Permabond®
Engineering Adhesives

FOOD GRADE EPOXY ADHESIVES



Permabond has introduced a range of epoxy adhesives which have been formulated using FDA approved raw materials. These adhesives comply with CFR 175.105 or CFR 175.300 and are ideal for bonding and sealing food contact equipment and appliances.

A global team of technical, sales, and distribution professionals are specially trained to ensure they can assist you in selecting the most appropriate standard or custom formulated product for your unique application. Our team looks forward to hearing from you.

KEY FEATURES:

- Room temperature cure or heat for a faster cure
- Excellent shock and impact resistance
- Good environmental durability
- Bond a wide variety of substrate materials
- Easy to apply from dual cartridge
- Gap filling products available
- High shear strength and high peel strength
- High level of toughening







IDEAL FOR BONDING:

- Stainless Steel
- Mild Steel
- Aluminum
- Ceramics
- Composites
- Glass

...and many more!

2-Part epoxy adhesives offer a quick and easy way of bonding a wide variety of substrates including, metals, composites, ceramics, and glass. They allow accurate alignment of parts and, if necessary, can be cured quickly by applying heat. They cure to form a high strength rigid solid which is non-porous and can be easily cleaned. They offer excellent resistance to water, food, cleaning fluids, and heat.



Technical Data	ET5145	ET5147	ET 5164
Temperature Range	-40 to +80°C (-40 to +175°F)	-40 to +120°C (-40 to +250°F)	-55 to 70°C (-67 to 158°F)
Appearance	Off-white	Off-white	Off-white
Mixed Viscosity	Thixotropic Paste	Thixotropic Paste	Thixotropic Paste
Mix Ratio	1:1	2:1	1:1
Maximum Gap Fill	2mm (0.08in.)	2mm (0.08in.)	2mm (0.08in.)
Pot life @ 23°C	50 - 80 minutes	40 - 60 minutes	50 - 70 minutes
Time to Working Strength @ 23°C	16 hours	16 hours	8 hours
Time to Working Strength @ 60°C	30 minutes	30 minutes	20 minutes
Shore D Hardness	80	70	80
Shear Strength	19-21 N/mm^2 (2800-3000 psi)	18-20 N/mm^2 (2600-2900 psi)	17-23 N/mm^2 (2465-3335 psi)
Peel Strength	30-50 N/25 mm (7-11 PIW)	40-70 N/25 mm (9-16 PIW)	-
Complies with	**CFR 175.105**	**CFR 175.105**	**CFR 175.300**

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The information given and the recommendations made herein are based on our experience and are believed to be accurate. No guarantee as to, or responsibility for, their accuracy can be given or accepted, however, and no statement herein is to be treated as a representation or warranty. In every case we urge and recommend that purchasers, before using any product, make their own tests to determine, to their own satisfaction, its suitability for their particular purposes under their own operating conditions. Always refer to current product technical datasheet for most recent and accurate technical information.