

1-component PUR prepolymer

683.24

Meets the IMO resolution A.1/3.18 e “low flame-spread characteristics”

Application: Adhesive with functional additives for mineral aggregate panels, sandwich and composite panels made of soft wood species, for polystyrene foam, PUR foams, metals and many other substrates. Not suitable for larch. For use in shipbuilding.

Characteristics/ Directions for Use: Free of solvents and formaldehyde. Good adhesion to many substrates. Moisture-curing. Good joint-filling characteristics. High strength data. Meets the requirements of D4 according to the EN 204/205. Heat resistance level according to the Watt 91 >7 N/mm² at 80 °C, HRT 92 approx. +120 °C. Fast setting at high temperatures. With wheelmark approval. For the manufacture of building elements that have to meet the IMO Resolution A.1/3.18 e “low flame-spread characteristics”, the maximum application amount of 250 g/m² may not be exceeded. See EG Examination Certificate (Module B) No. 118.409 of the BG Verkehr.



Standard application of the adhesive is one-sided, by spatula or roller.

Processing temperature [°C]:	>+10
Appearance of the glue film:	beige
Foaming:	minimal
Pressing time at +20 °C [min]:	65 – 75 (Jowat test method)
Density at +20 °C [g/cm ³]:	approx. 1.50 (Jowat test method)

In case of non-absorbent substrates and wood with moisture content below 8 %, the adhesive film or the materials to be bonded are to be fogged. Please take care during pressing to prevent the press from gluing shut. Coat the press with a suitable Jowat® separating agent for PU adhesives. We recommend using release paper. Bonding results depend on the material properties and processing conditions. We therefore recommend preliminary customer trials.

Specification:

Viscosity at +20 °C [mPas]:	8,500 ± 1,500
(Brookfield, spindle 5, 20 rpm)	
Open time at +20 °C / 50 % RH [min]:	24 ± 4
(Jowat test method)	
Solids content [%]:	96.5 ± 3.5
(Jowat test method)	

continued on page 2

03/18 All data indicated are characteristics represented as average values. Our technical data sheets are constantly revised to represent the latest state of technology. This edition is replacing all previous ones, and is valid on the date of compilation.
Please refer to the last page of this technical data sheet for additional information.

Jowat 
 Klebstoffe

Cleaning: Before curing the prepolymer can be cleaned with a solvent-soaked rag for instance using Jowat® Thinner 401.30 or with Jowat® PUR Cleaner 402.38, after curing only mechanical removal (e.g. emery paper).

**Storage/
Transport:** In properly closed original containers, cool and dry (15 – 25 °C). Do not transport at temperatures below 5 °C. Best-before date, please refer to label on the packaging unit.

Packaging: Types of packaging and units upon request.

Remarks: **For further information concerning safety, handling, transport and disposal, please refer to the Safety Data Sheet.**

Our information on this data sheet is based on test results from our laboratories as well as on experience gained in the field by our customers. It can, however, not cover all parameters for each specific application and is therefore not binding for us. The information given in this leaflet represents neither a performance guarantee nor a guarantee of properties, nature, condition, state or quality. No liability may be derived from these indications nor from the recommendations made by our free technical advisory service.

Jowat Information

Gluing as one of the most efficient methods of bonding is constantly gaining importance and expanding into new areas of application. At the same time, the number of substrates to be bonded is also growing at an unprecedented rate. New methods and equipment to process adhesives are developed.

The in-house R & D departments of Jowat are responding with intensive efforts to keep pace with these constant changes. A highly qualified team of chemists and engineers is using the latest techniques and brightest ideas to provide the utmost in advice our customers and to make sure that they get the adhesive which meets their needs.

Our information is based on test results from our laboratories as well as on experience gained in the field by our customers. This advice, however, cannot cover all eventualities for each specific application and as such is not binding for us. Please, contact our technical service department in each case to find out what the actual technical state of development for the respective product is, and request the latest data sheet. Any use of our product without this precautionary measure would be your sole responsibility.

The processing company itself must therefore test the adhesives manufactured by us for suitability in each individual case. This applies to the first use of a sample as well as to modifications during an ongoing production.

We are therefore requesting all our new customers to test our adhesives for suitability on original parts at conditions equal to normal processing conditions. The bond has then to be subjected to the actual stress which it would undergo when in use and has to be assessed. This test is absolutely necessary.

Customers who undertake modifications during a running production are requested to pass this information on to us. Please notify us when machines are set to new parameters as well as when the substrates to be bonded are changed. Only then will Jowat be able to provide our most up-to-date information to the processor using our adhesives.

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