



Product code : 50045A

**ISOLEMFI 50045A + HARDENER 521****DESCRIPTION**

Polyurethane two parts adhesive

**AREAS OF APPLICATION**

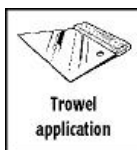
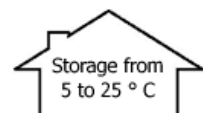
ISOLEMFI 50045A mixed with hardener 521 allows bonding of a wide variety of materials, eg: polystyrene foam, polyurethane foam, phenolic foam, foam glass, mineral wool, laminate, ceramic tiles on plaster board with cardboard or aluminium vapour shield, wood, chipboard, polyester, steel or aluminium sheets, fibrecement.

**TECHNICAL DATA**

	PART A	PART B
	ISOLEMFI 50045A	DURCISSEUR 521
Type of product	Based on polyols	Isocyanate
Colour	Beige	Dark brown
Viscosity at 20 °C	Brookfield RVT spindle 5 / 10 rpm : 17,000 ± 7,000 mPa.s	Brookfield LVT / spindle 3 / 30 rpm : 300 ± 100 mPa.s
Density at 20 °C	1.55 ± 0.03	1.23 ± 0.02
Conventional solids content (EN 827)	Ca. 100 %	100 %
Cleaner	EMFINET 683	EMFINET 683

**ADVICE**

See also the material safety data sheet of the hardener.



MIXTURE A + B	
Mixture (in weight)	Part A/ Part B = 100/20
Mixture (in volume)	Part A/ Part B = 100/25
Application temperature	15 to 30 °C
Pot life	75 ± 25 min*
Open time at 20 °C	2 h 30 min*
Pressing time at 20 °C	3 h 30 min minimum*
Final setting time at 20 °C	48 h*
Final Shore A hardness	Ca 90
Calorific power	Ca 16.5 MJ/kg
Specific data	Colour : beige Viscosity : Brookfield RVT / spindle 7 / 10 rpm : ca 8,000 mPa.s at 3 min

\*this time is valuable for a temperature of 20 °C. It is longer under 20 °C and shorter over 20 °C.

It is therefore necessary to specify precisely working and pressing times before any manufacturing ; otherwise, defective bonding could happen.

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## INSTRUCTIONS FOR USE

### Substrates preparation :

The substrates to be assembled must be flat, dry, dust free and not have any traces of grease or other contaminants that could adversely affect the bonding performance.

If the substrates need to be cleaned, use EMFINET 683, methylethylketone (MEK) or acetone.

Check the compatibility of the solvent used with the substrates.

If necessary, rub down beforehand. Clean again after rubbing down.

When using solvents, extinguish all sources of ignition and carefully follow the safety and handling instructions given by the manufacturer.

### Application :

Pour part B (hardener) into part A in the right ratio and mix homogeneously.

The reaction between the components A and B is exothermic. As a result, the temperature of the mixture may increase somewhat.

Apply this mixture uniformly with a scraper, in rope form or by spraying onto one of the substrates.

Apply a pressure between 0.2 and 0.4 daN/cm<sup>2</sup> ensuring a perfect contact between substrates and adhesive.

To specify the times, see the paragraph titled "Technical data".

### Cleaning :

Tools can be cleaned with EMFINET 683, MEK or acetone before the adhesive has completely cured. After curing, abrasion is necessary.

## CONSUMPTION

200 to 500 g /m<sup>2</sup> according to materials

## STORAGE AND SHELF LIFE

12 months in closed original packaging stored in dry premises between 5 and 25 °C

## PACKAGING

ISOLEMFI 50045A : 25 and 40 kg cans, 250 kg drums and 1,250 kg containers

HARDENER 521 : 60 and 250 kg drums, 1,250 kg containers

## SAFETY

ISOLEMFI 50045A (part A) is not classified hazardous

Hardener 521 (part B) is harmful.

Read material safety data sheets before use.

The technical data contained herein is based on our present knowledge and experience and we cannot be held liable for any errors, inaccuracies, omissions or editorial failings that result from technological changes or research between the date of issue of this document and the date the product is acquired.

Before using the product, the user should carry out any necessary tests in order to ensure that the product is suitable for the intended application. Moreover, all users should contact the seller or the manufacturer of the product for additional technical information concerning its use if they think that the information in their possession needs to be clarified in any way, whether for normal use or a specific application of our product.

Our guarantee applies within the context of the statutory regulations and provisions in force, current professional standards and in accordance with the stipulations set out in our general sales conditions.

The information detailed in the present technical data sheet is given by way of indication and is not exhaustive. The same applies to any information provided verbally by telephone to any prospective or existing customer.