Technical Data Sheet

Properties:

AKEMI® AKEPUR 150 is a creamy paste-like, solvent-free two-component adhesive based on PUR.

The product is distinguished by the following properties:

- creamy paste-like consistency for a fast and at the same time clean processing of large parts, perfect for levelling uneven surfaces when bonding
- elastic adhesive gap compensates for different thermal expansions of parts being bonded
- fast processing time (15 min), which is especially important for a fast further treatment of bonded parts
- already transportable within 1.5 h
- grindable after approx. 6 h
- good resistance to solvents
- very low shrinkage
- can be painted over
- strong bonding power on metals, ABS, PVC, GRP, ceramics, natural and artificial stone
- good adhesion on surfaces reinforced on the back with epoxy resin and glass fibers to glazed ceramics
- non-resistant towards yellowing by light and heat
- suitable for vertical and horizontal applications

Application Area:

AKEMI® AKEPUR 150 is mainly used for the production of sandwich constructions. In this process, large area stone slabs (natural stone, quartz, ceramics, Solid Surface) are bonded with various other materials (metals, PUR- und PS-foams, GRP, PVC). Concrete application is for example the bonding of stone or ceramics with aluminum honeycomb panels. AKEPUR 150 is also used for bonding stone and ceramic veneers to substrates. In addition, AKEPUR 150 is also very suitable for bonding wood as well as laminate (DPL/HPL) on various surfaces.

Instructions for Use:

1. The surface has to be clean, free of dust, completely dry and roughened.
2. Before application, component A has to be stirred in order to homogenize it. Component B can be used as such without stirring. The vessels of both components should be closed after each withdrawal.
3. Mixing ratio A/B per weight: 4:1.
4. Mix both components until all streaks have disappeared.
5. The mixture can be processed for approx. 15 min (20°C). After mixing the required amount, immediately spread the adhesive with a toothed spatula or roller on the surface of the part to be bonded, otherwise the maximum processing time will be shorter.
6. After 1.5 h (20°C) the bonded parts are can be moved, they can be ground after 6 h (20°). After 12 h, the adhesive gap shows functional strength.
7. Remove excess of AKEPUR 150 as long as it is liquid.
8. The hardening process is accelerated by heat and delayed by cold. In summer we recommend cooling the product before processing in order to extend the open time.
9. Tools can be cleaned with AKEMI® Nitro-Dilution.

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Special Notes:

- For professional use only.
- The optimal mechanical and chemical properties can only be attained by adhering to the exact mixing proportions and complete mixing; surplus of component A or B has the effect of a plasticizer and may slowly result in discoloration of the contact area.
- An adhesive which is already thickened or just gelling should not be used anymore.
- Do not use the product at temperatures below 10°C, because it will not sufficiently harden.
- The hardened adhesive tends to yellowing, if it is permanently exposed to light and temperatures.
- The hardened product can no longer be removed by solvents. Removal is only possible mechanically or by higher temperatures (> 200°C).
- On metal surfaces, the AKEMI® Primer AP 30 shows very good adhesion, comparable to previous roughening.
- Recycling in accordance with the guidelines of EU Decision 97/129 EC on the Packaging Directive 94/62/EC.

Technical Data:

Colour:	light beige
Density comp. A+B:	approx. 1.46 g/cm³

Pot life at various temperatures (100 g batch):

10°C: 18 - 23 min.
20°C: 15 - 20 min
30°C: 7 - 12 min

Pot life with various batch sizes (20°C):

100 g: 14 - 19 min
500 g: 11 - 16 min
1000 g: 10 - 15 min

Tensile strength (DIN EN ISO 527):	7 - 9 N/mm²
Elongation at break (DIN EN ISO 527):	120 - 140%

Storage:

If stored in dry and cool conditions (5-25°C/41-77°F) in its closed original container at least 12 months from production.

Health & Safety:

Read Safety Data sheet before handling or using this product.

Important Notice:

The above information is based on the latest stage of development and application technology. Due to a multiplicity of different influencing factors, this information – as well as other oral or written technical advises – must be considered as non-binding hints. The user is obliged in each particular case to conduct performance tests, including but not limited to trails of the product, in an inconspicuous area of fabrication of a sample piece.

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