

Stobicoll® B 323.00



General product information

Solvent free, flexible two component polyurethane adhesive. **Stobicoll® B 323.00** is designed for the production of sandwich elements with different materials in construction and building industry.

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Typical properties at 20°C

	Polyol	Polyisocyanate	Mixture
Density [g/cm ³] DIN 53217	1,60	1,22	1,52
Viscosity [mPa·s] DIN 53018/1+2	33000	250	6000
Mixing ratio by weight by volume	100 100	20 26	

Pot life 2 to 55 minutes at 20°C

Colour colourless

Curing profile

The curing time depends on the pot life of the system, the material- and surface temperature.

Typical mechanical properties

Shore hardness	60 D	DIN EN ISO 868
Tensile lap shear (Alu/Alu)	ca. 13 N/mm ²	EN1465
Application temperature range	-40 till 80°C	-

Processing Conditions

The resin component should be stirred well before using.

Immediately prior to use, both components are mixed together until homogeneous. Never mix together more adhesive than can be used in the given pot life. After mixing the adhesive is ready for use. The adhesive should not be used at temperatures below 10°C. 15 - 25°C is the most useful processing temperature.

The cure time is dependent on the material- and the ambient temperature. Higher temperatures will shorten the cure time, lower temperatures will lead to longer cure times. Curing will be fully complete after 7 days.

Application of the adhesive by hand is best done using a spatula or hand roller coater. Suitable mechanised application equipment used in combination with two-component mixing equipment. The adhesive is applied to only one surface. The coating weight is depending on the materials to be bonded. Generally the amount will be in the range of 250 - 350 g/m². The layer of adhesive should be thick enough to assure a complete wetting of the other surface by the adhesive.

The combined materials should be kept under pressure until the adhesive has cross linked sufficiently to maintain the bond during further handling. The recommended pressure is in the range of 3-7 N/cm² and could be achieved by using a hydraulic press or weights. When bonding materials with significantly different coefficients of thermal expansion, press temperatures should not be higher than 60°C.

The surfaces to be glued should be clean, dry and free from dust. Oil, fat and residual release agents should be removed with cleaning solvents like esters or ketones.

If new materials should be bonded a previous gluing test should be done. Processing and adhesion should be tested.

Precaution

Material safety data sheet should be read very carefully before use.

Packaging

312.5 kg drums. Other sizes on request.

Storage life

Both components must be protected against humidity. Do not store at temperature below + 5 °C. 15 - 25 °C is the most favourable storage temperature. Original closed drums can be stored for at least 6 months at ambient temperature. After a long storage period, the resin component should be stirred well before using.

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