



# XPU 18560M A+B

## POLYURETHANE ADHESIVE

### KEY BENEFITS

- Good adhesion on FRP on gel coat without the use of primer
- Long open time
- Excellent hydrolysis resistance

### DESCRIPTION

XPU 18560M A/B is a 2-component, polyurethane based, adhesive that can be cured at room temperature

### APPLICATION

XPU 18560M A/B is specifically designed for structural bonding in boat applications in particular to assemble the following materials:

- Composite material
- Fiber Reinforced Polyester (FRP)
- Thermoset material

### FEATURES

- Solvent-free, does not contain mercury salt
- Easy and fast application with automatic dosing and mixing equipments
- High mechanical properties with good flexibility
- Excellent hydrolysis resistance (cataplasma)
- Long open time
- Excellent resistance to sagging (can be applied under roof)
- high gap filling behavior in boat building
- In general good adhesion on many substrates without the use of a primer
- For detailed information, please consult Bostik

### METHOD OF USE

**Application conditions:** Application temperature between +15°C and +25°C and a relative humidity less than 70%.

**Substrate:** The substrate should be dry, clean and free of dust and grease, (ideally with a surface energy more than 40dynes/cm)

**Application method:** Automatic dosing equipment or pneumatic gun with 1/1 cartridges. : The mixture has to be applied immediately after mixing.

**Mixing ratio A:B in weight:** 100A:86B.

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

**Mixing:** Good mixing is obtained with a static mixer.

**Open time 20°C:** ca. 45 minutes. The open time depends on the temperature and the relative humidity. This value is measured on a 20 mm diameter bead of adhesive, a temperature of +23°C. but need to be checked in industrial conditions

**Assembling:** After applying the adhesive, assemble the parts within the open time and immediately clamp or press.

**Setting time (waiting time before handling):** ca. 4h at +23°C. The setting time depends on temperature, relative humidity and thickness of the bead of adhesive. The setting time is measured on a 5 mm bead thickness of adhesive.

**Curing time:** Complete curing will take at least 3 days at a temperature of +20°C. Depending on higher or lower temperatures the curing time will be shorter or longer.

**Gap filling:** this product can fill gap from 2 to 15 mm

**Cleaning:** Uncured XPU 18560M A/B can be removed with Cleaner 14.

TECHNICAL DATA		A component
CHARACTERISTIC		VALUE
Basic material		polyols
Consistency		viscous liquid
Viscosity	[mPa.s]	50,000s
Specific gravity	[g/ cm³]	ca. 1.67
Colour		grey

TECHNICAL DATA		B component
CHARACTERISTIC		VALUE
Basic material		modified MDI prepolymer
Consistency		viscous liquid
Viscosity	[mPa.s]	30,000
Specific gravity	[g/ cm³]	ca. 1.47
Colour		beige

TECHNICAL DATA		A + B components
CHARACTERISTIC		VALUE
Basic material		polyurethane
Consistency		very pasty and thixotropic
Viscosity	[mPas]	300,000
Specific gravity	[g/ cm³]	ca.1.58
Colour		grey
POT LIFE** in 100cc 23°C	[min]	ca 50
Tensile stress at break * DIN 53504/ISO 527	[MPa]	ca. 7
Elongation at break * DIN 53504/ISO 527	[%]	ca. 40

\* Tensile strength ISO 527 test sample 1A according room temperature curing, testing speed 100 mm/min

\*\* The pot life depends on the amount of product, the temperature and the relative humidity. The indicated pot life is measured with 100 cc mixed product at a temperature of +23°C.

## PACKAGING

- 18560M A: 30 kg and 250kg drum
- 18560M B: 25.8 kg and 215kg drum
- 18560M A/B dual cartridges 400ml

Fax : +49 (0)54 25/801140  
[www.bostik.de](http://www.bostik.de)

Fax : +31 (0)7 36 244 344  
[www.bostik.nl](http://www.bostik.nl)

## STORAGE

18560M A/B can be stored for 24weeks in an original, unopened container in a dry place at temperatures between +10°C and +25°C.

## FURTHER INFORMATION

The following publication is available on request:

- Material Safety Data Sheets (MSDS)

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



XPU 18560M A +B TECHNICAL DATA SHEET, SEPTEMBER 2023