



Product code : 50064A

## ISOLEMFI 50064A + HARDENER 50038B

### DESCRIPTION

Polyurethane two parts adhesive.

### AREAS OF APPLICATION

ISOLEMFI 50064A mixed with hardener ISOLEMFI 50038B can be used to bond a lot of materials , e.g. extruded or expanded polystyrene, polyurethane foam, phenolic foam, mineral wool, laminated panels, ceramic tiles to plaster boards (with or without aluminium vapour shield), wood, agglomerates, polyester, steel or aluminium sheets, fibre cement.

### TECHNICAL DATA

	PART A	PART B
	ISOLEMFI 50064A	ISOLEMFI 50038B
Type of product	Based on polyols	Based on isocyanates
Colour	Black	Green grey
Viscosity at 20 °C	Brookfield RVT / spindle 7 / 10 rpm : 70,000 ± 10,000 mPa.s	Brookfield RVT / spindle 6 / 5 rpm : ca. 17,000 mPa.s
Density at 20 °C	1.60 ± 0.05	1.52 ± 0.03

### ADVICE

Read material safety data sheets of both components.

MIXTURE A + B	
Mixture (in volume)	A/B = 100/100
Open time at 20 °C	8 min*
Final Shore D hardness	Ca. 70
Specific data	Colour : black Density at 20 °C : 1.56 ± 0.04 Viscosity at 20 °C : slightly thixotropic Shore A hardness after 30 min at 20 °C : > 25 Shore A hardness after 60 min at 20 °C : > 65



\*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.

### INSTRUCTIONS FOR USE

Preparation of substrates :

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

They can be cleaned with EMFINET 683, methylethylketone (MEK) or acetone.

Check the compatibility of the solvent used with the substrates.

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

Let dry after degreasing.

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

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

#### Application :

The mixture and application has to be done with a special two-component gun through a static mixer.

At the beginning of the extrusion, do not use the first 5 to 10 cm of the mixture.

Apply ropes of the mixture on one of the materials ; the ropes may be spread uniformly with a notched spreader. Thanks to its thixotropic consistency, the adhesive will not sag.

Take care not to exceed the open time.

Assembling has to be followed by a uniform pressure applied across the entire surface ensuring a perfect contact between the adhesive and the substrates during setting.

Refer to the table below to specify the times.

It is recommended to work at a temperature between 15 and 30 °C.

#### 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 300 g/m<sup>2</sup> according to materials

#### STORAGE AND SHELF LIFE

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

#### PACKAGING

Two-component cartridges

#### SAFETY

ISOLEMFI 50064A (part A) is irritant. Hardener ISOLEMFI 50038B (part B) is harmful.

Read material safety data sheets before use.

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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.

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