



The Glue People

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TradePUR RC30M

Roller coating polyurethane.

General Description

TradePUR RC30M is a single component, moisture curing polyurethane adhesive developed to meet exacting industrial standards in a new climate of environmental awareness. This product has been formulated to enable users to comply with up to date health and safety and environment protection legislation. The adhesive has been produced to give exceptional levels of adhesion to a wide variety of substrates, coupled with the advantages associated with roller coating polyurethane adhesives has offered the panel industry a new exciting solution to environmental problems.

This formulation is suitable for bonding many substrates such as steel, aluminium, polyurethane foams, wood, mineral wood, polystyrene foams, GRP, uPVC and many plastic materials. TradePUR RC30M has found a wide scope of applications from the manufacturing of portable buildings to architectural cladding and insulated door panels.

Due to the careful selection of chemicals used in the production of this adhesive; the cure rate characteristics can be accurately controlled. To achieve this control the adhesive should be applied together with a precise amount of water mist. TGP's coupling of chemistry together with application engineering ensures a total adhesive package with guaranteed results.

TradePUR RC30M is also used in quality processes associated with textile bonding, automotive seats and office furniture.

Application

Preparation

Surfaces must be clean, dry and free from any contaminants liable to impair adhesion. Metal surfaces such as galvanised steel and untreated aluminium require the use of a primer in order to obtain a satisfactory bond.

Method of application

It is suitable for application by conventional equipment; either by hand or automatic systems. The adhesive is applied to one surface only. TradePUR RC30M may be applied directly to polystyrene foam without causing cell attack.

Bonding / Pressure range

The table below is a guide to cure times and assumes 100% relative humidity as obtained by spraying 7-10% water mist in to the adhesive.

Temperature (°C)	Open Time	Press Time	Total Cure Time
10	60	120	180
12	54	108	162
14	46	93	139
16	39	79	118
18	35	70	105
20	30	60	90
22	24	49	73
24	21	44	65
26	18	38	56
28	16	35	51
30	15	30	45

Special comments

Since TradePUR RC30M cures upon exposure to humid air, special consideration should be given to handling and storage of the material.

Physical Data

Base	Polyurethane
Colour	Green
Viscosity @ 20°C	4000 - 6500 cps
Specific gravity @ 20°C	1.10 – 1.16
Non volatile content	97 – 100%
Flammability	No flash point
Coverage	Up to 20m ² per litre depending on the substrates being bonded.
Chemical resistance	Resistant to water, aliphatic oils, dilute acids and alkalis.
Service temperature	-40°C to +130°C
Application temperature	Minimum +10°C / Maximum +25°C
Storage life @ 25°C	3 months in unopened containers. Store between 5°C and 25°C. Lower temperatures can cause permanent damage to the solution.
Cleaning solvent	Tradesolve 9.
Dilution solvent	TradePUR RC30M is supplied ready to use. No dilution required.

Important Notice

Data contained in this document is for information only and is believed to be reliable. Trade Grade Products Ltd (TGP) cannot assume responsibility for results obtained by others over whose methods we have no control. It is the user's responsibility to determine suitability of the product for any specific purpose and TGP is pleased to provide a sample upon request.

Before using this product ensure that you have been supplied with and have read carefully the following information.

- The hazard label (complying with latest CDG/CPL regulations) applied to the container.
- Material Safety Data Sheet, TradePUR RC30M.