

TECHNICAL DATA SHEET

DEKAPUR 2K-6000

POWER CONSTRUCTION ADHESIVE

PRODUCT

Dekapur 2K-6000 is a thixotropic, solventfree, 2-component, polyurethane construction adhesive.

APPLICATIONS

- Different kinds of wood (plywood, fibreboard).
- Sandwich panels.
- Non porous synthetics and metals (e.g.polyester, polystyrene foam, aluminium, etc.).
- Stony materials (plaster).

FEATURES

- Solventfree.
- Good temperature resistance from -30°C till +90°C.
- Short pressing time of 5 hours.
- 2 Component, so controlled curing.
- Easy and fast application.
- High gap filling properties.

TECHNICAL DATA

Product:	: Dekapur 2K-6000 A-component
Basic material	: polyol
Consistency	: liquid
Specific gravity	: ca. 1.80 kg/liter
Viscosity (20°C)	: thixotropic
Colour	: beige
Packaging	: 14 kg & 5 kg

Product:	: Dekapur 2K-6000 B-component
Basic material	: MDI
Consistency	: liquid
Specific gravity	: ca. 1.20 kg/liter
Viscosity (20°C)	: ca. 150 mPa.s
Colour	: dark brown
Packaging	: 2,3 kg & 0,85 kg

Product:	: Dekapur 2K-6000 A + B-component cured
Basic material	: polyurethane
Consistency	: liquid
Specific gravity	: ca. 1.68 kg/liter
Viscosity (20°C)	: thixotropic
Colour	: beige
Tensile strength (ASTM C 297)	: >12 MPa
Shear strength (ASTM D 1002)	: >5 MPa
Temperature resistance	: -30°C till +90°C

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ADHESION

In general **Dekapur 2K-6000** adheres well without primer on polyester, polystyrene foam, polyurethane foam, plaster and plywood. On metal sheets an excellent adhesion is achieved by sanding and degreasing with acetone. For lacquered and coated surfaces we recommend to remove the layers by sanding and degreasing with acetone. For more detailed information, please contact Dekalin.

METHOD OF USE

Application conditions:	Application temperature between +15°C and +25°C and a relative humidity between 40% and 60%.
Substrate:	The substrate should be dry, clean and free of dust and grease. Smooth non porous materials, such as metals, should be roughened and degreased.
Application method:	Spatula.
Mixing ratio A:B in weight:	100:16
Mixing ratio A:B in volume:	100:24
Mixing:	Mix both components with a Collomix WK 70S spindel and using a drilling machine with a minimal power of 400 Watt and 600 rpm. Mix in the right mixing ratio, until both components are mixed homogenously.
Pot life 20°C/55%R.H.:	Ca. 50 minutes. The pot life depends on the amount of product, the temperature and the relative humidity. The indicated pot life is measured with 100 gram mixed product at a temperature of +20°C and a relative humidity of 55%.
Application:	The mixture has to be applied immediately. Apply Dekapur 2K-6000 on one side (one strong porous surfaces at two sides).
Open time 20°C/55% R.H.:	Ca.100 minutes. The open time depends on the temperature and the relative humidity. The open time measured after mixing at a consumption of 500 g/m ² , a temperature of +20°C and a relative humidity of 55%.
Assembling:	After applying the adhesive, assemble the parts (within the open time) and immediately clamp or press (0,1 -1 kg/cm ³).
Pressing time:	Ca. 5 hours at +20°C. The pressing time depends on the temperature and the relative humidity. The pressing time is measured at a consumption of 500 g/m ² , a temperature of +20°C and a relative humidity of 55%.
Curing time:	Complete curing will take about 24 hours at a temperature of +20°C and a relative humidity of 55%. Depending on higher or lower temperatures the curing time will be shorter or longer.
Consumption:	Ca. 500 g/m ² (depends on the type of substrate and on the expected differences in thermal expansion).
Cleaning:	Uncured Dekapur 2K-6000 can be removed with e.g. acetone.

STORAGE STABILITY

Dekapur 2K-6000 can be stored for 12 months in an original, unopened container in a dry place at temperatures between +15°C and +25°C.

SAFETY PRECAUTIONS

Consult our latest safety data sheet for more details.

TRANSPORT CLASSIFICATION

Consult our latest safety data sheet for more details.

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