

# X/2/50 SR

## PRODUCT DESCRIPTION AND CHARACTERISTICS

**X/2/50 SR** is a one component adhesive suitable for bonding in hot and cold condition plasticized PVC to itself, polyurethane, halogenated (primed) rubbers.

## TECHNICAL DATA

<b>Composition:</b>	polyurethane resin in a blend of organic solvents
<b>Mode of setting:</b>	solvent release and reaction with curing agent
<b>Colour:</b>	opalascent colorless
<b>Solvents:</b>	esters and ketons
<b>Components:</b>	one component; the adhesive can be used with the addition of 3% - 5% of <b>DESMODUR RFE</b> or <b>ATTIVATORE VKL50</b> to improve the adhesion to PVC with high plasticizer content and heat resistance of the bonds
<b>Pot life (25°C, 50% R.H.):</b>	4 hours when the hardener is added
<b>Solids content:</b>	18 – 20% *
<b>Viscosity (Brookfield spindle 4, speed 50, 25°C):</b>	3.000 - 3.500 mPa.s *

\* Value valid as product supply specification on leaving factory.



## METHOD OF USE

**Surface preparation:** it is recommended to clean the surface of plasticized PVC with a pad lightly soaked with **SOLVENTE ST/133**.

The same solvent is suitable to remove oily matters and release agents.

Onto GRP the best results are achieved roughing the surface.

Vulcanized rubbers, after solvent wiping, must be treated with halogenating **PRIMERS AC/20** or **AC/23/M**.

**Application:** spread by brush a coat of adhesive onto both the adherends.

**Drying time:** **X/2/50 SR** is contactable at cold within 10' from the application.

A longer time is generally available when bonding plasticized PVC to itself.

After this time the surfaces to be joined must be heat reactivated by infrared or hot air, at a temperature of 50° - 60°C.

**Assembly:** join the parts and press at 2 - 3 kg/cm<sup>2</sup> for 10-15 seconds.

Maximum bond strength of the adhesive is achieved after 48 hours.

Long drying times and hot application provide higher initial strength.

**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/512**.

## 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
1102425	jerrycan 16 Kg.	1



**Fratelli Zucchini S.p.A.**

Via C. Colombo, 6  
44124 Ferrara - Italy

Tel. +39 0532 782711  
Fax +39 0532 732121

info@zucchini.it  
www.zucchini.it

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