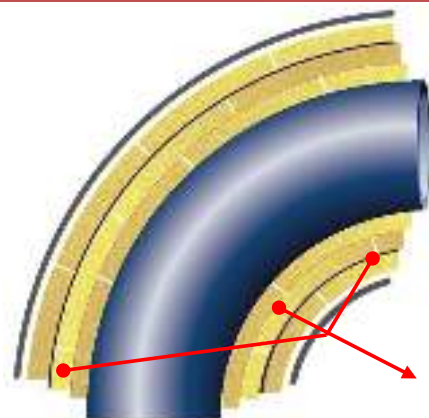


SHC 107-74

POLY CELL II ADHESIVE



SHC 107-74

MAIN APPLICATION

- ◇ Strong adhesion strength
- ◇ Adhesive for Al-foil & PIR insulation
- ◇ Bonding cold insulation for elbow and pipes

SHC 107-74 is 2 component urethane based adhesive for cold insulation.

COLOR

Part A : Cream / Part B : Brown
Mixed (A&B): Off-White

APPLICATION TOOL

Trowel, Brush

AVERAGE WEIGHT / LITER (ASTM D 1475)

1.46 ±0.05 kg/Liter ; Mixed (A&B)

AVERAGE NON-VOLATILE (ASTM D 1644)

97% ±4.6 by volume

98% ±4.6 by weight

COVERAGE RANGE (SHTM 13)

(Subject to type of surface and nature of material being bonded)

3.1 kg/m²

Wet Film Thickness: 2.1 mm

Dry Film Thickness: 2.0 mm

MIXING RATIO (by weight)

Part A : Part B = 5 : 1

POT LIFE (25°C, 50%RH) (SHTM 07)

60~90 minutes

CURING TIME (25°C, 50%RH) (SHTM 12)

Set To Touch: 6 hours

Dry Through: 20 hours

Maximum strength: 7 days

SERVICE TEMPERATURE LIMITS (SHTM 08)

(Temperature at coated surface)

-196°C ~ 93°C

WET FLAMMABILITY (ASTM D 3278)

(Part A, B or Blended)

Flash Point : Over 99°C

REMARKS

Store and apply between 4°C and 38°C.

Contains no asbestos, lead, mercury or mercury compounds.

Allow 48 hours curing time at 25°C, 50%RH minimum before placing in service.

Pot life is longer at lower temperatures, shorter at higher temperatures.

Do not heat Part A, Part B, or the mixed material to above 38°C.



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Preparation for application

- Do not thin product.
- Make sure the mixing ratio of mass of 2 component Part A(5) and Part B(1).
- Check the quantity to be applied in advance and calculate the weight of A and B. Do not mix product having 60~90 minutes of pot life more than that to be applied within 2 hours limit. The excessive will turn into being cured condition which cannot be applied.
- Apply only to clean, dry, oil-free surfaces.
- Keep the container of product firmly closed in times of not in use to prevent evaporation of oil and surface skinning.

Application Method

- Mix SHC 107-74 A and B well to be homogeneous. As the mixing heat occurred by excessive agitating shortens pot life and thereby causes fast curing of product, stir well so slowly.
- Apply SHC 107-74 at a thickness of 2.1 mm in wet, which is equivalent to 3.1 kg/m².
- Apply one side or both evenly.
- Remove any adhesives appeared between insulations by pressing firmly.
- This application provides dry film thickness of 2.0 mm.
- As rough or porous surfaces require more products, higher built thickness is recommended

Tools

- Use clean trowel or putting knife.
- Be mindful to have uniform thickness using the tools.

Clean up

- As dried product is too difficult to remove, clean them before drying.
- After dried, use mineral spirits or chlorinated solvent, once cured, employ strong solvent like xylene to clean the equipment.

SHTM : SAM HWA TEST METHOD

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The warranted shelf life is one year from date of shipment.

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