

Cl/SfB	Yt3
CAW Z20	
Uniclass L6739:P7112	

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

Property	Result
Composition	Polyurethane liquid
Conformance	EN204: D4
Specific Gravity	1.08
Viscosity (at 20°C)	2,000 cps
Cure Time (at 20°C)	30 - 40 minutes
Open Time	6 - 7 minutes
Application Temperature	+5°C to +40°C
Service Temperature	-50°C to +120°C
Storage	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.
Shelf Life	9 months when stored as recommended in original unopened packaging.

Necessary Tools

- Suitable trowel, adhesive spreader or roller.

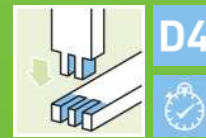
Preparation

- 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.



PU220

Wood Adhesive



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

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.



Technical Service

tremco illbruck has a team of experienced Technical Service Representatives who provide assistance in the selection and specification of products. For more detailed information, service and advice, please call Customer Service on 01942 251400.

Guarantee / Warranty

tremco illbruck products are manufactured to rigid standards of quality. Any product which

has been applied (a) in accordance with tremco illbruck written instructions and (b) in any application recommended by tremco illbruck, but which is proved to be defective, will be replaced free of charge.

No liability can be accepted for the information provided in this leaflet although it is published in good faith and believed to be correct. tremco illbruck Ltd. reserves the right to alter product specifications without prior notice, in line with Company policy of continuous development and improvement.



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