Description
PU220 is a low viscosity, rapid curing, polyurethane wood adhesive. The adhesive is highly water-resistant and can be used in applications where regular wetting and/or high humidity is anticipated.

Colour
Amber

Packaging
500 ml bottles (12 per carton)

Technical Information

<table>
<thead>
<tr>
<th>Characteristic</th>
<th>Result</th>
</tr>
</thead>
<tbody>
<tr>
<td>Composition</td>
<td>Polyurethane liquid</td>
</tr>
<tr>
<td>Conformance</td>
<td>EN204: D4</td>
</tr>
<tr>
<td>Specific Gravity</td>
<td>1.08</td>
</tr>
<tr>
<td>Viscosity (at 20°C)</td>
<td>2,000 cps</td>
</tr>
<tr>
<td>Cure Time (at 20°C)</td>
<td>30 - 40 minutes</td>
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<tr>
<td>Open Time</td>
<td>6 - 7 minutes</td>
</tr>
<tr>
<td>Application Temperature</td>
<td>+5°C to +40°C</td>
</tr>
<tr>
<td>Service Temperature</td>
<td>-50°C to +120°C</td>
</tr>
<tr>
<td>Storage</td>
<td>illbruck PU220 is protected by a blanket of nitrogen in the container prior to dispatch, which forms a dry, inert layer on top of the adhesive. Store in dry shaded conditions between +5°C and +25°C.</td>
</tr>
<tr>
<td>Shelf Life</td>
<td>9 months when stored as recommended in original unopened packaging.</td>
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</tbody>
</table>

Necessary Tools
- Suitable trowel, adhesive spreader or roller.

Protective Equipment
USE IN WELL VENTILATED CONDITIONS and ensure all recommended protective equipment is worn during handling & use of this product. For full recommendation, refer to safety data sheet.

Preparation
- Always carry out a test to confirm compatibility prior to use.
- All surfaces to be bonded must be close fitting, degreased, clean, and free from dust and any other contamination.
- Dampening the surfaces to be bonded with a moist cloth or spray can accelerate the rate of cure.
- Metals should be stored at room temperature prior to bonding to avoid chilling the glue line.
- Most coated and pre finished ready for painting metals are well suited for bonding. Some grades of aluminium galvanised steel and plastics can be difficult to bond and may require the use of a primer.

Usage / Purpose
PU220 is a low viscosity PU adhesive designed for bonding wood to wood very rapidly and is suitable for full water immersion, even in seawater. It is used to bond many types of wood, plastic foams and other insulating materials to a wide variety of both rigid and flexible facing materials. Such composites form structural sandwich panels and insulated building boards and may be used in the manufacture of cold stores, caravans, mobile homes and offices, insulated building units, etc.

Key Benefits
- Waterproof adhesive suitable for external use - meets the requirements of EN 204 (D4)
- Forms an exceptionally high bond strength to most building materials, even damp substrates
- Gap filling action achieves a high strength bond with irregular or uneven substrates
- Rapid curing and outstanding bond strength without the need for priming or surface treatment
PU220

Wood Adhesive

Application
- Apply using a trowel, notched scraper or hand roller to one of the surfaces to be bonded along the glue line. The amount applied will vary according to the porosity/smoothness of the substrates and the means of application but would normally be in the range of 80-120 ml per m².
- Once the adhesive has been applied a light misting of water should be applied. About 5-7.5% of water by weight based on the adhesive coating weight is ideal. Avoid excessive amounts of water.
- Assembly should then take place with the application of pressure/clamping as soon as possible to minimise water evaporation and within the open time of the adhesive.
- The pressure required will vary depending on the substrates used but will typically be in the range of 0.5 to 0.9 bar.
- The pressure should be maintained until the adhesive has cured sufficiently to permit handling of the bonded item.
- Full cure will not be obtained for 24 hours and handling within this period should be kept to a minimum.

Coverage
80 to 120 ml per m², depending on substrate.

Cleaning
Remove excess adhesive immediately with AA290 PU Foam Cleaner. Ensure surface is solvent resistant before cleaning. Cured adhesive can only be removed mechanically.

Please Note
Not suitable for bonding polyethylene, polypropylene, Teflon® or Nylon. Moisture content of wood must not exceed 30% w/w.

Health & Safety Precautions
Safety data sheet must be read and understood before use.