

METAL PANEL BOND 60

**CHEMICAL
BASE:** PU

**REACTION
TIME:** 60 MIN

COLOUR: BLACK

HARDNESS: 80 D

VISCOSITY: THIXOTROPIC

Polymix Metal Panel Bond 60 is a two component, room temperature curing, black coloured, odourless, thixotropic polyurethane adhesive specially designed for structural bonding of a wide range of materials as thermosetting and thermoplastic materials, steel, aluminium, concrete, wood and glass.

PRODUCT DATA

PROPERTIES	COMPONENT A	COMPONENT B	MIXED
Chemical base	Polyol	MDI	Polyurethane
Mixing ratio by volume	1,00	1,00	
Mixing ratio by weight	0,87	1,00	
Colour	Black	Amber	Black
Appearance	Liquid	Liquid	Thixotropic
Viscosity (mPa·s)	1.700	3.000	40.000
Relative density	1,02	1,17	1,10
Application temperature (°C)			+10 / +30
Working time			60 min
Bonding time			180 min
Fully cured time			24 h
Temperature of exothermic reaction (°C)			30
Hardness (Shore)			80 D
Elongation (%)			15%
Service Temperature (°C)			-36 / +100
Shelf life (month)			12
Storage temperature (°C)			+20 / +30



PROCESSING

The strength and durability of bonded joints depend on proper pre-treatment of the surfaces to be bonded. At the very least, joint surfaces should be cleaned with a good degreasing agent in order to remove all traces of dust, dirt, oil and grease.

Pre-treatment of thermoplastics materials such as PVC, polycarbonate, polypropylene, PMMA, etc., can be made using a mixture of light ethers or with isopropanol. Use of strong solvents is not recommended due to the risk of damage to the plastic surface.

Pre-treatment of other surfaces can be made using acetone or trichloroethylene.

Petrol or other solvents should never be used.

Where possible, carry out a mechanical abrasion to remove paint from the surfaces (where necessary) and to increase strength and resistance of the adhesion. Let dry the pre-treated area before applying the adhesive.



PRODUCT APPLICATION

Polymix Metal Panel Bond 60 is available in bi-component cartridge (side by side), or in several sizes drums.

Anyway, blending should be made through static mixer composed by a minimum of 16 elements. A lower number of components doesn't allow a complete mixing. A higher number of components would increase speed of the chemical reaction of hardening. Static mixer are disposable.

Bi-components cartridges can be used through manual applicators or specific pneumatic tools, depending on capacity and cartridge shape.

For process and in continuative applications, automatic dosing systems for low viscosity materials can be used. Base on specific needs Inchimica's technical service is available to offer advice for the correct machinery to use with specific requirements.

The mixture must be applied directly from the mixer on the pre-treated dry surface. The optimal layer of adhesive that will guarantee the highest resistance for the joint should be at least 0.5 mm thick. The components have to be assembled before the adhesive starts curing and sealed with a steady pressure all over the gluing area.

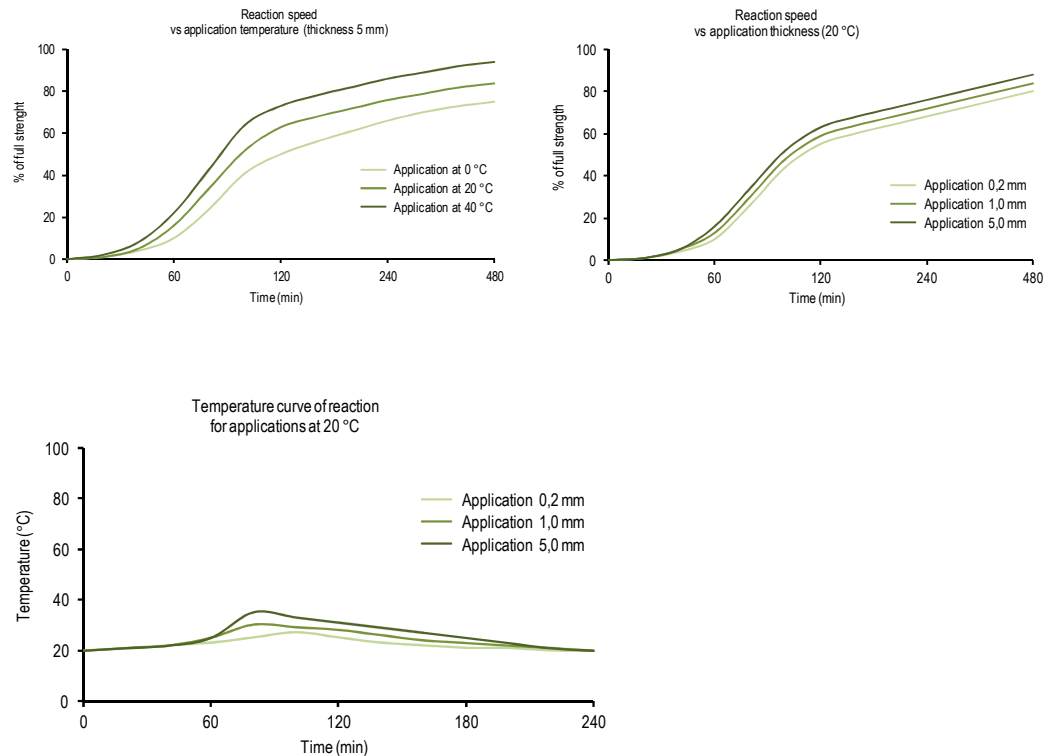


REACTION MECHANISM

The speed of the hardening reaction is mainly influenced by two factors, the application temperature and the application thickness. Being the reaction exothermic, the speed decreases as the thickness and temperature application increase.

Even if in smaller measure, the substrate influences the speed of reaction. Materials with a high coefficient of thermal conductivity will tend to slow down the reaction.

The maximal temperature of the reaction will be reached in 5 mm application thickness and is always lower than 40°C.

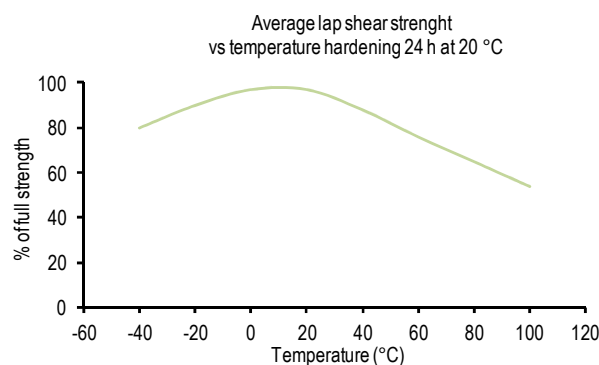


TECHNICAL CARATTERISTICS OF CURED PRODUCT

The below properties have been measured through standard samples tests, made bonding by overlapping samples of different materials of dimensions 100 × 20 × 20 mm with an adhesion area of 20 × 20 mm.

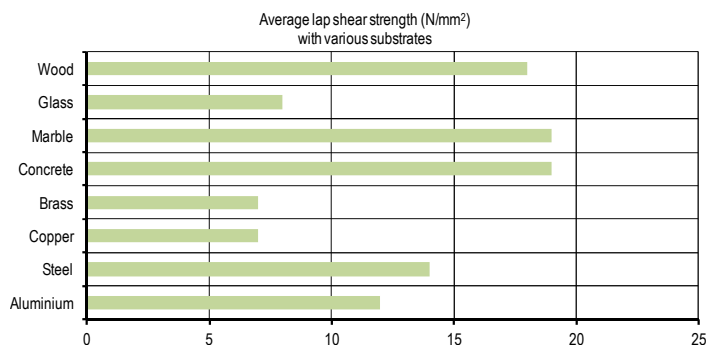
The values, obtained with standard methods on typical lots, are exclusively provided as technical information, and not as product specification.

In any case, it will be up to the user to test the product for a specific situation and then give his final approval.



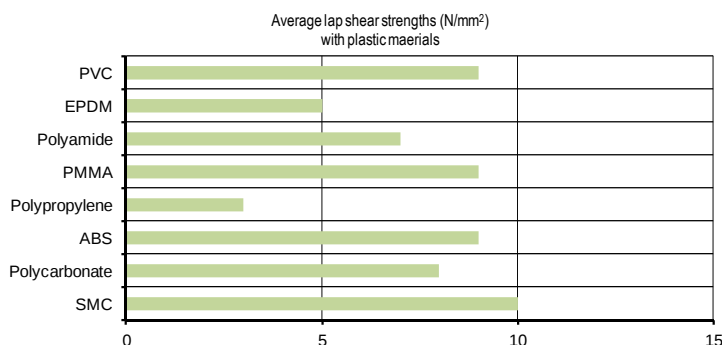
PHYSICAL PROPERTIES AT 20 °C

Tensile strength (N/mm ²)	23
Resistivity (Ω·cm)	1,2x10 ¹⁵
Dielectric constant ϵ_r	3,8
Dielectric strength (kV/mm)	25
Thermal conductivity (W/m·K)	0,21



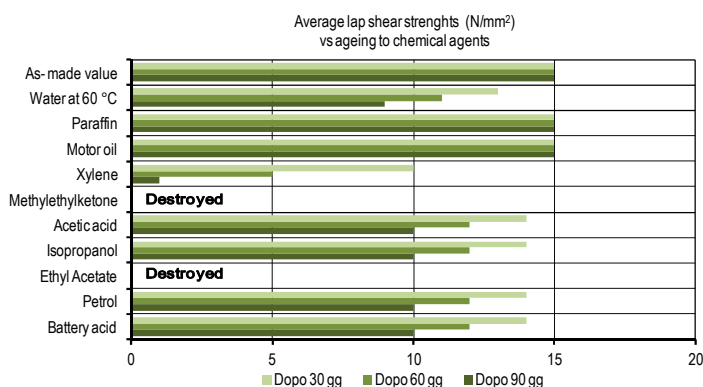
The tests have been conducted at 20°C on metal to metal joints, which have been hardened for 48 hours at 20°C.

Pre-treatment has been made by sanding and degreasing with acetone.

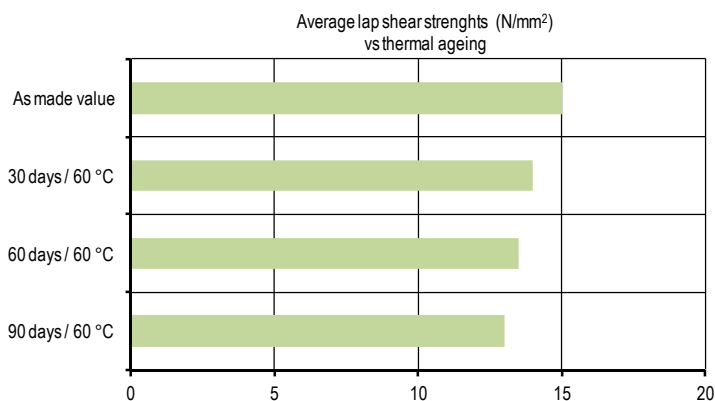


The tests have been conducted at 20°C on plastic to plastic joints, which have been hardened for 48 hours at 20°C.

Pre-treatment has been made by abrading and degreasing with isopropanol.



If not otherwise specified, the tests have been carried out at 20 °C after immersion for 30, 60 and 90 days at 20 °C on steel to steel joints which have been hardened for 48 hours at 20 °C.



The tests have been carried out at 20 °C on steel to steel joints, which have been aged at 60 °C.

At the end of the 3 thermo cycles of 24 hours each ranging from -40 °C to 100 °C, there has been no variation in the average lap shear strength.

Pre-treatment has been made by sanding and degreasing with acetone.



PRODUCT STORAGE

Polymix Metal Panel Bond 60 has a shelf life of 12 months from the initial production as long as it is stored in a cool and dry place, between +20 °C and +30 °C. Expiry date is indicated on the label.

Once opened, the cartridges will last until the expiry date (as long as the above conditions are met) leaving the last mixer used onto the cartridge.



**PRODUCT HANDLING
CAUTIONS**

Polymix products are generally quite harmless to handle provided that certain precautions are normally taken when handling chemicals.

The uncured materials must not be allowed to come into contact with foodstuffs or food utensils, and measures should be taken to prevent the uncured materials from coming in contact with the skin, since people with particularly sensitive skin may be affected.

The wearing of impervious rubber or plastic gloves will normally be necessary; likewise the use of eye protection.

The skin should be thoroughly cleaned at the end of each working period by washing with soap and warm water. The use of solvents has to be avoided. Disposable paper should be used to dry the skin.

Adequate ventilation of the working area is recommended.

These precautions are described in greater detail in the safety data sheet for the individual products and should be referred to for further information.



NOTES

The information and, in particular, the recommendations relating to the application and end-use of Inchimica® products, are given in good faith based on Inchimica®'s current knowledge and experience of the products when properly stored, handled and applied under normal conditions.

Inchimica® cannot assume responsibility for the results obtained by others over whose methods we have no control.

It is the user's responsibility to determine suitability for the user's purpose of any production method mentioned herein and to adopt such precautions as may be advisable for the protection of property and of persons against any hazards that may be involved in the handling and use thereof.

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Users should always refer to the most recent issue of the technical data sheet for the product concerned, copies of which will be supplied on request.