



SHC 107-84H

POLY CELL ADHESIVE COATING



MAIN APPLICATION

- ◇ Low viscosity adhesive
- ◇ Strong and flexible coating after curing
- ◇ Excellent adhesion strength for low temperature
- ◇ Non flammable solvent
- ◇ 2 component adhesive

SHC 107-84H is a glass mesh adhesive for cryogenic temperature application.

COLOR

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

APPLICATION TOOL

Spray, Brush

AVERAGE WEIGHT / LITER (ASTM D 1475)

1.48 ±0.05 kg/L ; Mixed (A&B)

AVERAGE NON-VOLATILE (ASTM D 2369)

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 = 4 : 1 (Spray)

Part A : Part B = 5 : 1 (Brush)

POT LIFE (25°C, 50%RH) (SHTM 07)

2 ~ 3 hours

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

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.

SHTM : SAM HWA TEST METHOD

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

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Preparation for application

- Do not thin product.
- Make sure the mixing ratio of mass of 2 component Part A(4) 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 2~3 hours of pot life more than that to be applied within 3 hours limit. The excessive will turn into being cured condition which cannot be applied.
- In case of surfaces consisting of Urethane Form, check the condition having the irregularities on the surfaces in advance.
- Apply only to clean, dry, oil-free surfaces and 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 107-84H 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 107-84H as first coat at a thickness of 1.05 mm in wet, which is equivalent to 3.1 kg/m².
- before set-to touch drying after first coating, embed Reinforcing Membrane or Glass cloth fully into the first coat for complete contact. Smooth the reinforcing membrane not to be folded and overlap all edges of membrane at least 50mm.
- After reinforcement work, apply finish (secondary) coat at a thickness of 1.05mm in wet.
- This application provides dry film thickness of 2.0 mm.
- The interval between the first base coating and secondary may vary depend on temperature of application.
- As rough or porous surfaces require more products, higher built thickness is recommended.

Tools

- Use clean brush or spray. Be mindful to have uniform thickness using the tools.
- For the right choice of spray equipment, consult equipment supplier in advance. Only the corrosion resistant pumps are allowed.

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.