



OBO-bond Adhesive brown

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Applications

Bonding of obomodulan® 302 pink, 400 orange, 502 orange, 500 magma, 630 mokka, 652 mokka, 700 terra

Properties

- good filling properties
- no sagging at vertical surfaces

OBO-bond brown is an easy-to-use, two-component polyurethane-based adhesive that cures at room temperature.

Processing data

Product	Mixture OBO-bond brown	Resin Component A	Hardener Component B
Colour	brown	brown	brown
Mixing ratio in parts by weight		100	50
Viscosity at 25°C in mPas	thixotrope	pasty	120 ± 20
Density at 20°C in g / cm³	0,80 ± 0,03	0,68 ± 0,02	1,23 ± 0,02
Pot life 150 g / 20 °C in min.	15 – 20	-	-
Curing time at RT in hours	8 – 10	-	-

Physical data

Flexural strength (EN ISO 178) in MPa	40 ± 5
Flexural elongation at break (EN ISO 178) in %	5,2 ± 0,3
Flexural modulus (EN ISO 178) in MPa	1370 ± 100
Compressive strength (EN ISO 604) in MPa	36 ± 4
Heat resistance (HDT) (DIN EN ISO 75 B) in °C	80 ± 3
Shore hardness (DIN ISO 7619-1) Shore D	65 ± 3

Sales kit (packages)

article number	material	kg / unit
LZ VA000001	OBO-bond brown Comp. A	0,4 kg
LZ VB000001	OBO-bond 50 Comp. B	0,2 kg



Processing

Mix components A and B together carefully.

We recommend application with a spreading spatula or brush.
The consumption per m² is approx. 500 - 600 g.
The adhesive has a low reaction temperature.

The boards should be fixed after gluing with screw clamps.

Example to determine the pressing force per screw clamp:

Screw diameter:	36 mm
Screw clamp surface:	1018 mm ²
Tighten the screw clamp by hand:	300 kg (= 3000 N)
Pressure (= force / surface):	3000 N / 1018 mm ² = ca. 3 N / mm ² = ca. 3 MPa



Before mechanical processing, we recommend a curing time of 8 - 10 hours.

Storage

Store the adhesive in tempered rooms at approx. 18 - 25 °C. Already opened containers should be closed immediately after use and should be used as soon as possible.

Handling Precautions

Our products are generally quite easy to handle provided that certain precautions normally taken when handling chemicals are observed. The uncured materials must not, for instance, 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 cleansed at the end of each working period by washing with soap and warm water. The use of solvents is to be avoided. Disposable paper - not cloth towels - should be used to dry the skin.

Adequate ventilation of the working area is recommended.

Waste Disposal

According to arrangement with local authorities cured material can be disposed as domestic or commercial waste. Non-cured products are waste which is subject to inspection and has to be disposed accordingly.

All information about the material and the working and processing are made to the best of our knowledge and are not to be regarded as an assurance of the properties of the material. Our information does not relieve the customer of their own suitability test for applications and procedures.