



Marocol PU2/D480

Product

Simson Marocol PU2/D480 is a thixotropic, 2-component, polyurethane construction adhesive without solvents.

Applications

Making adhesive connections 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.
- Long open time of 200 minutes.
- Controlled curing.
- Easy and fast application.

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.

Mixing ratio A:B in weight: 100:16.

Mixing ratio A:B in volume: 100:24.

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

Pot life 20°C/55%R.H.: 115 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 115 minutes. Apply Marocol PU2/D480 on one side (on strong porous surfaces two sides).

Open time 20°C/55% R.H.: 200 minutes. The open time depends on the temperature and the relative humidity. The open time is measured after mixing at a consumption of 500 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. 8 hours at +20°C. The pressing time depends on the temperature and the relative humidity. The pressing time is measured at a consumption of 500 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: Ca. 500 g/m² (depends on the type of substrate and on the expected differences in thermal expansion).

Cleaning: Uncured Marocol PU2/D480 can be removed with Solvent 5 or acetone.

Technical data

A-component:

Basic material	polyol
Consistency	liquid
Viscosity A-component	thixotropic
Specific gravity A-component	1.80 g/cm ³
Colour component A	beige
Packaging A-component	tin 1 kg and 7 kg, drum 275 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	tin 0.18 kg and 1.17 kg, drum 25 kg

A+B component:

Basic material	polyurethane
Consistency	liquid
Viscosity mixture	thixotropic
Specific gravity mixture	1.68 g/cm ³
Colour component A+B	beige

Tensile strength according ASTM C 297	> 12 MPa
Shear strength according ASTM D 1002 *	> 5 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 PU2/D480 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)

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