

## Product information

# HELAPLAST

## Transparent plastic adhesive

**Use:** Long lasting elastic adhesion with high firmness of PVC and Polyurethane for joining conveyor belts, lining reservoirs etc. by means of a one- or a two component(s) adhesive. As well as adhesion of various products made of plastic, rubber, metal, textile, leather, wood and similar materials, together and one to another.

By adding the binding material **ELASTOSAL Hardener RFE**, the gluingfirmness, the resistance against heat, emollients and dampness and the adherence can be significantly improved.

### Technical data:

Base:	polyurethane
Colour:	colourless
Spissitude:	0,85 g/m <sup>3</sup>
Viscosity:	about 2500 mPa s
Hardener:	ELASTOSAL RFE
Diluent/Cleaner:	ELASTOSAL Lösit MEK
Application meansl:	Brush, spatula
Consumption per coat:	about 150-200 g/m <sup>2</sup>
Setting time:	1 -3 min
Open time:	min. 2 hours
Ready for use after:	about 24 hours
Final hardening after:	about 48 hours
Storage:	min. 12 months
Stocking:	dry, cool, frost free

### Operation:

#### 1. Surface Pre-treatment:

The surfaces to be bound must be clean, dry, free of fat and oil. Plastic and metals need to be washed with a cleaner (**ELASTOSAL Lösit MEK** for.i.) and left for drying. Whenever possible, surfaces should be slightly roughened and totally dusted.

In case of metals, to improve the adherence, surfaces should be coated with **ELASTOSAL Metal Primer**.

#### 2. Blending (Only in case of addition of the hardener):

Blending proportions: HELAPLAST : ELASTOSAL Hardener RFE = 100 : 5 parts by weight. The duration of use (open time) of the compound is at least 2 hours with packing as closed as possible.

#### 3. Application and drying:

Application: Preferably 2 coatings. Apply a thin, even coat on both surfaces to be bound.

Drying:

*Variant 1:* Let both coats dry out (each time about 30 min.). Then reactivate the coat by means of hot air (at about 60°-70°C) and join immediately. The waiting time before reactivating should not exceed 5 hours.

*Variant 2:* Let the first coat dry completely (about 30 min.). Let the last coat dry only shortly (about 1 – 3 min) so that it is still somewhat wet before joining. If it is completely dry the coat can be reactivated by supply of hot air.

#### 4. Joining:

Put both surfaces exactly together and join them with high pressure (for i. with a roller or a hammer).

Furthermore it is important that the surfaces have full contact one to the other.

**Warning: The adhesive swells at low temperature (< 10°C) but is fit for use again when warmed up at normal room temperature!** The best working conditions are at 15-25°C and 30-75 % relative humidity. In case of bad weather conditions such as cold, rain and heavy sun, normal working conditions have to be restored by means of protections such as a provisory roof, hot air supply etc.

**Operators protection:** Take note of the danger warnings and follow the security advice on the packaging! Request the "Security Data sheet"!

**Packaging:** tin 300 g, tin 650 g, can 4 kg, can 24 kg, drum 170 kg

**Remark:** The content of this technical information is the result of lengthy research and of experience from many technical applications. All data and advice reflect our current best knowledge. They don't represent a quality guarantee and don't exempt the user from making practical tests with the product to obtain the specific requested results and goals he wants. Concerning the advice in this technical sheet, no request for indemnity will be accepted what ever the object or legal case. We reserve the right to make technical changes in line with product development. Standing 10/2015