

TECHNICAL DATA SHEET

TDS N°01 / 2014.12

ACROBOND® MS 60 HV**GENERAL CHARACTERISTICS / MAIN USE :****High performance, flexible black adhesive with high green tack**

Flexible adhesive with high green tack, mainly designed as a primer-less product for using in various applications such as windshield bonding; wet in wet over-paintable or during initial few days but lacquers must be tested individually. This adhesive is mainly suitable on materials such as various metals, galvanized steel, lacquered-coated aluminium and steel, plywood, fibre reinforced Polyester / GRP, laminated units, most commonly used rigid insulating foams, glass, enamel as well as some thermoplastic materials such as PUR, ABS-PC, rigid PVC (excepted PTFE and polyolefin-based for which a special primer will be required). Adhesion on materials and paints must be tested for compatibility by carrying out preliminary trials; some primers of Acrobond® PR range may be necessary to achieve required results. Main use is in transportation (car repairing, motor vehicle industry, containers, BTR), building, composite manufacturing, marine, industry but also in many and various other industrial applications.




TECHNICAL PROPERTIES OF PRODUCT :

Chemical base	1-part, MS- polymer based, humidity curing (moisture absorption from air + material), solvent-free.
Colour	Black only; not available in other colours.
Consistency	Pasty, non sag - low slump, quite easy to apply by extrusion but high green strength.
Density	~1,25 g/cm ³ (DIN 53479)
Skin forming / curing speed	~10 minutes / ~3 mm on the first day (DIN 50014 / 23°C / 50% HR)
Shore A hardness	~56 (DIN 53505)
Elongation at tear	~350% (DIN 53504)
Mechanical strength	Tensile strength: ~4,7 N/mm ² (DIN 53504) Tear strength: ~23 N/mm (ASTM D 624, mould B).
Cured film properties	Good flexibility and resistance against humidity, weathering and temperatures from -40°C to +90°C continuously and +120°C for short intervals and even +180°C for less than 30 minutes.

PREPARATION AND PROCESSING :

Materials and Surfaces	The surfaces to be bonded must be clean, dry and free of any dust and grease. Adhesion to and compatibility with plastic materials and lacquers must be individually tested; especially plastics which may be sensitive to micro-cracking under tension such as PMMA, ABS, PC, etc. Store materials and process at temperatures not below +10°C (to prevent condensation of moisture on metal surfaces). For some materials, adhesion can be improved by cleaning (powder coated substrates with Acrodis WL in order to eliminate residual waxes on surface) or by using special primers such as Acrobond® PR 13 in most cases and Acrobond® PR 9 for polyolefin-based plastics such as PP and TPE. For special requirements or on not common materials, we do recommend achieving preliminary and adapted testing to ensure expected results. Technical department is available for any additional technical advice you might need or shared preliminary and specific laboratory testing.
Application	Use standard single-component hand, pneumatic or battery powered applicators. Apply Acrobond®, available in standard 310 ml cartridges or 600 ml foil-bags, with a blade or a putty gun by extruding the required quantity depending on expected loads. For air guns, adjust required pressure (2-6 bar).
Joining / smoothing	Immediately after extruding or latest within above mentioned skin forming time, both materials have to be joined together under a moderate pressure which allows the film to transfer to second material. We recommend to fix the bonded materials until complete curing, especially if there is a risk of flowing on vertical surfaces because of proper high weight of fixed materials. If smoothing of the joints is required, do it latest within 2/3 rd of the skin forming time; use a spatula in case of later over-painting (paint must always be tested and approved) or a neutral and compatible smoothing agent such as AM 10 which does not modify inherent properties of the sealant. Skin forming and curing time are both strongly dependant on temperature and moisture content of air and materials; high temperatures and humidity content will shorten it, lower ones do lengthen it dramatically.
Alternative products	Other products are available in our product range with different shore hardness and mechanical properties; PUR-polymer based products of our Acrobond® PU range can be more suitable especially when seals have to be over-painted.
Cleaning	Clean tools immediately after using with our cleaner Acrodis H (for uncured sealant).

RECOMMENDATIONS / STORAGE / SAFETY :

Storage	≤ 12 months (≥ +10°C to ≤ +25°C) in dry place, tightly closed original packaging; protect against frost.
Packaging / transport	310 ml cartridges (x12 units). 600 ml foil-bags and pails on demand. ADR Classification: void.
Handling precaution	Before first using, read carefully Material Safety Data Sheet (available on request). Pictograms indicating the obligation of wearing personal protective equipment:   
Labelling CLP regulation Hazard Pictograms / Signal word void	Hazard statements: void. General information: Take the regular precautions for handling and processing chemical products. Assure sufficient ventilation during processing. Avoid direct skin contact. Wear protective gloves and glasses. For professional and industrial use only.
General Information	The foregoing information represents values obtained in our laboratory and has been supplied in good faith, it shall not be construed to be legally binding, in particular, it shall not exempt the purchaser from taking responsibility for testing the product supplied so as to determine its suitability for the intended application. Given the high number of materials appearing on the market and the different methods of use, which are beyond our influence and control, we cannot accept any responsibility for the results of your work. Warranty is made exclusively for the constantly high quality of our products. Please note our terms of sales, delivery & payment.