

Product Certificates / Test reports

ift Rosenheim

Examination of tensile strength of bonded frame corners of aluminium composite sections at different temperatures after diverse storage conditions.

Test report No.: 50933381

French VOC-Emission class A+

Special Properties

- » tough-elastic adhesive joint
- » Solvent-free
- » Thixotropic, does not drop off
- » Compatible with natural stone
- » Expands (foams) during the curing process!
- » Joint filling
- » Fast and homogeneous, full hardening
- » Good adhesion characteristics to several types of wood, and building material, ceramics, metal, duroplast and thermoplastic after appropriate preparation of the surface.

Product Applications

- » For universal use
- » Aluminium window and door manufacturing for bonding of corner connectors
- » Window and door construction
- » Stair construction and building trade
- » With many assembly bonding processes
- » Diverse industrial fields
- » If wood is glued, it achieves the durability class D4 as per DIN EN 204.
- » Can be over-coated with many paint systems
- » Can subsequently be powder-coated (30 min/+200 °C (+392 °F))
- » Can be ground when hard-dry

Technical Data

Basis	1-C-humidity-cross-linking polyurethane	
Colour	hard-dry	black
Viscosity	at +20 °C (+68 °F)	medium viscous-pasty
Density	as per EN 542 at +20 °C (+68 °F)	approx. 1.52 g/cm ³ (12.69 lb/gal)
Skinning time - dry	at +20 °C (+68 °F), 50 % r. H., applied quantity 500 µm (19.7 mil)-PE/PVC	approx. 7 min
Skinning time - wet	at +20 °C (+68 °F), sprayed with water; applied quantity 500 µm (19.7 mil)-PE/PVC	approx. 4 min
Functional strength	depending on application at +20 °C (+68 °F)	approx. 20 min
Curing speed	at +20 °C (+68 °C), 50 % r. H.	approx. 2.5 mm (98.4 mil) in 24 h
Curing time	at +20 °C (+68 °F), 50 % r. H. until it reaches the final strength	approx. 7 d

Applied quantity	depending on carrier material	approx. 150-200 g/m ² (4-6 oz/yd ²)
Processing temperatures	adhesive and substrates	from +7 °C (+45 °F) to +30 °C (+86 °F)

General Information

Paint the bonded workpieces only after the adhesive has cured completely; if they are painted too early, formation of paint bubbles cannot be excluded.

If permanent humidity impact is expected, the bonded joints/bonded surfaces must additionally be sealed/protected using a "suitable sealant".

Bonding of materials with different longitudinal extension must be assessed regarding their long-term behaviour, especially when they are exposed to fluctuating temperature ranges.

The cured mass changes its colour due to UV radiation but not its strength in the cured bonded joint.

Caution: the viscosity of the 1-C-PUR adhesives is approximately twice as high at +15 °C (+59 °F) as at +25 °C (+77 °F).

Skinning, joining times, as well as the required press and following processing times can only be determined accurately by self-tests because they depend on material, temperature, applied quantity, air humidity, material humidity, thickness of adhesive film, press power, and other criterions. For processing, appropriate safety allowances shall be planned in addition to the specified guiding values.

Preparation

Acclimatise the product before the application.

The surfaces of the workpieces to be bonded must be dry, and free from dust and grease.

Depending on the material surface, check if the bonding result can be improved by grinding or applying of primer.

Polyolefins (among others PE, PP) cannot be bonded without preparation, e.g. plasma- or corona treatment. If

PS-hard surfaces are bonded, generally we recommend using a primer.

For corrosion protection and for sealing of e.g. mitres and butt joints in the field of aluminium construction, the corrosion-protective sealant 0363 1-Part Adhesive or the colour variants are applied on the blank aluminium cut surfaces before the connecting elements are bonded.

Bonding

The adhesive is applied one-sided as bead on one of the parts to be bonded.

If non-absorbing materials are bonded (material humidity <8 %), water must be "sprayed very finely" onto the adhesive to achieve complete curing.

The workpieces must be fit together and pressed within the skinning time.

After they have been fit together, the parts must be fixed and pressed until functional strength has been reached.

Remove oozing adhesive when it is fresh.

If the thickness of the joints is >2.5 mm (98.4 mil), the setting times, press times and curing time are clearly longer, joint thickness ≥5 mm (196.9 mil) shall be avoided.

Bonding of metals

Bonding of aluminium, copper, brass: only on chemically pretreated or varnished surfaces; these materials cannot be durably bonded to be age-resistant without appropriate pre-treatment of the surfaces to be glued.

Due to the difficult definition of aluminium surfaces and qualities, we generally recommend gathering sufficient information from the supplier to prepare the planned bonding process optimally; sufficient qualification tests are required.

Due to their variety, age and, if necessary, additional treatment with oil or wax, anodized surfaces do not allow any general statement about wettability or bonding characteristics of these bonding surfaces.

If stainless steel is manufactured or processed, auxiliary aids, e.g. wax, oil, etc. are often used, that usually cannot be removed by simple wiping away; it turned out that after the cleaning with solvent-based cleaning agents a clearly better bonding result will be achieved after grinding, or better sand blasting, of the surface and following cleaning with solvent.

Galvanized sheet metals must generally be protected from stagnant humidity that is permanently acting on it "formation of white rust". In this case, it must be excluded that occurring humidity can get onto the bonding surface.

If metals are bonded with absorbent materials (e.g. wood, building materials, etc.), humidity can be transported slowly through the absorbent material, through the bonded joint, to the metallic surface and here, it can cause corrosion damages on the metal. Therefore, the metallic bonding surface must be equipped with an appropriate corrosion protection, e. g. varnish, powder coating!

Powder coatings with shares of PTFE cannot be bonded reliably without pre-treatment (e. g. plasma procedure).

Bonding of wood

Bonding of larch: If larch is bonded outdoors, generally 1-C-PUR-adhesives may not be used. Substances, included in the wood or possibly generated, e.g. "Arabicum Galactan", considerably destroy/weak the bonding strength. No problems are known for PVAc- and EPOXI adhesives.

If solid wood is bonded, the adhesive should preferably be applied on the two surfaces to be bonded. The press pressure shall be $>1 \text{ N/mm}^2$ ($>145 \text{ psi}$).

If solid wood is bonded for outdoor application, perform appropriate tests to achieve optimum bonding depending on wood type, weathering intensity, surface protection and dimensions of adhesive joints.

Important instructions

Only instructed personnel in specialist firms are allowed to use the product!

KEEP OUT OF REACH OF CHILDREN !

KEEP HOBBOCK, DRUM, CONTAINER, e.g. TIGHTLY CLOSED !

USE ONLY FOR APPLICATIONS MENTIONED IN THE TECHNICAL DATA SHEET !

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Please, also consider the Safety Data Sheet!

Cleaning

Remove the fresh, not cured adhesive from the surfaces. Cured adhesive can only be removed mechanically.

Storage

Store the hermetically closed original trading units in a dry place at temperatures of $+15 \text{ °C}$ ($+59 \text{ °F}$) to $+25 \text{ °C}$ ($+77 \text{ °F}$) no direct sun radiation.

While transported within the usual transport times, the

product may be exposed to temperatures of -30 °C (-22 °F) to +35 °C (+95 °F).

Storage life in unopened original packagings: 24 Months

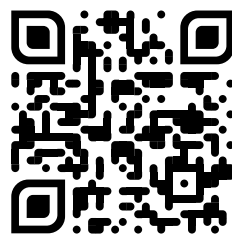
During the storage time, viscosity is increasing, reactivity is decreasing.

Packaging

- » 310 ml (10.48 fl oz) PE-Euro cartridge, net weight: 470 g (16.6 oz)
- » 600 ml (20.29 fl oz) Alu/PP-tube bag, net weight: 910 g (2.0 lb)

Other trading units on request.

Installation Guide



Scan the QR code for the Installation Guide, to ensure an accurate and compliant install.

Alternatively follow this link:
obexuk.qrd.by/0860-install