

KEOL

POLYURETHANE ADHESIVE

K-PURE 478



478 adhesive from the K-PURE range is a colorless, UV-resistant, two-component polyurethane elastomeric adhesive. **478 adhesive from the K-PURE range** has been formulated for the molding of very clear and slightly colored components with a thickness of 5 to 20mm. Additionally, the long pot life of the mixed system allows it to be fully degassed and pourable, producing a virtually bubble-free cast.

- COLORLESS
- UV RESISTANT
- LONG POT LIFE

| | |
|----------------|--------------|
| CHEMICAL BASIS | Polyurethane |
| REACTION TIME | 15min |
| COLOR | Colorless |
| HARDNESS | 80A |
| VISCOSITY | Liquid |

| PROPERTIES | COMPONENT A | COMPONENT B | MIX |
|--------------------------------------|-------------|-------------|--------------|
| Chemical basis | Polyol | HDI | Polyurethane |
| Ratio of mixture to volume | 1.03 | 1.00 | |
| Ratio of mixture to weight | 1.00 | 1.00 | |
| Color | Colorless | Colorless | Colorless |
| Appearance | Liquid | Liquid | Liquid |
| Viscosity (mPa•s)@25°C | 300 | 3,000 | 1,650 |
| Relative density | 1.04 | 1.07 | 1.05 |
| Application temperature (°C) | | | +10 / +30 |
| Reaction time (100g @20°C) | | | 15min |
| Sticking time (100g @20°C) | | | 60mins |
| Full reaction time (100g @20°C) | | | 120mins |
| Exothermic reaction temperature (°C) | | | 30 |
| Hardness (Shore) | | | 80A |
| Elongation (%) | | | 70% |
| Service temperature (°C) | | | -40 / +90 |
| Storage time (months) | | | 12 months |
| Storage temperature (°C) | | | +20 / +30 |

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KEOL**POLYURETHANE ADHESIVE****PREPARATION AND MIX RATIO**

Components should be measured with an accuracy of 2% or better. Care should be taken when measuring by volume as it is an inherently inaccurate method unless specific volumetric measuring equipment is used.

None of the components require preparation before use.

Components can be mixed and poured at room temperature and require no preheating before use.

The components should be mixed thoroughly by hand using a flat blade such as a palette knife. Mixing should be done carefully to avoid inclusion of air and also to ensure that the material from the sides and bottom of the container is removed and mixed.

To avoid staining of unmixed components in the finished product, the mixed material can then be transferred to a second container and mixed again.

DEGASSING

If degassing is necessary, it must be carried out immediately after mixing. It is important to remember that this outgassing is only possible if the material has a long enough pot life or gel time to allow for mixing, outgassing and pouring.

The degassing chamber must be large enough to accommodate the mixing container and ideally empty it, the pump must be able to create a sufficient vacuum in the chamber to start degassing within one minute. Once violent bubbling ceases degassing is complete for most applications. However, for completely bubble-free pours, it is recommended to remix the product and repeat the degassing to remove as much air as possible.

Please note that increasing the amount of mix or working at higher ambient temperatures (e.g. summer) may reduce the pot life of the material. Wherever possible, tests should be carried out to establish these parameters.

**AFTERCURE**

This material will cure satisfactorily at room temperature. While the material can be demolded after approximately 3 hours, full strength and hardness will develop after 24 hours.

Post-cure the material for 8-12 hours at 40-50°C. This will improve the physical properties to some extent and reduce the full cure time.

**NOTE**

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