

XP 2035A/B

General Description

XP 2035 is a two part polyurethane adhesive, specifically developed for manual application. It is part of the Solfre 2 range of polyurethane adhesives meeting the exacting industrial standards in a new climate of environmental awareness. Once mixed the adhesive has a strong thixotropic structure with excellent non-slumping characteristics and may be applied by scraper, spreader or notched trowel. The mixed XP 2035 cures to form a tough but flexible bond resistant to water, heat and solvents.

Applications

An excellent general purpose adhesive XP 2035 finds many varied and diverse applications, however due to its thixotropic and gap filling characteristics it is ideally suited for bonding vertical surfaces. XP 2035 is ideal for on site composite panel manufacture and repair and widely used for repairing caravan panels. The adhesive does not contain any solvents and hence will not attack the polystyrene foam core materials used within the caravan panels; it will however bond excellently to metals, timber, internal claddings as well as concrete and brickwork.

Technical Data

Chemical Base	Polyurethane
Viscosity	Part A : Viscous paste at 20°C Part B : 150 – 250 cps at 20°C Mixed : Thixotropic paste
Specific Gravity	Mixed 1.30 – 1.50
Solvents	None
Non-Volatile Content	100 %
Flammability	No Flash Point
Service Temperature	-40°C to +130°C
Colour	Part A : Light Grey Part B : Brown Mixed : Buff
Chemical Resistance	Resistant to water, dilute acids, alkalis and aliphatic oils.

Application Data

Packaging

Available in 1Kg, 1.2kg, 5kg and 7.6kg kits

Storage life

6 months in unopened containers

Application Temperature

Between 10°C and 25°C

Storage Temperature

Between 4°C and 25°C. Lower temperatures can cause permanent damage to the product.

Coverage

Between 2 and 4 m²/Kg depending on the porosity and uniformity of the substrates being bonded. This has been determined coating one substrates.

Substrate Preparation

All surfaces should be free of contamination by dust, grease, oils or release agents. Substrates should be checked for contamination by mould release or cutting agents. Metals should be degreased prior to bonding as a precaution. Cleaning solutions, if used, must be allowed to evaporate before application of the adhesive.

Application

XP 2035 is supplied as a preweighed kit; the mixing ratio is 5 parts of the XP 2035A component to 1 part of the XP 2035B component by weight. Because of the relatively short pot life all substrate preparation should be completed before mixing the adhesive. XP 2035 only needs to be applied to one surface but the bond should be consolidated within 60 minutes of mixing. The bond should be left under pressure ideally for 12 hours, however sufficient cure for most purposes should be attained after 4 – 6 hours at 20°C.

Bonding Range and Pressure

XP 2035 should be used within 1 hour of mixing. All panels or composites should be held together throughout the curing process. Ideally this should be in a press, however for many repairs a series of chocks and weights is a practical solution which proves successful.

Cleaning Solvent

CAS 703 or CAS 704 on uncured material.

Dilution Solvent

XP 2035 is supplied ready for use. Dilution is not recommended.

Additional Information

Higher temperatures will dramatically reduce the working time of the adhesive, as lower temperatures will dramatically extend the total cure time of the adhesive.

Health and Safety Information

Please consult the XP 2035 Material Health and Safety Data Sheet for statutory regulation information.