



- TWO PART EPOXY**
- Benefit
- High peel strength increases design versatility
 - 1:1 mix ratio of most Permabond 2-component epoxies reduces equipment costs
 - Durability increases material choices
 - Rapid cure increases production rates
 - Room temperature cure reduces equipment & energy costs
 - Solvent free improves workplace safety
 - Low odour improves workplace environment



Grade	Description	Colour	Mixed Viscosity mPa.s = cP	Max. Gap Fill (mm) in	Pot Life	Handling Strength	Shear Strength (N/mm ²) psi	Peel Strength (N/25mm) PIW	Service Temp. (°C) °F	Availability
ET500	Very fast curing, clear, non-yellowing.	Clear, transparent	13,000-24,000	(2.0) 0.08	3 - 4 mins	5 - 8 mins	(12-18) 1750-2600	(5-20) 1-4	(-40 to +80) -40 to +175	Worldwide
ET505	Tough, structural multipurpose adhesive for bonding a wide variety of materials.	Amber	12,000-27,000	(2.0) 0.08	1 - 2 hours	3 - 5 hours	(18-21) 2600-3000	(60-80) 13-18	(-40 to +80) -40 to +175	Worldwide
ET510	Rapid curing and flexible for excellent impact and peel resistance.	Clear, transparent	22,000-39,000	(2.0) 0.08	10 - 20 mins	20 - 40 mins	(8-12) 1200-1750	(70-90) 16-20	(-40 to +80) -40 to +175	Worldwide
ET514	Toughened. Excellent flow control.	Grey	Thixo	(2.0) 0.08	30 - 50 mins	60 - 120 mins	(18-20) 2600-2900	(60-80) 13-18	(-40 to +100) -40 to +215	Worldwide
ET515	Clear and flexible, again with excellent peel and impact resistance.	Slightly amber	12,000-22,000	(2.0) 0.08	10 - 20 mins	20 - 30 mins	(8-12) 1200-1750	(70-90) 16-20	(-55 to +100) -65 to +215	Worldwide
ET536	Toughened, thixotropic, excellent gap fill and flow control.	Grey	Thixo	(5.0) 0.2	50 - 80 mins	90 - 120 mins	(15-24) 2200-3500	(60-80) 13-18	(-40 to +80) -40 to +175	Worldwide
ET538	Toughened, thixotropic, excellent gap fill and flow control. Long pot life for large assemblies.	Grey	Thixo	(5.0) 0.2	120 - 150 mins	3 - 5 hours	(18-20) 2600-2900	(60-80) 13-18	(-40 to +80) -40 to +175	Worldwide
ET5401	Toughened, 2:1 mix ratio, excellent gap fill and no slump, high temperature resistant. Properties enhanced by heat curing.	Amber	Thick Paste	(5.0) 0.2	10 - 12 mins	60 - 90 mins	(20-30)* 2900-4400	(250-300)* 55-66	(-40 to 140°C) -40 to +280°F (continuous) (+180°C)+356°F (peak)	Worldwide



SINGLE PART EPOXY

- Benefit
- High peel strength increases design versatility
 - No requirement for weighing or mixing material
 - Durability increases material choices
 - Rapid full cure increases production rates
 - Solvent free improves workplace safety
 - Low odour improves workplace environment
 - Excellent high temperature resistance and can withstand harsh environmental conditions
 - An effective alternative to welding or brazing



Grade	Description	Colour	Viscosity mPa.s = cP	Max. Gap Fill (mm) in	Cure Schedule Options	Shear Strength (N/mm ²) psi	Service Temp. (°C) °F	Availability
ES550	Toughened, non-sagging at curing temperature, excellent environmental resistance, good thermal conductivity.	Silver-grey	1,000,000 to 2,000,000	(5.0) 0.2	130°C (266°F): 75 mins 150°C (300°F): 60 mins 170°C (338°F): 40 mins	(27-41) 4000-6000	(-40 to +180) -40 to +356	Worldwide
ES558	Toughened, free flowing at curing temperature, excellent environmental resistance, good thermal conductivity.	Silver-grey	100,000 - 300,000	(0.5) 0.02	130°C (266°F): 75 mins 150°C (300°F): 60 mins 170°C (338°F): 40 mins	(27-41) 4000-6000	(-40 to +180) -40 to +356	Worldwide
ES562	Self-levelling, free flowing at curing temperature.	White	15,000 - 30,000	(0.25) 0.01	130°C (266°F): 60 mins 150°C (300°F): 45 mins 160°C (320°F): 20 mins	(20-35) 3000-5000	(-40 to +180) -40 to +356	Worldwide
ES569	High strength bonding, non-sagging at curing temperature.	Black	250,000 to 500,000	(5.0) 0.02	130°C (266°F): 75 mins 150°C (300°F): 60 mins 170°C (338°F): 40 mins	(27-41) 4000-6000	(-40 to +180) -40 to +356	Worldwide
ES578	Good thermal conductivity, excellent electrical insulation.	Black	600,000 - 800,000	(5.0) 0.02	130°C (266°F): 75 mins 150°C (300°F): 60 mins 170°C (338°F): 25 mins	(27-41) 4000-6000	(-40 to +180) -40 to +356	Worldwide