TECHNICAL DATASHEET

i.MIX 2K

i.GLUE SYSTEMS

Characteristics

- The 2-component hybrid-polymer-based (STPU) adhesive
- Ratio of mixture 10:1
- Fast curing even in thick layers
- For stress-compensating bonding and dynamic stresses
- High resistance to notches, tension and tearing
- Low odour
- Free of isocyanates
- Silicone-free
- Good weathering and ageing resistance
- Compatible with coatings according to DIN 52452

Fields of application

- For indoor and outdoor use
- For tension-equalizing bonding and assembly of a wide variety of material such as wood, wood-based materials, glass, metals (e.g. aluminum, stainless steel, anodized aluminum, brass, Copper), plastics (e.g. hard PVC, soft PVC, GRP etc.), mineral under green de (e.g. bricks, tiles, ceramics), fire-protected building boards (plasterboard, etc.)
- For body and vehicle construction, wagon and container construction, metal and apparatus construction, shipbuilding
- Sealing of air conditioning and ventilation systems
- Bonding stone, natural stone and ceramics
- Tension-compensating gluing of mirrors on ceramics, glass, plastic, precious steel, aluminum, wood, concrete etc.

Standards and tests

- For applications according to IVD information sheet no.12+30+35 suitable
- French VOC emission class A+
- Certified according to GOS

Technical properties

Single components:

Component A

Coulour	grey
Viscosity at 23 °C	pasty
Density at 23 °C according to ISO 1183-1 [g/cm³]	~ 1,31
Shelf life at 23 °C/50 % RAH for [months]	24

Component B

Coulour	white
Viscosity at 23 °C	pasty
Density at 23 °C according to ISO 1183-1 [g/cm³]	~ 1,28
Mixing ratio according to weight (base A : curing agent B)	91 : 9
Mixing ratio according to volume (base A : curing agent B)	10 : 1
Shelf life at 23 °C/50 % RAH for [months]	24

Unvulcanised compound:

Coulour	grey
Viscosity at 23 °C	pasty
Density at 23 °C according to ISO 1183-1 [g/cm³]	~ 1,30
Processing temperature from/to [°C]	+ 5 / + 40
Shore-A hardness after 4 h	~ 20 - 22
Shore-A hardness after 24 h	~ 45 - 48
Pot life at 23 °C/50 % RAH [minutes]	~ 25
Functional strength [min]	~ 60 - 120

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Vulcanizate:

Shore-A hardness according to ISO 868	~ 50 - 55
Temperature resistance from/to [°C]	- 40 / + 100
Tensile strength according to ISO 37, S3A [N/mm²]	~ 3,0
Elongation at break after ISO 37, S3A [%]	~ 200
Strain value at 100 % according to ISO 37, S3A [N/mm²]	~ 1,8

These data are not suitable for the issue of specifications.
Please contact i.GLUESYSTEMS prior to creating specifications.

Important information

Before applying this product the user has to ensure that the materials in the area of contact (solid, liquid and gaseous) are compatible with it and also amongst each other and do not damage or alter (e. g. discolour) each other. As for the materials that will be used at a later stage in the surrounding area of the product the user has to clarify beforehand that the substances of content or evaporations do not lead to an impairment or alteration (e. g. discolouration) of the product. In case of doubt the user should consult the respective manufacturer of the material. For UV-loaded bonds/seals of glass, we recommend the use of a high-quality silicone dhesive/sealant. For UV-loaded bonds/seals of transparent plastics such as acrylic glass we recommend the use of a high-quality silicone adhesive/sealant. Not suitable for sealing / bonding copper upon impact of UV-radiation and temperature.

Pretreatment

All adherent surfaces must be clean and any contaminant such as release agents, preserving agents, grease, oil, dust, water, old adhesives or sealants and other substances which could affect adhesion, should be removed. The adherent surfaces have to be clean, free from dust and grease as well as sustainable. The demands on elastic sealings and bondings depend on the respective exterior influences. Extreme fluctuations in temperature, tensile or shear forces, repeated contact with water etc. demand high requirements of a bonding.

In such cases it is advisable to apply primer in order to achieve a resilient bonding. Please consult our technical department.

Application information

Processing of 2-component adhesives and sealants out of side-by-side cartridges: First of all remove the lids of both component's chambers. Place cartridge into the pistol. Squeeze out material, until material comes out of both chambers. Wipe off material and attach the static mixing nozzle with help of the union nut. Check homogenity of the mixture. Component A is sensitive to atmospheric humidity and therefore must be protected from moisture. Component B does not react with atmospheric humidity and is stable under normal conditions (23 °C, 50 % RH). The longer it is kept in storage, the more likely the B component is to undergo a slight phase separation. In this case a small amount should be carefully extruded from the double cartridge until both components are homogeneous as they come out of the double cartridge. In the case of hobbocks the separation which occurs must be discarded. Thereafter the material can be processed without any problems. In order to achieve good adhesion and good mechanical properties air entrapment must be avoided. Processing/smoothing: The adhesive/sealant has to be smoothened within pot life in order to ensure close contact with joint edges/substrates. Smoothing Agent shall not be used. We recommend to store our products in unopened original packagings dry (<60 % RAH) at temperatures of +15 °C up to +25 °C. If the products are stored and / or transported at higher temperatures / air humidity for longer periods (some weeks), a diminuition of durability or a change of material characteristics may arise. Due to the many possible influences during and after application, the customer always has to carry out trials first.

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Delivery form

Container:	2k pouch 11 g
Colour:	grau
Packaging unit:	1,000 pieces
Article number:	Art.no. 1000-32

Safety precautions

Please observe the material safety data sheet.

Disposal

Information about disposal: Please refer to the material safety data sheet.

Warranty information

All information in this publication is based on our current technical knowledge and experiences.

However, since conditions and methods of use and application of our products are beyond our control, we suggest you to test the product before final use. Information given in this technical data sheet and explanations of i-GLUESYSTEMS in connection with this technical data sheet (e. g. service description, reference to DIN regulations etc.) is not to be seen as a warranty. Warranties require a separate written declaration of i-GLUESYSTEMS to prove their validity. The characteristics stated in this data sheet define the characteristics of the article broadly and concludingly.

Suggestions of use are not to be taken as confirmation of the appropriateness for the recommended intended use. We reserve the right to alter the product adjusting it according to technical progress and new developments. We are at your disposal both for inquiries as well as specific application problems. If a governmental approval or clearance is necessary for the application of our products, the user is responsable for the obtainment of such. Our recommendations do not excuse the user from the obligation to take into consideration the possibility of infringement of third paries' rights and - if necessary – resolving it.

For the rest our general terms and conditions apply, in particular regarding a possible liability for deffects.

You can find our general terms and conditions on our homepage:
https://www.i-gluesystems.com

i.GLUESYSTEMS GmbH
Ulmer Str. 53/1
D-73262 Reichenbach a.d.F.
T +49 7153 929 7885

info@i-gluesystems.com
www.i-gluesystems.com