



Marocol 18615

Product

Simson Marocol 18615 is a 2-component, polyurethane adhesive without solvents.

Applications

Bonding of sandwich panels existing of:

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

Features

- Solventfree.
- Good temperature resistance from -30°C till +90°C.
- Short pressing time of 4 hours.
- Controlled curing.
- Easy and fast application.
- Good bonding properties on metals.

Adhesion

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.

Method of use

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: Machine, spatula, roller, calendar roll.

Mixing ratio A:B in weight: 100:23.

Mixing ratio A:B in volume: 100:32.

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

Pot life 20°C/55%R.H.: 30 minutes. The pot life depends on the amount of product, the temperature and the relative humidity. The indicated pot life is measured with 100 gram mixed product at a temperature of +20°C and a relative humidity of 55%.

Application: The mixture has to be applied within 30 minutes. Apply Marocol 18615 on one side (on strong porous surfaces two sides).

Open time 20°C/55% R.H.: 80 minutes. The open time depends on the temperature and the relative humidity. The open time is measured after mixing at a consumption of 200 - 400 g/m², 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/cm²).



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Pressing time: Ca. 4 hours at +20°C. The pressing time depends on the temperature and the relative humidity. The pressing time is measured at a consumption of 200 - 400 g/m², 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/m² (depends on the type of substrate and on the expected differences in thermal expansion).

Cleaning: Uncured Marocol 18615 can be removed with Solvent 5 or acetone.

Technical data

A-component:

Basic material	polyol
Consistency	liquid
Viscosity A-component	32,000 ± 4,000 mPa.s
Specific gravity A-component	1.69 g/cm ³
Colour component A	beige
Packaging A-component	drum 275 kg and container 1,400 kg

B-component:

Basic material	MDI
Consistency	liquid
Viscosity B-component	150 mPa.s
Specific gravity B-component	1.20 g/cm ³
Colour component B	darkbrown
Packaging B-component	drum 225 kg

A+B component:

Basic material	polyurethane
Consistency	liquid
Viscosity mixture	4,000 ± 1,000 mPa.s
Specific gravity mixture	1.57 g/cm ³
Colour component A+B	beige

Tensile strength according ASTM C 297	> 12 MPa
Shear strength according ASTM D 1002 *	10 MPa
Solvent percentage	0%
Temperature resistance	-30°C to +90°C

* Test pieces stainless steel/stainless steel made with a overlap of 25 mm, a layer thickness of 0,17 mm and a pull speed of 10 mm/min.

Storage stability

Marocol 18615 can be stored for 9 months in an original, unopened container in a dry place at temperatures between +15°C and +25°C.

Further information

The following publication is available on request:

- Material Safety Data Sheets (MSDS Sheet)

UK

Bostik Ltd.
Stafford
Tel: +44 (0) 1785 27 27 27
Fax: +44 (0) 1785 22 26 65

France

Bostik S.A.
Paris
Tel: +33 (0) 1 74 96 91 18
Fax: +33 (0) 1 47 96 94 20

Germany

Bostik GmbH
Borgholzhausen
Tel: +49 (0) 54 25/8 01-0
Fax: +49 (0) 54 25/80 11 40

The Netherlands

Bostik B.V.
's-Hertogenbosch
Tel: +31 (0) 73 6 244 244
Fax: +31 (0) 73 6 244 344

For more Bostik locations please consult www.bostik.com

Bostik
The Adhesive Company

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