PERMABOND® ET5322

Two-Part Epoxy

Provisional Technical Datasheet

Features & Benefits

- Long open time
- Low exotherm
- Low viscosity

Description

PERMABOND® ET5322 is a low viscosity two-part adhesive with a long open time and low exotherm, even when cured at elevated temperatures. The low viscosity of ET5322 enables the adhesive to flow into small gaps, making it ideal for bonding membrane filters.

Physical Properties of Uncured Adhesive

	ET5322A	ET5322B
Chemical composition	Epoxy Resin	Polyamine Hardener
Appearance	Colourless	Amber
Viscosity @ 25°C	20rpm: 20,000-30,000 mPa.s *(cP)*	20rpm: 500-1,000 mPa.s *(cP)*
Specific gravity	1.16	0.97

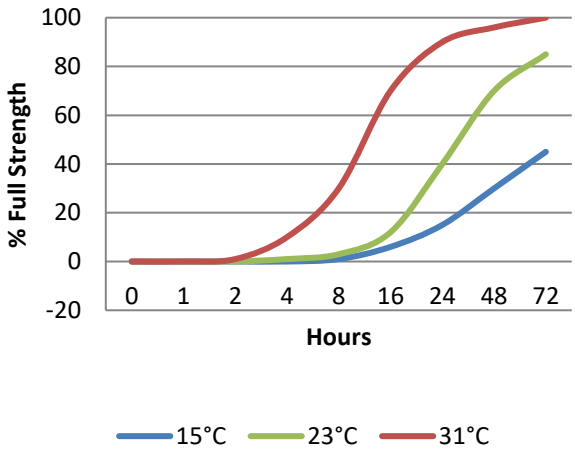
Typical Curing Properties

Mix ratio by volume	100:10
Mix ratio by weight	100:12
Usable / pot life @23°C	6 hours
Working strength @23°C	24 hours
Full cure @23°C	72 hours

Typical Performance of Cured Adhesive

Hardness (ISO868)	75-85 Shore D

Strength Development



Graph shows typical strength development of bonded components. An increase of 8°C in temperature will halve the cure time. Lower temperatures will result in a slower cure time.

Additional Information

This product is not recommended for use in contact with strong oxidizing materials.
Information regarding the safe handling of this material may be obtained from the safety data sheet.
Users are reminded that all materials, whether innocuous or not, should be handled in accordance with the principles of good industrial hygiene.

Storage & Handling

Storage Temperature	5 to 25°C *(41 to 77°F)*

Surface Preparation

Surfaces should be clean, dry and grease-free before applying the adhesive. Use a suitable solvent (such as acetone or isopropanol) for the degreasing of 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.

Directions for Use

1. Measure or weigh the material in the correct ratio.
2. Mix the resin and the hardener thoroughly.
3. Apply material to one of the substrates taking care not to entrap air.
4. Join the parts.
5. Large quantities and/or higher temperature will decrease the usable life or pot life.
6. Apply pressure to the assembly by clamping for 24 hours to ensure that working strength is obtained.
7. Full cure will be obtained after 72 hours at 23°C (73°F). Heat can be used to accelerate the curing process.

Video Links

Surface preparation:
https://youtu.be/8CMOMP7hXjU

Two-part epoxy directions for use:
https://youtu.be/GRX1RyknYqc

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