

SabreBond™ SE2



SabreBond SE2 is a high performance adhesive for primerless bonding of windscreens and side glass in mass transit vehicles. It has very high initial tack and green strength and rapid strength build up.

Applications

- For use in glass bonding applications in the bus, coach, automotive, rail and leisure vehicle industries.
- For glass bonding in aftermarket applications where fast drive away times are required.
- Structural elastic bonding between metal, composite, painted surfaces, and many plastics (not PE, PP or Teflon).

Characteristics

- High green strength, quick build-up of end strength, high shear strength after full cure
- High-performance mechanical properties
- Combines high stiffness with very high bond strength
- Does not contain isocyanates, silicone, solvent
- Can be sanded after full cure
- No bubble formation within adhesive
- Very easy to tool and finish
- High UV resistance
- Minimal health and safety considerations
- High specific adhesion
- Excellent long term durability
- Odourless
- No shrinkage

Technical Characteristics

| | |
|--|--------------|
| Base Material | MS Polymer |
| Consistency | Stable Paste |
| Curing System | Moisture |
| Through Cure Rate (mm/24hrs) | 3.8 |
| Density (Kg/l) | 1.4 |
| Elasticity Modulus at 100% (N/mm²) ISO 37 | 2.5 |
| Elongation at Break (%) ISO 37 | >400 |
| Tensile Strength (N/mm²) ISO 37 | >4 |
| Max Open Time (mins) | 20 |
| Shear Strength (N/mm²) ASTM D1002 - rate - 6mm/min | >3.5 |
| Shore A Hardness ±5 | 70 |
| Skin Over Time (mins) | 9 |
| Viscosity C&P @ 0.6 s⁻¹ (Pa.s) | 3500 |
| Volume Alteration (%) | <2 |
| UV Resistance ASTM G154 (CIELab - ΔE) | 0.32 |

(*) These values may vary depending on environmental factors such as: temperature, moisture and type of substrates.

Application

Method

Manual or pneumatic caulking gun.

Application Temperature

+5°C until +4 0°C.

Cleaning

White Spirit or Sabre Surface Activator immediately after application and before skin formation.

Tooling

Soapy solution before skin formation.

Repair With

SabreBond SE2. We recommend preliminary compatibility tests previous to application.

Shelf Life

12 months in unopened packaging, in a cool and dry storage place at temperatures between +5°C and +25°C.

Substrates

Nature

Clean glass and body side frame using Sabre Surface Activator. Allow 10 minutes to flash off and activate. A 'milky' white residue left on the glass is correct.

Priming

Non-fritted glass needs to be primed with Sabre Primer PX (see TDS for Sabre® PG for application). We recommend preliminary compatibility tests previous to application.

Packaging & Colour

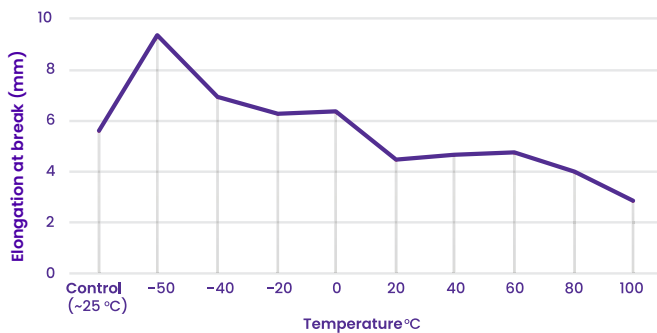
Available colours: Black

Packaging size: 290ml cartridge • 600ml foil pack • 200L on request



Sabre - Elongation at break (ASTM D1002)

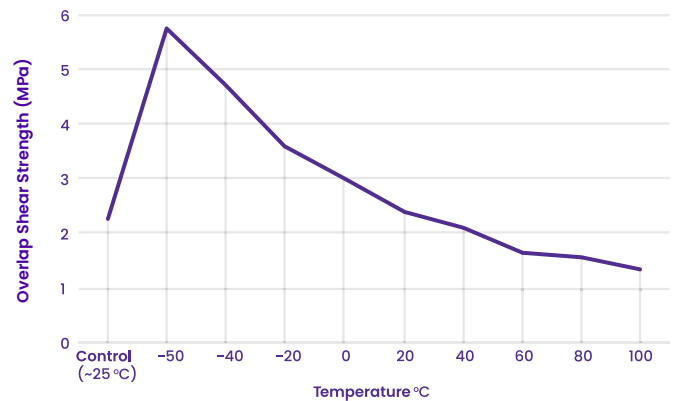
25mm overlapped joint



Resistance to Chemical Agents

Good resistance to water, aliphatic solvents, mineral oils, grease, diluted inorganic acids and alkalis. Poor resistance to aromatic solvents, concentrated acids, chlorinated hydrocarbons.

Sabre - Base temperature (ASTM D1002)



REMARKS

SabreBond SE2 can be coated with many types of paints and varnishes. Due to the large variety of paints and coatings a compatibility test is strongly recommended. The drying times of alkyd resin based paints may increase. SabreBond SE2 can be painted immediately after application "wet on wet" with waterbased industrial paints in paint ovens at temperatures of up to 200°C for up to 45 minutes. SabreBond SE2 can be applied to a wide variety of substrates. Due to the fact that specific substrates such as plastics, polycarbonate, etc. May differ from manufacturer to manufacturer, we recommend preliminary compatibility tests. This product cannot be used as glazing sealant. See specific application instruction, available on request.

DISCLAIMER

The variability of materials, substrates and conditions of use is such that no warranty of their functionality for a specific application can be deducted from this information, written recommendation or any other type of suggestion offered. Each user has the responsibility to complete adequate evaluations on the efficacy of the materials offered by Forgeway, of its products, services, recommendations and suggestions for the specific application need, and must accomplish sufficient testing to ascertain that the final product will be safe and sound for the final intent of the end user.

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