



## PRODUCT DATA SHEET

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### UrePac Bond 10 15

#### **Product Description**

UrePac Bond 10 15 is a single component adhesive based on polyether polyol and MDI isocyanate. The adhesive is a polyurethane pre-polymer with a surplus of isocyanate which reacts with the moisture in the atmosphere to cure the product. The product was developed as a fast reacting adhesive for bonding surfboard stringers to foam cores.

#### **Product Specification:**

220kg per 205lt Open top drum.

1100kg per 1000lt IBC

<b>Specific Gravity (22°C):</b>	1.10 +- 0.02 g/ml
<b>Viscosity (Brookfield) (22°C):</b>	5000 +- 150 m.Pas
<b>Flash Point:</b>	>200°C
<b>Appearance:</b>	White liquid
<b>Free NCO:</b>	10.0 +-0.5 %

#### **Processing Conditions:**

The curing of this adhesive is the process of a chemical reaction and therefore the temperature of the product will significantly affect the pot life of the product. The adhesive should be conditioned to at least 20°C to ensure that the product will perform as specified. If the product is heated above this temperature, the reaction between both components will take place much quicker and therefore the adhesive will have a reduced pot life. The bonding surfaces should be clean and free from oil, grease and excessive moisture. If the surfaces are completely free from moisture or will not be exposed to atmospheric moisture then a light misting with water may be necessary to fully cure the adhesive.

This product will foam slightly during cure, to expand into the surfaces, achieving a better bond. Excess foaming of the product will occur with thicker application, or excessive moisture.

## **Cured Adhesive Properties**

*The mechanical properties were measured on a test sample 0.5-1.0 mm thick after 7 days curing under normal conditions.*

<b>Gel Time (22°C):</b>	15+-5 minutes
<b>Demould time (22°C):</b>	1 hours
<b>Cured Density:</b>	1.10 +-0.02 g/ml
<b>Shore Hardness:</b>	70 +-5 Shore A
<b>Tensile Strength:</b>	10.0 N/mm <sup>2</sup>
<b>Elongation at break:</b>	350 %
<b>Tear Strength:</b>	20 N/mm
<b>Water Absorption:</b>	0.7% max

## **Storage and Handling**

UrePac Bond 10 15 will react with atmospheric moisture forming a cured skin in open containers, therefore the product should be kept in airtight drums at all times. It is advisable to seal the containers with dry nitrogen to ensure the maximum shelf life can be achieved and prevent skin formation. When kept at the proper storage temperature of 22 ± 5°C in airtight, dry drums, the material has a shelf life of six (6) months. Under no circumstances should material be stored at a temperature below 5°C.

**Please refer to the material safety data sheet for further advice on the safe handling of these products.**

**Transport Classification:                      Non Dangerous Good**