



Concave Sealer

Description: A thixotropic adhesive made to fill voids between Concave liners allowing you to pour crusher backing within 10-minutes after application. The adhesive is non-sag on a vertical surface and able to bond to any metal surface.

Intended Use: Recommended for bonding ABS, PVC, CRS, and Manganese with minimal surface preparation. Bonds to aluminum and stainless steel when used in combination with Plexus PC120 surface conditioner. The removal of surface impurities and preparation on metals can influence overall bond strength.

Product features:
Room temperature cure
Functional in 10 minutes for sealing gaps between liners
Bonds to poorly prepared surfaces
Non-sagging formula

Limitations:

Typical Physical Properties: *Technical data should be considered representative or typical only and should not be used for specification purposes.*

Cured 7 days @ 75° F

Adhesive Tensile Lap Shear(ABS)	1,300psi
Adhesive Tensile Lap Shear(AL)	2,041 psi
Adhesive Tensile Lap Shear(SS)	2,439 psi
Adhesive Tensile Lap Shear[GBS]	3,500 psi
Cured Density	28.1 in[3]/lbs.
Gap Fill	0.5 in.
Impact Resistance	22 ft.lb./in[2]
Shore Hardness	78 Shore D
Solids by Volume	100
Tensile Elongation	15-25%
Tpeel	35-40 pli

TESTS CONDUCTED

Adhesive Tensile Shear ASTM D 1002
Impact Resistance ASTM D 950
Cured Hardness Shore D ASTM D 2240
T-Peel Strength ASTM D 1876

Uncured

Color	straw
Fixture Time	10-15 min. @ 72°F, 22°C
Flashpoint	51°F
Full Cure	24 hrs.
Functional Cure	45 minutes
Mix Ratio by Volume	1:1
Mix Ratio by Weight	100/117
Mixed Density	8.20 lbs./gal./ .98gms/cc
Mixed Viscosity	Thixotropic/non-sagging
Service Temperature	-67°F - 250°F
Viscosity	Adhesive: 55,000 cps; Activator: 50,000 cps
Weight	Adhesive: 8.4lbs./gal.; Activator: 8.00 lbs./gal.
Working Time	4-6min. @ 72°F,[22°C]

Surface Preparation: Clean surface by solvent-wiping any deposits of heavy grease, oil, dirt, or other contaminants. Surface can also be cleaned with industrial cleaning equipment such as vapor phase degreasers or hot aqueous baths. If working with metal, abrade or roughen the surface to significantly increase the microscopic bond area and optimize the bond strength.

Mixing Instructions: ---- Proper homogenous mixing of resin and hardener is essential for the curing and development of stated strengths. ----

- 25 ML DEV-TUBE
1. Squeeze material into a small container the size of an ashtray.
 2. Using mixing stick included on Dev-tube handle, vigorously mix components for one (1) minute.
 3. Immediately apply to substrate.

35ML/50 ML/250 ML/380 ML/400 ML CARTRIDGES

1. Attach cartridge to Mark V™ [50ml], 380ml, 250ml [15:1 caulk gun], or 400ml dispensing systems [manual or pneumatic].
2. Open tip.
3. Burp cartridge by squeezing out some material until both sides are uniform (ensures no air bubbles are present during mixing).
4. Attach mix nozzle to end of cartridge.
5. Apply to substrate.

Application Instructions:

1. Unscrew retaining nut top of cartridge. Remove nose plug.
2. Insert Concave Sealer™ cartridge into caulking gun. [Using a 26:1 ratio gun is preferable for maximum delivery quickly]
3. Dispense until both part A (tan) and part B (straw) flow freely
4. Screw mix nozzle on cartridge. "Break-Off Tip" snaps easily to increase flow of mixed adhesive and to get a thicker bead flow to substrate.
5. Dispense Concave Sealer™ adhesive through mix nozzle. Be certain mixed adhesive flows streak-free and white before applying to work surface.
6. If the cartridge is not used for 8 minutes (@ 72°F [22°C]).
- 7..Working times and cure times are affected by the temperature of the adhesive.
 - Adhesive temperatures below 72° F [22°C] extend the work time and above 72° F [22°C] shorten work time.

APPLICATIONS

Gap Filling between Liners: Concave Sealer™ adhesive is designed to fill gaps up to 1/2" wide. If gap is larger, apply a first coat to fill the void and wait 5-minutes then re-apply over filling the larger void. The second application will bond to the previously applied Concave Sealer

Call Technical Service for any other questions: 1-855-489-7262

Storage:

Store between 55°F and 75°F. Continuous storage above 75°F reduces the shelf life of the materials. Prolonged exposure above 100°F quickly diminishes the product's reactivity, and should be avoided. Shelf life can be extended by refrigeration between 45°F and 55°F. DO NOT FREEZE.

Compliances:

None

Chemical Resistance:

Chemical resistance is calculated with a 7 day, room temp. cure (30 days immersion) @ 75°F

Acetic (Dilute) 10%	Fair
Ammonia	Fair
Cutting Oil	Very good
Gasoline (Unleaded)	Very good
Glycols/Antifreeze	Excellent
Hydrochloric 10%	Fair
Motor Oil	Very good
Sodium Hydroxide 10%	Very good

Precautions:

Please refer to the appropriate safety data sheet (SDS) prior to using this product.

For technical assistance, please call 1-855-489-7262

FOR INDUSTRIAL USE ONLY

Warranty:

ITW Performance Polymers will replace any material found to be defective. Because the storage, handling and application of this material is beyond our control, we can accept no liability for the results obtained.

Disclaimer:

All information on this data sheet is based on laboratory testing and is not intended for design purposes. ITW Performance Polymers makes no representations or warranties of any kind concerning this data.

Order Information:

81091 250 ml cartridge