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PU4694/100LT TWO COMPONENT POLYURETHANE ADHESIVE

**DESCRIPTION**

PU4694/100LT is a two pack universal adhesive developed for providing weather and water resistant bonding to a wide variety of substrates. The adhesive gives excellent bonds to wood, GRP, metals to insulation - extruded polystyrene, PU Foam, expanded polystyrene.

**PRODUCT APPLICATION**

One way stick:	The adhesive need be applied to one surface only.
Strong, resilient bonds:	Besides the diversity of materials that can be bonded, the cured adhesive exhibits excellent resistance to heat, cold, moisture and solvent.
Ease of application:	The adhesive is easily applied with a trowel or putty knife.

**TYPICAL SPECIFICATION**

	PU4694/100LT Part A Resin	D3488 Part B Hardener
Colour:	Buff Paste	Brown Liquid
Density:	1.58 g/cm <sup>3</sup>	1.23 g/cm <sup>3</sup>
Solids:	98 ± 2%	100%
Mixing Ratio (wt.)	5	1
Mixing Ratio (vol.)	3.91	1
Viscosity at 23°C:	9,000 ± 2,000 mPa.s	300 ± 75 mPa.s
Mix Viscosity:	5,000 ± 500 mPa.s	
Pot life*:	30 ± 3 minutes at 19°C	
Working Time*:	90 ± 5 minutes	
Handling Bond*:	230 minutes	
Coat Weight	200-350gsm	
Calorific Value:	14.9 ± 0.3 MJ/kg	

\*Dependent on local temperature and amount mixed.

Open Times and Press times as a function of Temperature

	13°C	15°C	17°C	19°C	21°C	23°C	25°C	27°C	29°C	31°C
<b>OJT (mins)</b>	117	107	98	90	82	75	68	62	56	51
<b>PT (mins)</b>	292	267.5	245.5	225	205	186.5	169.5	154.5	140.5	128

OJT: Open Joint Time (Max time open to air).

PT: Period of time required under pressure in the press.

## APPLICATION

1. Materials to be bonded must be free from surface contamination, e.g. dust and grease, etc. Roughen smooth surfaces to provide key.
2. Stir the adhesive before use to ensure uniformity.
3. Mix 1 part by weight of D3488 Part B (Hardener) to 5 parts by weight of PU4694/100LT Part A (Resin) until a mass with a uniform colour is obtained. The mixed adhesive after application remains workable for 90 minutes, dependent on the ambient temperature and the quantity mixed.
4. Apply the adhesive to one surface only.
5. Assemble the bond and hold as necessary whilst adhesive cures.
6. Remove excess adhesive immediately.
7. At a room temperature of 20°C, handling strength is obtained after 230 minutes. Do not use the adhesive in temperatures below 5°C.
8. Full cure is achieved in 4 days, dependant on temperature.
9. Always re-seal both containers after use

## STORAGE

Stored in unopened original containers, PU4694/100LT Part A will have a shelf life of one year. D3488 unpigmented has a shelf life of 1 year. However Part B pigmented versions may have a reduced shelf life. Store between 10°C to 35°C. Once opened, containers of D3488 Part B (Hardener) should be used within 10 days.

## HEALTH AND SAFETY

PU4694/100LT Part A (Resin) is not classified as a dangerous substance; however, the wearing of goggles is to be recommended.

D3488 Part B (Hardener) contains a non-volatile isocyanate. Avoid prolonged contact with skin. In cases on contact with eyes, flush out with excess water and seek medical attention. Wear goggles.

### Additional Precautions

1. Use industrial safety gloves.
2. Use suitable eye protection.
3. Before use, ensure that you have read the Health & Safety Data Sheets for this product.

The company will supply, upon request, individual advice in writing in connection with the use and application of its products in all appropriate cases. Customers are urged to make use of this service. This leaflet is provided for general guidance only. All recommendations and suggestions are made in good faith but without guarantee and are subject to the company's terms and conditions.