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Technical Data Sheet

Permatex® Black Plastic Welder®

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PRODUCT DESCRIPTION

Permatex® Black Plastic Welder® is a structural adhesive designed for general purpose bonding of a wide variety of materials. Black Plastic Welder® forms a tough, durable bond to most plastics, composites, ceramics, and wood in any combination. It is a fast, hard setting product with a 5 minute working time and 10 minute fixture time. **NOTE: Permatex® Black Plastic Welder® will not bond polyethylene and polypropylene plastics.**

PRODUCT BENEFITS

- Bond sets in 10 minutes
- Requires no primers
- Room temperature cure
- Gap filling to 0.125 inch
- Bonds diverse substrates
- Water resistant
- Good chemical resistance

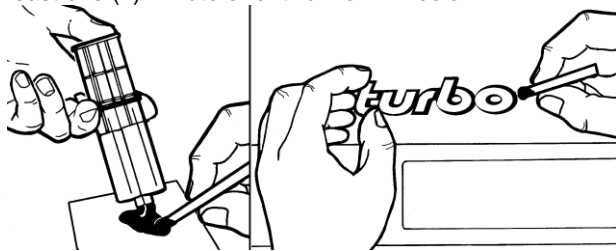
TYPICAL APPLICATIONS

Bonds rigid materials including:

- ABS
- Fiberglass
- PVC
- Vinyl
- FRP
- Acrylic
- Glass
- Styrene
- Wood
- SMC

DIRECTIONS FOR USE

1. Protect work area from accidental spills.
2. Surface must be clean, dry and free of grease & oil.
3. Roughen surfaces with sandpaper or other abrasives.
4. Remove the plastic tab from the tip of both nozzles.
5. Depress plunger on syringe to dispense Part A and Part B. Thoroughly mix on a clean, disposable surface for at least one (1) minute or until uniform in color.



6. Apply to surfaces being repaired. Assemble parts immediately. Remove excess adhesive immediately.
7. Allow bond to set for 8 – 10 minutes before moving or handling. Product fully cures within 24 hours.

For Cleanup

1. For any cleanup, use isopropyl alcohol before the material is allowed to dry.
2. Clean hands with Permatex® Fast Orange® hand cleaner or soap and water.

PROPERTIES OF UNCURED MATERIAL

| | Typical Value |
|------------------|--------------------|
| Chemical Type | Structural acrylic |
| Mix ratio | 1 : 1 |
| Appearance | |
| Part A | Black |
| Part B | Amber |
| Odor | Acrid |
| Specific Gravity | 0.94 – 1.0 |
| Flash Point, TCC | 51°F |
| Viscosity | Heavy syrup |

CURING PROPERTIES

| | |
|-------------------|-----------------|
| Working Time | 4 - 6 minutes |
| Fixture Time | 8 - 10 minutes |
| Final color | Black |
| Temperature range | -60°F to +250°F |
| Hardness | 70D |
| Elongation | 7% |

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 |
|-------------|--|
| 84145 | 5 min. Black Plastic Welder®, 0.84 fl. oz. dual syringe, carded |

STORAGE

Products shall be ideally stored in a cool, dry location in unopened containers at a temperature between 46° to 82°F (8° to 28°C) 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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