

Features & Benefits

- Brush on liquid
- Quick & easy to use
- Use with Permabond[®] TA4590 and TA4591 Structural Acrylic (TA) adhesives for rapid cure and fast strength development

Description

Permabond[®] Initiator 44 is used in conjunction with Permabond TA (structural acrylic) adhesives as a no-mix resin and initiator system. Its solvent free formulation allows a long open time if required. Alternatively, parts can be bonded immediately after application (no need to wait for evaporation).

Physical Properties

Colour	Green
Viscosity	<50 mPa.s (cP)
Flashpoint	100°C
Specific Gravity	1.1
On-part life	30 minutes
Fixture time 23°C (with Permabond [®] TA4590)*	Steel: <15-30 seconds
Shear Strength 23°C (with Permabond [®] TA4590)	Steel: 9 N/mm ² after 3 mins Steel: >20 N/mm ² after 24 hours

*Tested on steel using TA4590, single side activation. Fixture time will depend on the substrates being bonded, surface preparation, gap and whether one or two surface activation is used.

Storage & Handling

Storage Temperature	5 to 25°C
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Additional Information

Users are reminded that all materials, whether innocuous or not, should be handled in accordance with the principles of good industrial hygiene. Full information can be obtained from the Safety Data Sheet.

Directions for Use

- Surfaces should be clean, dry and grease-free prior to initiator application.
- Permabond[®] Initiator 44 should be applied either by wiping (using a clean cloth), spraying or brushing onto part. For best results it should be a thin even coating.
- Permabond[®] TA structural acrylic should be applied to the corresponding part.
- When the two parts marry, the adhesive is reacted and will cure. Parts should be clamped firmly and not disturbed for the duration of the handling time (as per table on the left).
- Excess initiator can be cleaned off using a suitable alcohol (such as isopropanol, acetone or MEK).
- For maximum bond strength, allow adhesive to cure for 24 hours.

Do not mix Permabond[®] Initiator directly with large quantities of structural acrylic adhesive.

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