



Toll Free: 87 PERMATEX  
(877-376-2839)

10 Columbus Blvd., Hartford,  
Connecticut 06106

6875 Parkland Boulevard, Solon  
Ohio 44139

## Technical Data Sheet

### Permatex® Plastic Bonder

AAM Revised 10/02

#### PRODUCT DESCRIPTION

S.I.N.: 834-300

Permatex® Plastic Bonder is designed with an activator/primer for use with low surface energy plastics such as polyethylene and polypropylene but will work on any type of plastic. The activator is designed for use with the supplied plastic bonding adhesive but will work with most cyanoacrylate type (super glue) adhesives.

#### PRODUCT BENEFITS

- No mixing required
- Increases bond strength
- Works with many plastics

#### TYPICAL APPLICATIONS

For priming polyolefinic plastics such as polyethylene and polypropylene or other low surface energy substrates. The activator may be used with other types of adhesives, including epoxies.

#### DIRECTIONS FOR USE

1. Protect the work surface against accidental spills, as cyanoacrylates can mark finishes and fabrics.
2. Clean and ensure a close fit on the surfaces to be bonded.
3. Apply the primer/activator to both surfaces to be bonded. Use the brush top cap to ensure primer is applied to the entire surface to be bonded.
4. Allow the primer to dry completely, about 30 seconds.. Extra coats are not needed.
5. After the primer has dried, apply the glue to one of the surfaces. Use sparingly, one square inch of surface area requires only one drop of glue.
6. Assemble the parts immediately. Hold the surfaces to be bonded together for 15 to 30 seconds. No clamping is required. DO NOT REPOSITION THE PARTS.
7. Replace the cap, and store the glue in a cool spot.
8. Allow the parts to cure overnight.

#### For Cleanup

1. To remove Super Glue, use Super Glue Remover, acetone or nail polish remover that contains acetone.
2. To remove from hard surfaces such as Formica®, saturate a soft cloth or paper towel with the acetone and allow to rest on the spot for about 10 – 15 minutes. After the Super Glue is removed, a white or light colored spot may be left which is easily removed by applying vegetable oil or olive oil to the spot to restore the color.
3. Clean hands with Super Glue Remover or acetone then use Permatex® brand hand cleaners.

#### PROPERTIES OF UNCURED MATERIAL

##### Activator

Chemical Type  
Appearance  
Odor  
Specific Gravity  
Flash Point, TCC, °F

##### Typical Value

Amine  
Clear liquid  
Ketone odor  
0.79  
1

##### Adhesive

Chemical Type  
Appearance  
Odor  
Specific Gravity  
Flash Point, TCC, (°F)

##### Typical Value

Ethyl cyanoacrylate  
Clear gel  
Mild pungent  
1.1  
185

#### TYPICAL CURING PERFORMANCE

Permatex® Super Glue Gel cures on exposure to moisture. Fixture time is 15 – 30 seconds and full cure within 24 hours.

#### TYPICAL ENVIRONMENTAL RESISTANCE

##### Temperature Resistance

Continuous, °C (°F)

##### Typical Values

-54 to 82 (-65 to 180)

##### Chemical / Solvent Resistance

The product retains effective properties when in contact with most solvents.

#### GENERAL INFORMATION

**This product is not recommended for use in pure oxygen and/or oxygen rich systems and should not be selected as a sealant 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
82565	2 g tube adh, 0.1 fl. oz. activator, carded

#### STORAGE

Products shall be ideally stored in a cool, dry location in unopened containers at a temperature between 8° to 28°C (46° to 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.

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.  
PERMATEX, INC., HARTFORD SQUARE NORTH, 10 COLUMBUS BOULEVARD, HARTFORD, CT 06106 PHONE – (1-87)PERMATEX)

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