



# MAROCOL PU2D480A + Hardener 4600B

## POLYURETHANE ADHESIVE

### KEY FEATURES

- Solvent free.
- Long open time until 190 minutes
- Easy and fast application

### DESCRIPTION

Marocol PU2D480A is thixotropic 2-component polyurethane construction adhesive without solvents.

### APPLICATION

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.
- Synthetic and teak decks.

### FEATURES

- Solvent free.
- Good temperature resistance from -30°C till +90°C.
- Long open time of 190 minutes.
- Short pressing time.
- Controlled curing.
- Easy and fast application.
- Good thixotropy.
- Good bonding properties on metals.

### METHOD OF USE

In general a good adhesion without a primer on polyurethane foam, plaster and plywood. On metal sheets and polyester, an excellent adhesion is achieved by roughening and degreasing with acetone. For lacquered and coated surfaces, 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:** 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 23°C/50%R.H.:** 140 minutes. The pot life depends on the amount of product, the temperature and the relative humidity. The indicated pot life is measured with 100 g mixed product at a temperature of 23°C and a relative humidity of 50%.

**Application:** The mixture has to be applied within 115 minutes. Apply Marocol PU2D480A one side (on strong porous surfaces two sides).

**Open time 23°C/50%R.H.:** 190 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 23°C and a relative humidity of 50%.

**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 hours at 23°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 23°C and a relative humidity of 50%.

**Curing time:** Complete curing will take about 24 hours at a temperature of 23°C and a relative humidity of 50%. Depending on higher or lower temperatures, the curing time will be shorter or longer.

**Consumption:** ca. 500 g/m<sup>2</sup> (depends on type of substrate and on the expected differences in thermal expansion).

**Cleaning:** Uncured Marocol PU2D480A can be removed with acetone.

TECHNICAL DATA		A component
CHARACTERISTIC		VALUE
Basic material		polyol
Consistency		Paste (thixotropic)
Viscosity	[Pa.s]	ca. 10,000
Specific gravity	[g/cm³]	ca. 1.80
Colour		Beige
Packaging		Can 7 kg, Drum 275 kg

TECHNICAL DATA		B component
CHARACTERISTIC		VALUE
Basic material		MDI
Consistency		Liquid
Viscosity	[mPa.s]	ca. 200
Specific gravity	[g/cm³]	ca. 1.23
Colour		Dark brown

TECHNICAL DATA		A + B components
CHARACTERISTIC		VALUE
Basic material		polyurethane
Consistency		Paste (thixotropic)
Viscosity	[Pa.s]	ca. 1,900
Specific gravity	[g/cm³]	ca. 1.68
Colour		Beige
Tensile strength DIN 53504/ISO 37*	[MPa]	5
Elongation* DIN 53504/ISO 3*7	[MPa]	16
Solvent percentage	[%]	0
Temperature resistance	[°C]	-30 to +90

\* Test performed at 23°C/50% relative humidity. Tested after 14 days of curing.

## PACKAGING

Marocol PU2D480A: Can 7 kg, Drum 275 kg.  
Hardener 4600B: Container 1200 kg, 250kg drum.

## STORAGE

Marocol PU2D480A and Hardener 4600B can both be stored for 12 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:

- Safety Data Sheets (SDS).

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

