

Glue guide between PK and PK or Other materials

Because PK have excellent chemical resistance, special glues are needed for adhesion between PK and PK or other materials.

- 1) PK: M330A
- 2) EP: Epoxy
- 3) GL: Glass

I. 1 Pack Glue test

Production	Three bond (Japan)			Selley (Australia)	
Product Name	TB1530	TB7784	TB3018	Selley's All Plastic Glue + Primer pen	
Main Material	Special Polymer	Cyanoacrylate	Acrylate	Ethyl cyanoacrylate + Primer pen	
Curing Type	Moisture hardening type	Moisture hardening type	UV Curing	Moisture hardening type	
Curing conditions	Room-temp. 24hr	Room-temp. 24hr	UV Wavelength : 365nm, Light quantity : 3000mJ/cm ²	Primer Pen print + Glue print(20~30sec), 30min room temp. aging	
Tensile shear strength	PK ¹⁾ + PK	5.3 MPa/300mm ²	2.2 MPa/300mm ²	Unable UV Curing.	8 MPa/100mm ²
	PK + EP ²⁾	5.3 MPa/300mm ²	2.9 MPa/300mm ²	Unable UV Curing	No test.
	PK + GL ³⁾	Break glass	Break glass	4 MPa/300mm ²	No test.

II. 2 Pack Glue test

Production	Three bond (Japan)	Toyo-morton (Japan)	
Product Name	TB2001 + TB2105F	TM-585-60K(S) + CAT-10	
Main Material	Epoxy + Modified polyamide amine	Polyester + Polyisocyanurate	
Curing Type	2 Pack (Glue : Hardener = 1 : 1)	2 Pack (Glue + Hardener)	
Curing conditions	Room-temp. 72hr	3~5μm → Dry : 80°C, 30sec → Press : 50°C NipRoll → Aging : 40°C, 3Day	
Tensile shear strength	PK ¹⁾ + PK	PK Elongation	4~5N Sample width : 15mm, T-type peeling, Peeling rate : 300mm/min
	PK + EP ²⁾	PK Elongation	No test.