

Technical Data Sheet

PROPELLING EXCELLENCE
PROXL[®]

generation[™]

20

HIGH BUILD SEAM SEALER

A high build 2k for use in vertical or horizontal seams to match OEM sealers applied in rectangular shaped bead. The product is non-sagging and no-flowing, used to re-create the sprayed and brushed effect.

Product Code - PROSEAL-HB; PROSEAL-HB200

CHEMICAL BASE

PU

REACTION TIME

15 MIN

COLOUR

Grey

HARDNESS

40 D

VISCOSITY

THIXOTROPIC



proxl.com

Visit our website
for more products

Technical Data

PROPERTIES	COMPONENT A	COMPONENT B	MIXED
Chemical base	Polyol	MDI	Polyurethane
Mixing ratio by volume	1,00	1,00	
Mixing ratio by weight	0,86	1,00	
Colour	Beige	Straw	Beige
Appearance	Liquid	Liquid	Thixotropic
Viscosity (mPa*s)	6.000	3.000	50.000
Relative density	1,00	1,16	1,08
Application temperature (°C)			+10 / +30
Working time			15 min
Bonding time			60 min
Fully cured time			720 min
Temperature of exothermic reaction (°C)			30
Hardness (Shore)			40 D
Elongation (%)			90%
Service Temperature (°C)			-40 / +90
Shelf life (month)			12
Storage temperature (°C)			+20 / +30

Surface Preparation

The strength and durability of bonded joints depend on proper pre-treatment of the surfaces to be bonded

- Joint surfaces should be cleaned with a good degreasing agent to remove all traces of dust, dirt, oil and grease.
- Pre-treatment of thermoplastics materials such as PVC, polycarbonate, polypropylene, PMMA, etc., can be made using a mixture of light ethers or with isopropanol. Use of strong solvents is not recommended due to the risk of damage to the plastic surface.
- Where possible, carry out a mechanical abrasion to remove paint from the surfaces (where necessary) and to increase strength and resistance of the adhesion. Let dry the pre-treated area before applying the adhesive.
- Pre-treatment of other surfaces can be made using acetone or trichloroethylene
- Petrol or other solvents should never be used.

Application Guide

HIGH BUILD SEAM SEALER GREY is available in bi-component cartridge (side by side)

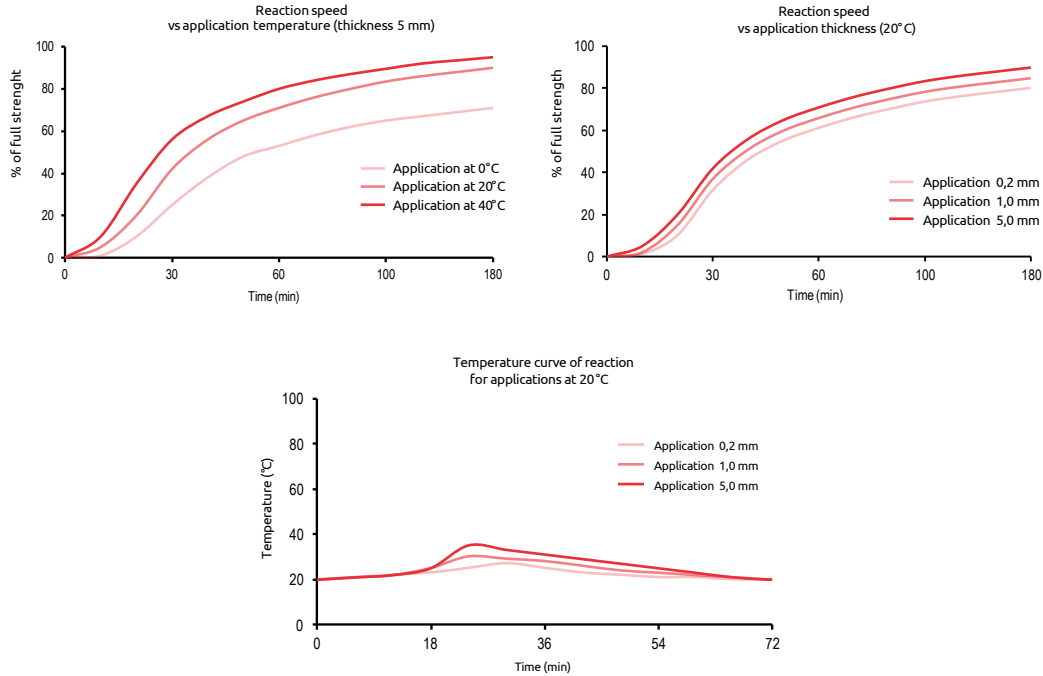
Blending should be made through static mixer composed by a minimum of 21 elements. A lower number of components doesn't allow a complete mixing. A higher number of components would increase speed of the chemical reaction of hardening. Static mixer nozzles are designed for 1 use only.

Bi-components cartridges can be used through manual applicators or specific pneumatic tools, depending on capacity and cartridge shape.

The mixture must be applied directly from the mixer on the pre-treated dry surface. The optimal layer of adhesive that will guarantee the highest resistance for the joint should be at least 0.5 mm thick. The 2 surfaces have to be assembled before the adhesive starts curing and sealed with a steady pressure all over the glued area.

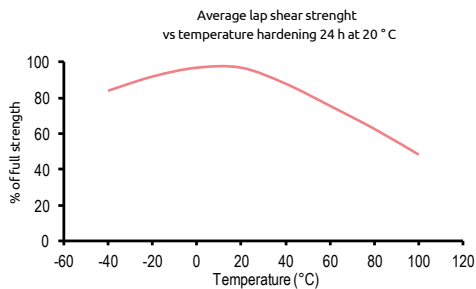
Reaction Mechanism

The speed of the hardening reaction is influenced by two factors, the application temperature and the application thickness. As the reaction is exothermic, the speed decreases as the thickness and temperature application increase. The substrate influences the speed of reaction. Materials with a high coefficient of thermal conductivity will tend to slow down the reaction. The maximal temperature of the reaction will be reached in 5 mm application thickness and is always lower than 30°C.



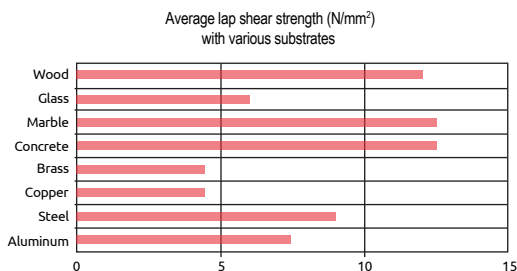
Technical Characteristics of Cured Products

The below properties have been measured through standard samples tests, made bonding by overlapping samples of different materials of dimensions 100 × 20 × 20 mm with an adhesion area of 20 × 20 mm. The values, obtained with standard methods on typical lots, are exclusively provided as technical information, and not as product specification. It is up to the user to test the product for a specific situation and then give his final approval.



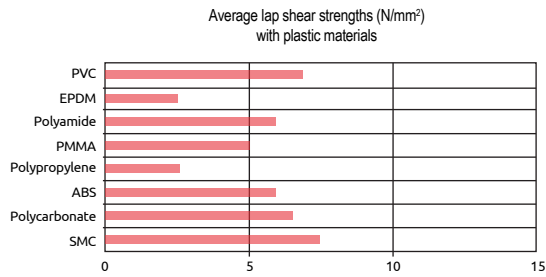
PHYSICAL PROPERTIES AT 20 °C

Tensile strength (N/mm ²)	20
Resistivity (Ω · cm)	1,8x10 ¹⁴
Dielectric constant	3,1
Dielectric strength (kV/mm)	22
Thermal conductivity (W/m·K)	0,20



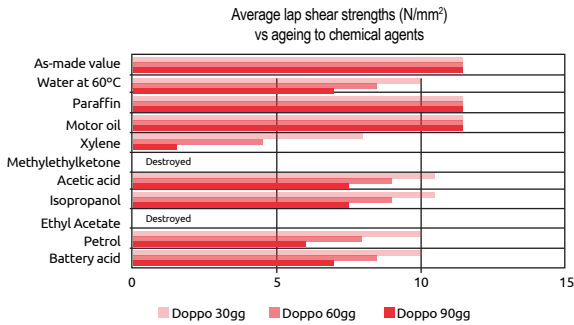
The tests have been conducted at 20°C on metal to metal joints, which have been hardened for 48 hours at 20°C.

Pre-treatment has been made by sanding and degreasing with acetone.

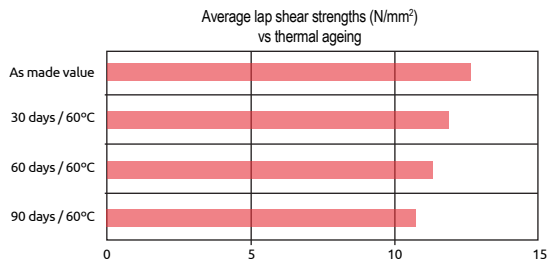


The tests have been conducted at 20°C on plastic to plastic joints, which have been hardened for 48 hours at 20°C.

Pre-treatment has been made by abrading and degreasing with isopropanol.



If not otherwise specified, the tests have been carried out at 20 °C after immersion for 30, 60 and 90 days at 20 °C on steel to steel joints which have been hardened for 48 hours at 20 °C.



The tests have been carried out at 20 °C on steel to steel joints, which have been aged at 60 °C.

At the end of the 3 thermo cycles of 24 hours each ranging from -40 °C to 100 °C, there has been no variation in the average lap shear strength.

Pre-treatment has been made by sanding and degreasing with acetone.

PRODUCT STORAGE

SELF LEVELING SEAM SEALER has a shelf life of 12 months from the initial production as long as it is stored in a cool and dry place, between +20 °C and +30 °C. Expiry date is indicated on the label.

PRODUCT HANDLING CAUTIONS

ProXL products are harmless to handle provided that certain precautions are taken when handling chemicals. The uncured materials must not be allowed to come into contact with foodstuffs or food utensils, and measures should be taken to prevent the uncured materials from coming in contact with the skin, since people with particularly sensitive skin may be affected. The wearing of impervious rubber or plastic gloves will normally be necessary; likewise the use of eye protection. The skin should be thoroughly cleaned at the end of each working period by washing with soap and warm water. The use of solvents has to be avoided. Disposable paper should be used to dry the skin. Adequate ventilation of the working area is recommended. These precautions are described in greater detail in the safety data sheet for the individual products and should be referred to for further information.

DISCLAIMER OF LIABILITY

The information and, in particular, the recommendations relating to the application and end-use of ProXL products, are given in good faith based on ProXL current knowledge and experience of the products when properly stored, handled and applied under normal conditions. ProXL cannot assume responsibility for the results obtained by others over whose methods we have no control. It is the user's responsibility to determine suitability for the user's purpose of any production method mentioned herein and to adopt such precautions as may be advisable for the protection of property and of persons against any hazards that may be involved in the handling and use thereof. ProXL specifically disclaims all warranties expressed or implied, including warranties of merchantability or fitness for a particular purpose, arising from sale or use of ProXL products. ProXL specifically disclaims any liability for consequential or incidental damages of any kind, including lost profits. Users should always refer to the most recent issue of the technical data sheet for the product concerned, copies of which will be supplied on request.