

CHARACTERISTICS

- Two-component polyurethane-based adhesive
- Very fast strength build-up (after 2 hours already 80% of the final strength)
- Extremely high end strength
- Does not need air moisture to harden
- Thixotrope (does not expire)
- Odourless
- Shrink-free
- Solvent-free
- For indoor and outdoor use
- Water resistant after complete curing
- Paintable with most water- and solvent-based paints

APPLICATIONS

- Bonding of angle irons in profiles of windows, doors and gates.
- Carrossery construction.
- Metal construction.
- For the structural bonding of many materials, such as plastics (PVC, acrylic, HPL, polyester...), metal, cement, wood, glass, concrete, stone, natural stone, polystyrene, polyurethane...
 - Applications under water (if applied to dry surfaces).

TECHNICAL CHARACTERISTICS

Base	Polyurethane
Number of components	2
Curing system	Chemical curing (exothermal reaction)
Mixing ratio	1:1
Processing time (open time)	15 min.
Can be manipulated after	60 min.
Complete curing time	12 hours
Viscosity (mixture)	50 000 mPa.s (thixotroop)
Density (mixture)	1,08 g/ml
Shore hardness (mixture)	40 D
Application temperature	+10°C - +30°C
Temperature exothermal reaction	< 30°C
Temperature resistance of cured product	-40°C - +90°C
Tensile strength (*) after 48 hours of curing at 20°C	20 N/mm ²
Heat conduction coefficient	0,20 W/m.K
Shelf life, unopened packing in dry conditions between +20°C - +30°C	12 months

(*) The values are provided only as technical information and do not constitute specifications of the product.

PACKING AND COLOUR

6 x 2x200 ml (400 ml) side-by-side cartridges and 6 nozzles per box Milky

METHOD OF USE

Preparation

- The surfaces to be bonded must be free of dust, dirt, oil or grease.
- Thermoplastic materials such as PVC, polycarbonate, PMMA... can be pre-treated with isopropanol. The use of strong

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DL Chemicals nv Roterijstraat 201-203 - Zone 5 Snepbeek - 8793 Waregem - Belgium T +32 56 62 70 51 - F +32 56 60 95 68 info@dl-chem.com - **www.dl-chem.com** solvents should be avoided, as they can damage the surface.

- The pretreatment of all other surfaces can be carried out with acetone. Never use petrol or other solvents.
- For lacquered surfaces, perform a mechanical sanding operation to remove paint from the surface to be bonded and to increase the strength of the bonding.
- Allow the pre-treated surfaces to dry before applying the adhesive.
- Underfloor heating must have dilated at least 48 hours before installation.

Application

- The user must test and approve the product for the specific application required.
- Check the homogeneous mixing of the mixture. Do not use the first 2 cm product to be sure.
- Remove the protective cover and break the seal with a lifting motion.
- Use the supplied mixer nozzle. This nozzle has at least 16 elements. A nozzle with fewer elements makes complete mixing impossible, a nozzle with more elements increases the chemical reaction rate of the curing.
- Apply with a manual 2-component dosing gun for side-by-side cartridges or an accu or pneumatic gun for 2-component adhesive in side-by-side cartridges The maximum pressure is 7 bar.
- The mixture must be applied directly from the mixer nozzle to the pre-treated and dry surface in a layer of at least 0,5 mm thick.
- Bring the materials together within the processing time and press over the entire adhesive surface for 1 hour.
 For the bonding of angle irons: apply the adhesive in several layers in the profiles and place the angle iron in the adhesive.
- It is also possible to apply the adhesive by post-injection in the provided opening of the profile.
- Avoid loading the bonded parts within the hour after bonding.

Cleaning

- Materials and fresh stains can be cleaned with Parafoam Gun & Spray Cleaner, acetone or MEK.
- Cured adhesive residues can only be removed mechanically.

STORAGE

- The cartridges must be kept in the original packaging and must be protected from light and heat sources.
- Once opened, the cartridges can be stored until the expiration date (in the above conditions), with the last used mixer nozzle in place.
- Replace the mixer nozzle just before continuing to work.

SAFETY

- Avoid contact between unpolymerized substances and foodstuffs or kitchen utensils and take all necessary precautions to avoid contact with the skin, as it may cause harm to hypersensitive people.
- It is advisable to wear rubber or latex gloves and to protect the eyes well.
- After use it is recommended to wash the skin well with warm water and soap. The use of solvents is not recommended.
- It is advisable to ventilate the work area well.
- Please consult the safety data sheet at www.dl-chem.com.

RESTRICTIONS

- For professional use only.
- With direct UV load, yellowing can occur over time. The mechanical properties are not affected by UV light.
- Not suitable for structural bonding of glazing.
- Avoid contact with the edge seal of double glazing and PVB film of laminated glass.
- Not suitable for bonding PE, PP, PA, PTFE, silicone, bituminous substrates, EPDM.
- The adhesion on lacquered or coated surfaces must be tested in advance.

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