Rudol

technical information

Product name	:	**HAFTVERMITTLER P 437 I + VERNETZER V 438 II** (ADHESION PROMOTER P 437 I + V 438 II)
Type	:	Two-pack PU system for bonding steel, GRP, aluminium, polyamide, concrete and ceramic tiles with PU coatings such as *BAYTEC REACTIVE. It can also be used to bond new PU coatings to old.
Viscosity	:	P 437 I = 9,500 +/- 2,500 mPa.s at 20°C V 438 II = 120 +/- 50 mPa.s at 20°C
Solids	:	100% by weight. The supply form contains no solvents.
Colour	:	P 437 I = grey V 438 II = brown Mixture = Olive-green.
Consumption	:	60 to 100 g/m² on an impermeable substrate.
Application	:	The system is suitable for application by brushing or rolling. It can also be sprayed after addition of up to 15% solvent (LÖSEMITTEL E, ethyl acetate, methyl ethyl ketone) to the ADHESION PROMOTER MIXTURE. A spray gun with a 1.5 mm nozzle is suitable for this purpose. After addition of the solvent, the adhesion promoter should be sprayed generously onto the substrate to avoid separation of the components in the mixture. **Important:** The solvents used must be **waterfree!**
Properties	:	The system adheres very well on all substrates. It has high resistance to hydrolysis and excellent resistance to the salt spray test, water immersion and hot air. It also stands up very well to mechanical stress, e.g. in roller.
Formulation	:	Before use, 2,500 g ADHESION PROMOTER P 437 I is mixed well with 1000 g CROSSLINKING AGENT V 438 II until a uniform colour is achieved. If the system is to be sprayed, LÖSEMITTEL E, or one of the other solvents listed, have to be added.
Pot life	:	The pot life of the mixture is around 15 minutes. If the mixture contains a sol vent, the pot life is about 30 minutes.
Procedure	:	First clean the steel and then blast it down to the bare metal (Sa 2 1/2). The material used for blasting should not be too coarse. Degrease the steel in a vapour bath with dichloromethane or 1,1,1-trichloroethane. Apply the mixture in crosswise passes to produce a coat which is thin but sufficient to cover the substrate. The substrate temperature should be at least 6°C over the dewpoint temperature. Otherwise a condens water film will prevent the bonding. The lowest application temperature of the substrate is 8°C, the highest is 80°C. Depending on the climatic conditions, the *BAYTEC REACTIVE should be applied 60 to 180 minutes after application of the adhesion promoter which should be nearly tack.

Special : ADHESION PROMOTER P 437 I should always be stirred advice thoroughly before use.

If the atmospheric humidity and/or temperature is high, the free curing time may be reduced to 30 minutes. Increased temperature also reduces the pot life significantly.

If the adhesion promoter film wasn't overlayed within 8 hours then it has to be freshened up by applying another coat. In this case it is essential to add 20% solvent to the second mixture. Our experience shows that such operation should it be done more then once. It has to be done within 24 hours from the first application.

CROSSLINKING AGENT V 438 II contains isocyanate. Please observe the information in our Safety Data Sheets.

Safety : When working with this product, safety goggles, protective gloves and overalls fastened at the neck and wrist should always be worn.

If the product is applied by spraying, a face mask (preferably with fresh air supply) should be worn.

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