

X/165/FS

PRODUCT DESCRIPTION AND CHARACTERISTICS

X/165/FS is a one part polyurethane adhesive.

Its thermal resistance improves if used in combination with a curing agent.

Highly recommended in furniture and upholstery, for bonding polyurethane foams to fabrics, fibreglass, PVC, wood and ABS.

TECHNICAL DATA

Composition:	polyurethane resin and organic solvent blend
Mode of setting:	solvent release
Colour:	opalascent colorless
Solvents:	ketones
Components:	one-part adhesive ready to use. It can be used with the addition of 3 - 5% by weight of VKL 50 , KE , KE/3 to improve thermal resistance of the bonding
Pot life (25°C, 50% R.H.):	4 hours with VKL 50 or KE , 8 hours with VKL 50
Solids content:	12 – 14% *
Viscosity (Brookfield spindle 2, speed 50 at 25° C):	250 - 500 mPa.s *

* Value valid as product supply specification on leaving factory.

METHOD OF USE

Surface preparation: in case of contaminated surfaces with oily matters or release agents, it is suggested to wipe with **ST/513 Solvent** prior to bond.

In case of more solvent-sensitive surfaces like ABS, PC-ABS, it is recommended the use of **ST/198**.

With fiberglass it is suggested to sand the surface.

Application: apply with a spray gun, nozzle \varnothing 1,5 - 2 mm., an uniform coat on to both sides to be joined.

Drying time: the minimum required is about 20 minutes.

The dried film does not tack at room temperature, so heat activate the film with IR rays or hot air at a temperature ranging from 60°C to 70°C before joining the parts.

Assembly: join the parts immediately soon after heat activation pressing by hand, roller or special counterblock. Maximum strength can be reached after 2 - 3 days after application.

Note: with bag or fitted upholstery insert the covering at cold (dried adhesive) and after correct positioning, heat activate the parts and join them.

Thinner: **ST/513**.

SAFETY AND HEALTH

See Safety Data Sheet.

STORAGE STABILITY

12 months from the date of manufacture if the product is kept sealed in the original container and stored in a dry place at temperatures between +5° and +25°C.

AVAILABILITY

Code	Pack	Unit
1100166	jerrycan 16 Kg.	-



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