

HIGH PERFORMANCE FOR HIGH TEMPERATURES - ET5424

Permabond ET5424 has outstanding high temperature performance and can even replace welding!

Permabond ET5424 is a two-part epoxy adhesive that has been designed originally for the aerospace industry. Its exceptional temperature resistance, as well as its low-outgassing formulation, make it ideal for aerospace, automotive and many industrial adhesive applications while also being an excellent replacement for welding.

ET5424 cures at room temperature to form a very strong bond. With a service temperature of 230°C, it is ideal for bonding parts that later need to undergo powder coating or paint stoving. ET5424 will withstand the temperatures of the oven curing the paint, all the while providing an even stress distribution throughout the joints.

When compared to welding, ET5424 provides a 100% watertight seal and leaves no pin prick holes or unsightly stress areas. In addition, there is no specialist equipment or high skill level required, and the hazards are far lower. It can also be used in ATEX areas where welding is not allowed.



KEY FEATURES:

- ▶ Very high temperature resistance (230°C)
- ▶ Good strength retention at high temperature
- ▶ Meets ECSS-Q-ST-70-02C requirements for thermal outgassing
- ▶ High shear strength
- ▶ Room temperature cure (heat speeds up cure)
- ▶ Long open time for accurate part alignment
- ▶ Good replacement for welding
- ▶ Reduced-hazards SDS
- ▶ Suitable for manual or automated dispensing systems
- ▶ Cured adhesive can be painted / go through paint bake process

IDEAL FOR BONDING:

- Aluminium
- Carbon Fibre
- Composite materials
- FRP
- Mild Steel
- Stainless Steel
- *And many more*





DESCRIPTION

The following technical data for Permabond ET5424 is a guideline and does not constitute a specification. For full technical information, please refer to the technical data sheet, available at www.permabond.com. Please contact Permabond to discuss your bonding project.

	ET5424
Description	Two-part epoxy
Appearance	Dark grey (mixed)
Features	4:1 mix ratio adhesive, Low outgassing, high temperature resistance
Viscosity	~200,000 (cP) mPas (mixed)
Shear Strength mPa ² @23°C after 5 days	Aluminium: 22-27 / Mild Steel: 20-25 / Stainless Steel: 24-29 / Carbon Fibre: >20 **SF
Full cure	23°C - 3-5 days / 66°C - 1 hour
Working Strength	24 hours
Storage	Temperatures between 5 and 25°C
Packaging	6 x 400ml cartridges / 1x5kg (part A) / 1x5kg (part B)

The table below shows the performance of ET5424 across a range of temperatures. This product retains good strength performance even at very high heat, making it ideal for paint stoving & powder coating applications and also means it's an ideal replacement for welding.



WWW.PERMABOND.COM

Authorised distributor stamp:



info.americas@permabond.com US - 800-640-7599

info.europe@permabond.com UK - 0800 975 9800

info.asia@permabond.com Asia + 86 21 5773 4913