



Icema[®] R 101

Type of Adhesive 2- Component Polyurethane.

- Product Benefits**
- high viscous
 - easy to apply with tooth trowel
 - long processing time

Typical Applications Production of sandwich boards.

Suitable substrates Core materials: foam made of PVC, PU, PS, body layers made of wood, cement fibre boards, HPL, pre-treated plastics (PU, PMMA, PA, PC, ABS), glass, enamel, wood, concrete, stone and pre-treated metal (ALU, steel).

Typical Properties

| Property | Value | |
|---|--|---|
| | Component A – Icema [®] R 101 | Component B – Härter 7 |
| Base | polyurethane | isocyanate |
| Colour | pearl white | dark brown |
| Solids content | 100% | - |
| Isocyanate content | - | approx. 31% NCO |
| Viscosity | approx. 260000 mPas | approx. 200 mPas |
| Density | approx. 1.95 g/cm ³ | approx. 1.20 g/cm ³ |
| Shelf life | 24 months (at -25°C - +35°C in unopened original pack) | 12 months (at +5 - +35°C in unopened original pack) |
| Properties of the reaction product | | |
| Colour | travel white | |
| Hardness | approx. 70 Shore D | |
| Density | approx. 1.85 g/cm ³ | |



Application Instructions

- Mixing ratio: 100 : 15 (g/g)
- Pot life: approx. 120 min.
- Minimum Curing time: approx. 24 h
- Processing temperature: 15 - 25°C

- 2- component polyurethanes cure only in combination with a suitable hardener. Before processing, the hardener has to be added in the right mixing ratio and stirred homogeneously. After addition of the hardener the mixture can be used for a certain time. This time changes by environment-, and adhesion temperature and by the total quantity of the mixture as well.
- A negligible change of mixing ratio only affects the mechanical properties but not processing time or minimum curing time.
- The reaction of 2- component polyurethane adhesives strongly depends on temperature. Therefore the temperature of working process should not fall below 15°C because the curing process can be disturbed and the properties of the adhesive joint could change.
- Curing can be accelerated by heat.
- However, it is recommended not to increase temperature above 60°C.

Pre-treatment of bonding surfaces:

- Surfaces have to be clean, dry and free of grease and oil. Polyolefin materials must be corona pre-treated or flame treated. Other plastics like ABS, PS, PVC, PC etc. as well as most metals should be pre-treated with suitable primers.

Processing:

- Before processing the adhesive has to be stirred well and carefully mixed with the hardener. It has to be applied thinny to one bonding surface. It has to be applied as much adhesive till the joint between the bonding surfaces is completely filled.

Application:

- 2- component mixing machines, tooth trowel, Pfohl roller.

Because of no initial strength the bonding till curing has to be fixed or pressed until the adhesive is cured.

The adhesive must not be diluted.



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TECHNICAL DATA SHEET

| | |
|------------------------------|--|
| Cleaning Instructions | Please contact your local Sales Office for available cleaning solutions. |
| Typical Packaging | Please contact your local Sales Office for available packaging options. |
| Storage Conditions | In original sealed packaging protected from sun, dust, moisture and high temperatures. Clean and dry conditions above 15°C and below 25°C. |
| Disposal Advice | Please refer to the MSDS for disposal instructions. |
| Safety Advice | Please refer to the MSDS for safety advice. |

Our Focus is Clear. Perfecting Adhesives.

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