



# PA380

## Heavy Duty PUR Marine Adhesive D4

A one component high viscosity polyurethane based adhesive specially designed to provide marine grade quality for current industry needs. It can be also used in furniture industry DIY projects where you need premium quality. Unlike common polyurethane adhesives, it does not foam up uncontrollably.

### FEATURES & BENEFITS

- **Water-resistant and weatherproof: Withstand temperature and seasonal changes and suitable for both interior and exterior applications.**
- **Retards fire.**
- **Low-foam.**
- **High adhesion strength. Suitable for wood based materials, metals, natural stones, ceramic, rubber etc.**
- **Can be sanded and painted after curing.**
- High viscosity: Easier to use on vertical surfaces compared to standart liquid adhesives.
- Long open time: gives sufficient working time.

### APPLICATIONS

- **Fixing and gluing wooden elements to other various porous and non-porous elements as wood, metal, concrete, polystyrene foam etc.**
- **Furniture and boat production.**
- **All bonding applications that need a high water resistance and fire retardant properties.**

### INSTRUCTIONS

- The elements to be bonded must be properly clean and free from dust and grease.
- One of the substrates must be porous to ensure better curing.
- Apply the adhesive with a brush as thin film to one or both surfaces and join the parts within 20 minutes.
- Press the elements together -if needed- at least for 2-3 hours. Uncured adhesive can be cleaned by acetone.

Both Water  
Resistant and  
Fire  
Retardant



## STANDARDS

Meets or exceeds the requirements of the following specifications:

- Wheelmark Certified
- Reaction to fire class E according to EN 13501-1

## RESTRICTIONS;

- The shelf life is limited once the bottle is opened.
- The bottles must be kept tightly closed after use.
- Storage above +35 °C and below -10 °C may shorten the shelf-life.
- Pressing time depends on ambience conditions (temperature, humidity etc.) and porosity of the surfaces to be bonded.

## STORAGE AND SHELF LIFE;

12 months if stored in its original package, away from direct sunlight and moisture, between +10 °C and +25 °C .

## PROPERTIES

<b>Basis</b>	: <b>Polyurethane Prepolymer</b>	
<b>Color</b>	: Beige-Yellowish	
<b>Curing system</b>	: Moisture curing	
<b>Density</b>	: 1,10 g/ml ± 0,01	(ASTM D1875)
<b>Viscosity</b>	: 20 °C 10000-15000 cp cps at 20°C	
<b>Tack-Free time</b>	: Approx 1 h (23 °C and 50% R.H.)	(ASTM C679)
<b>Maximum Shear Strength</b>	: After 15 min: > 50 kgf/cm <sup>2</sup>	
<b>After 24 hours:</b>	<b>&gt; 70 kgf/cm<sup>2</sup></b>	
<b>Consumption</b>	: Approx. 150 ml/m <sup>2</sup>	
<b>Compression time</b>	: Min. 2 hours*	
<b>Water resistant class</b>	: D4	(DIN EN 204)
<b>Fire classification</b>	: E	(EN 13501-1)
<b>Temperature resistance</b>	:-30 °C to +100 °C	
<b>Application Temperature</b>	: +5 oC to +35 oC	



## PRODUCT

Product Type	Weight	Package
PA380	800 gr.	12

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