



# MAROCOL PU2/D430 + HARDENER 4300 B

## POLYURETHANE ADHESIVE

### KEY BENEFITS

- General purpose
- Long open time until 150 minutes
- Pressing time around 8 hours

### DESCRIPTION

Marocol PU2/D430 is a 2-component polyurethane adhesive without solvents.

### APPLICATION

This adhesive is specially design to Bond the different constitutive substrates of sandwich panels like:

- Different kinds of wood: plywood, fibreboard
- Non porous synthetics and metals: polyester, polystyrene foam, polyurethane foam, aluminium, steel, etc
- Stony materials: plaster

### FEATURES

- Solvent free
- Good temperature resistance from -30°C till +90°C
- Long open time of 150 minutes
- Controlled curing
- Easy and fast application

### METHOD OF USE

In general a good adhesion without a primer on polyester, polystyrene foam, polyurethane foam, plaster and plywood. On metal sheets an excellent adhesion is achieved by roughening and degreasing with acetone. For lacquered and coated surfaces we advise to remove the layers by roughening and degreasing with acetone. For detailed information about these applications, please consult Bostik.

**Application conditions:** Application temperature between +15°C and +25°C and a relative humidity between 40% and 60%.

**Substrate:** The substrate should be dry, clean and free of dust and grease. Smooth non porous materials, such as metals, should be roughened and degreased.

**Application method:** spatula, roller, calendar roll.

**Mixing ratio A:B in weight:** 100:20.

**Mixing ratio A:B in volume:** 100:25;

**Mixing:** Mix both components, in the right mixing ratio, until both components are mixed homogenous.

**Pot life C20°C/55%R.H.:** 100 minutes. The pot life depends on the amount of product, the temperature and the relative humidity. The indicated pot life is measured with 100 cc mixed product at a temperature of 20°C and a relative humidity of 55%.

**Application:** The mixture has to be applied within 100 minutes. Apply Marocol PU2/D430 one side (on strong porous surfaces two sides).

**Open time 20°C/55% R.H.:** 150 minutes.

The open time depends on temperature and the relative humidity. The open time is measured after mixing at a consumption of 200 - 400 g/m<sup>2</sup>, a temperature of 20°C and a relative humidity of 55%.

**Assembling:** After applying the adhesive, assemble the parts (within the open time) and immediately clamp or press (0,1 - 1 kg/cm<sup>2</sup>).

**Pressing time:** ca. 8 hour at 20°C. The pressing time depends on temperature and relative humidity. The pressing time is measured at a consumption of 200 - 400 g/m<sup>2</sup>, a temperature of 20°C and a relative humidity of 55%.

**Curing time:** Complete curing will take about 24 hours at a temperature of 20°C and a relative humidity of 55%. Depending on higher or lower temperatures the curing time will be shorter or longer.

**Consumption:** 200 - 400 g/m<sup>2</sup> (depends on type of substrate and on the expected differences in thermal expansion).

**Cleaning:** Uncured Marocol PU2/D430 can be removed with Solvent 5 or acetone.

| TECHNICAL DATA   |                       | A component |
|------------------|-----------------------|-------------|
| CHARACTERISTIC   |                       | VALUE       |
| Basic material   |                       | polyol      |
| Consistency      |                       | liquid      |
| Viscosity        | [mPa.s]               | ca. 10,000s |
| Specific gravity | [g/ cm <sup>3</sup> ] | ca. 1.52    |
| Colour           |                       | Beige       |

| TECHNICAL DATA   |                       | B component |
|------------------|-----------------------|-------------|
| CHARACTERISTIC   |                       | VALUE       |
| Basic material   |                       | MDI         |
| Consistency      |                       | liquid      |
| Viscosity        | [mPa.s]               | ca. 150     |
| Specific gravity | [g/ cm <sup>3</sup> ] | ca. 1.20    |
| Colour           |                       | Dark brown  |

| TECHNICAL DATA                  |                       | A + B components |
|---------------------------------|-----------------------|------------------|
| CHARACTERISTIC                  |                       | VALUE            |
| Basic material                  |                       | polyurethane     |
| Consistency                     |                       | liquid           |
| Viscosity                       | [mPa.s]               | ca. 4,000        |
| Specific gravity                | [g/ cm <sup>3</sup> ] | ca. 1.46         |
| Colour                          |                       | Beige            |
| Tensile strength<br>ASTM C 297  | [MPa]                 | > 12             |
| Shear strength<br>ASTM D 1002 * | [MPa]                 | > 5              |
| Solvent percentage              | [%]                   | 0                |
| Temperature resistance          | [°C]                  | -30 to +90       |

\* Test pieces stainless steel/ stainless steel made with an overlap of 25 mm, a layer thickness of 0.17 mm and a pull speed of 10 mm/min.

## PACKAGING

- Marocol PU2D430A: Tin 10 kg and 20 kg, drum 225 kg, container 1050 kg
- Hardener 4300B: Tin 2,2 kg and 4 kg, drum 225 kg

## STORAGE

Marocol PU2/D430 can be stored for 9 months in a closed (unopened) container in a dry and cool place at temperatures between +15°C and +25°C.

## FURTHER INFORMATION

The following publication is available on request:

- Material Safety Data Sheets (MSDS)

The information given and recommendations made herein are based on Bostik's research only and are not guaranteed to be accurate. The performance of the product, its shelf life, and application characteristics will depend on many variables, including the kind of materials to which the product will be applied, the environment in which the product is stored or applied, and the equipment used for application. Any change in any of these variables can affect the product's performance. It is the buyer's obligation, prior to using the product, to test the suitability of the product for an intended use under the conditions that will exist at the time of the intended use. Bostik does not warrant the product's suitability for any particular application. The product is sold pursuant to Bostik's Terms and Conditions of Sale that accompanies the product at the time of sale. Nothing contained herein shall be construed to imply the nonexistence of any relevant patents or to constitute permission, inducement, or recommendation to practice any invention covered by any patent, without authority from the owner of the patent.

## SMART HELP

Please contact your local representative

