and 82°F) unless otherwise labeled. Optimal storage is at the lower half of this temperature range. To prevent contamination of unused product, do not return any material to its original container.

NOTE

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