



**Recommended adhesives for use with Victrex® PEEK™ polymer**

**Araldite AV 138/Hardener HV 998** - two-component epoxy

Ciba-Geigy Corp., Madison Heights, MI Tel.: 313-585-7200

Bond strength achieved - 2270 psi

**Loctite 3105** - light cure acrylic

Loctite Corp., Hartford, CT Tel.: 800-323-5106

Bond strength achieved - 1100 psi

**Depend 330** - two-part, no-mix acrylic

Loctite Corp., Hartford, CT Tel.: 800-323-5106

Bond strength achieved - 350 psi

**PRISM 401** - surface insensitive cyanoacrylate

Loctite Corp., Hartford, CT Tel.: 800-323-5106

Bond strength achieved - 350 psi

**Scotch-Weld 2216 B/A** - two-component epoxy

3M Industrial Specialties, St. Paul, MN Tel.: 800-362-3550

Bond strength achieved - 2580 psi

**Scotch-Weld 3532 B/A** - two-component polyurethane

3M Industrial Specialties, St. Paul, MN Tel.: 800-362-3550

Bond strength achieved - 2950 psi

Note: Due to the smooth surface on molded and extruded PEEK™ polymer components, we recommend either a chromic acid etch or mechanical abrasion to leave surface features for the adhesive to bond to. Plasma or corona treatments also significantly improve bond strength. The surfaces to be bonded should be cleaned and degreased.