

**PRODUCT DESCRIPTION**
**S.I.N.: 834-300**

Permatex® 5 min Plastic Weld is a structural adhesive designed for general purpose bonding of a wide variety of materials. 5 min Plastic Weld forms a tough, durable bond to most plastics, composites, ceramics, wood in any combination. 5 min Plastic Weld is a fast curing product with gelling of mixed adhesive in 5 - 6 minutes and fixturing in 9 - 10 minutes. NOTE: 5 min Plastic Weld will not bond most polyethylene or polypropylene plastics.

**PRODUCT BENEFITS**

- Sets in 5 minutes
- Requires no primers
- Room temperature cure
- Gap filling to 3mm
- Bonds diverse substrates
- Water resistant
- Good chemical resistance

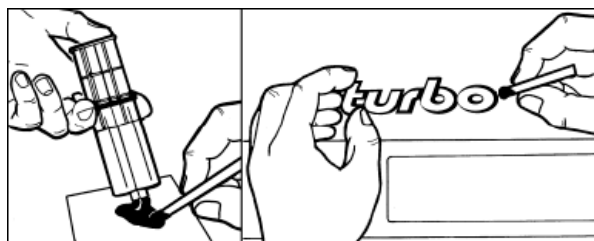
**TYPICAL APPLICATIONS**

To bond rigid materials including:

- ABS
- Fibreglass
- PVC
- Vinyl
- GRP
- 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. Use a sharp blade to cut off the tips of both nozzles.
5. Depress plunger on syringe to dispense Part A and Part B. Thoroughly mix on a clean discardable surface for at least one (1) minute or until uniform in colour.



6. Apply to surfaces being repaired. Assemble parts immediately. Remove excess epoxy immediately.
7. Allow bond to set for 9 - 10 minutes before moving.

**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	Natural
Part B	Amber
Odour	Acrid
Specific Gravity	0.94 - 1.0
Flash Point, TCC	10°C
Viscosity	Heavy syrup

**CURING PROPERTIES**

Working Time	5 - 6 minutes
Fixture Time	8 - 10 minutes
Final colour	Off white - amber
Temperature range	-50°C to +121°C
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 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
35222&35223	25 ml. dual syringe, carded

**STORAGE**

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