



Product code : 50048E

## ISOLEMFI 50048E + HARDENER 50048B

### DESCRIPTION

Very fast curing polyurethane two parts adhesive.

### AREAS OF APPLICATION

ISOLEMFI 50048E mixed with hardener 50048B can be used for continuous bonding insulation panels (e.g. extruded or expanded polystyrene, polyurethane foam, mineral wool) to aluminium or steel.

### TECHNICAL DATA

	PART A	PART B
	ISOLEMFI 50048E	HARDENER 50048B
Type of product	Based on polyethers	Based on isocyanates
Colour	Clear yellow	Dark brown
Viscosity at 20 °C	Brookfield LVT / spindle 3 / 60 rpm : 1,200 ± 100 mPa.s	Brookfield LVT / spindle 3 / 30 rpm : 300 ± 100 mPa.s
Density at 20 °C	0.95 ± 0.05	1.23 ± 0.02
Conventional solids content (EN 827)	99 ± 1 %	100 %

### ADVICE

Read material safety data sheets of both components.



MIXTURE A + B	
Mixture (in weight)	A/B = ISOLEMFI 50048E/HARDENER 50048B = 40/60
Application temperature	15 to 30 °C
Open time at 20 °C	20 s
Temperature resistance of the assemblies	-40 to +100 °C
Specific data	Colour : dark brown Pressing time at 40 °C : ca 80 s

### INSTRUCTIONS FOR USE

Preparation of substrates :

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

They may be cleaned with EMFINET 683 or methylethylketone (MEK).

Check the compatibility of the solvent used with the substrates.

For materials sensitive to ketones, use EMFINET 688/1 or ethyl alcohol.

If necessary, rub down metal surfaces beforehand. Clean them after rubbing down.

Let dry after degreasing.

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

Application :

Application has to be done with a special two-component pump through a static mixer.

Be sure of the right ratio between both components.

Spread uniformly on the whole of one of both surfaces and assemble immediately.

Assembling has to be followed by a uniform and maximum pressure applied across the entire surface without irreversible deformation of substrates, ensuring a perfect contact between the adhesive and the substrates during setting.

The setting time depends on temperature. So it is necessary :

- in case of working under 40 °C : to be sure that the pressing time is long enough

- in case of working over 20 °C : to be sure that open time and closed assembly time are not excessive

Otherwise, defective bonding could happen.

Cleaning :

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

## CONSUMPTION

150 to 250 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

Metal containers

## SAFETY

ISOLEMFI 50048E is not classified as hazardous. Hardener 50048B is harmful.

Read material safety data sheets before use.

## PRECAUTIONS FOR USE

As reaction is exothermic, do not mix both components in a large quantity ; otherwise, temperature could increase too much and pot life would decrease.

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