

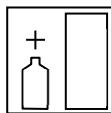
## Technical data sheet



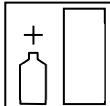
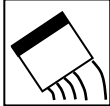
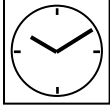
### PUR

#### Fitting adhesive

#### Application:

- Composite manufacturing industry
- manufacture of waterborne vessels (boats: motorboats and sailing yachts)
  - wind turbines
  - transport (fairings, car bodies, etc.)
  - other products made of composite (laminated) materials

CHARACTERISTICS		PUR	STANDARD
Density (component A)		1.85 – 1.95 g/cm³	PN-EN ISO 2811-1
Density (component B)		1.15 – 1.25 g/cm³	PN-EN ISO 2811-1
Gel time at 20°C		85 - 115 min	--
Colour		beige	--
Shrinkage		< 1 %	PN EN ISO 3521
Tensile strength		> 4 MPa	PN EN ISO 527
Elongation at break		> 35 %	PN EN ISO 527
Polish Register of Shipping Type Approval Certificate		TT/1337/710250/22	
SUBSTRATES			
The surface must be compact, dry, clean and free from cracks and fats.			
polyester, vinyl ester and epoxy laminates	degrease with the PLUS 780 a remover, dry sand P80 – P120, and degrease again.		
plywood, wood, varnished wood	dry sand with P80 – P120 and remove dust		
aluminium	degrease with the PLUS 780 a remover, dry sand P80 – P120, and degrease again.		
CAUTION			
The adhesive should not be applied directly on wash primers, one-component acrylic or nitrocellulose products			
PROPORCJE MIESZANIA			
	ADHESIVE (component A)  HARDENER (component B)	Ratio by weight	
		7kg	
		1kg	
PROCEDURE			
<p>Bring components A and B to room temperature. Mix at the ratio of 7:1 parts by weight with a mechanical mixer (600 rpm max.) for 3-5 minutes until a homogenous mass is obtained.</p> <p>Spread the adhesive evenly with a spatula by rubbing it lightly into the substrate. Apply the adhesive to the surface, which will bond in 60 minutes. To achieve a uniform spread of the adhesive, apply vacuum pressure for at least 3 hours.</p> <p><b>Caution:</b> Pay particular attention to thoroughly mix both components together (especially near the package walls), otherwise there is a risk that the adhesive will not bind!</p> <p>In the adhesive is applied on surfaces with the humidity above 2% CM or on primers prior to their flashing, the adhesive bond may foam which significantly decreases its properties.</p>			
YIELD			
Depending on the substrate and the type of glued material: 1.0 - 1.5 kg/m²			
APPLICATION CONDITIONS			
Ambient temperature:15 - 25°C Relative humidity: 45 - 75%			

APPLICATION	
	Clean and sand the surface
	Degrease the surface with PLUS 780
	Use the required amount of hardener. Mix the components thoroughly until a uniform consistency is obtained. Gel time at 20°C: 85 - 115 min.
	Trowel with type B notches, depending on the glued material and substrate (e.g. B3, B11)
	Curing time (min 24 hours at 20°C)
SUPPLEMENTARY PRODUCTS	
PLUS 750	
EQUIPMENT CLEANING	
THIN 850 acrylic thinner or NC solvent. Clean mechanically after curing.	
PACKAGING	
Component A 7kg Component B 1kg	
STORAGE CONDITIONS	
Store in a cool dry room, away from sources of fire and heat. Avoid direct exposure to sunlight.	
SHELF LIFE	
Component A	12 months / 20°C
Component B	6 months / 20°C
SAFETY	
See the Safety Data Sheet.	
NOTES	
Intended for professional use only.	
OTHER INFORMATION	
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