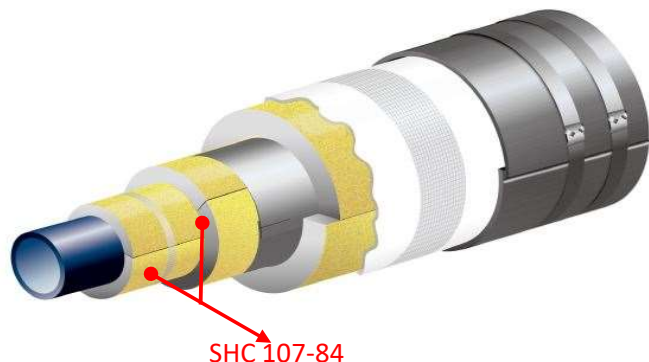


SHC 107-84

POLY CELL ADHESIVE



MAIN APPLICATION

- ◇ Bonding most cold insulation to themselves and to other surfaces
- ◇ High adhesion strength containing no flammable solvent
- ◇ Strong and flexible after curing
- ◇ 2 component adhesive
- ◇ Can be used as both an attachment adhesive and joint sealant in low temperature installations using cellular glass, polystyrene, or PU/PDP

SHC 107-84 is 2 component urethane based adhesive and joint sealant for cold insulation.

COLOR

Part A : Cream / Part B : Brown
Mixed (A&B): Amber

APPLICATION TOOL

Trowel, Brush

AVERAGE WEIGHT / LITER (ASTM D 1475)

1.35 ±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)
2.8 kg/m²
Wet Film Thickness: 2.1 mm
Dry Film Thickness: 2.0 mm

MIXING RATIO (by weight)

Parts A : Part B = 9 : 1

POT LIFE (25°C, 50%RH) (SHTM 07)

1 ~ 2 hours

CURING TIME (25°C, 50%RH) (SHTM 12)

Set To Touch: 8 hours
Dry Through: 24 hours
Maximum strength: 7 days

SERVICE TEMPERATURE LIMITS (SHTM 08)

(Temperature at coated surface)
-196°C ~ 93°C

WET FLAMMABILITY (ASTM D3278)

Flash Point: ≥93°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(9) 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 1~2 hours 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 107-84 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 107-84 at a thickness of 2.1 mm in wet, which is equivalent to 2.8 kg/m².
- Apply to both side of substrate to be applied evenly and homogenously.
- 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 brush or trowel.
- 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.