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Adhesive systems



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Technical Data – Penloc Solo

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PENLOC SOLO is a single part structural adhesive, with high initial grab and fast through cure. It produces highly resilient bonds between a wide range of substrates. The resultant bonds are resistant to water, sea water, oils and most common solvents and temperatures between - 40°C to +150°C as well as UV light and aggressive environments. Penloc Solo has been specifically formulated to build high initial bond strength on a variety of complex substrates including those associated with industrial prefabricated structures, portable utility buildings, dwellings, containers and vehicle bodies. It can be used for other industrial applications such as bonding and sealing of steel floor plates, rubbing strips, skylights, heavy profiles, lap seams etc. Penloc Solo has been designed to hold unsupported components against a vertical plane or soffit soon after application. Penloc Solo is non-hazardous, contains no free isocyanates, VOC's, acids or halogens. For most applications primerless adhesion can be obtained. Penloc Solo is tolerant to damp substrates. Penloc Solo does not shrink on curing.

During the early part of the curing process of the adhesive, it is possible to move, adjust or re-align the adhesive joint by up to 50%.

TECHNICAL DATA

Form:	Smooth viscous paste
Storage Life:	6 months in original containers stored below 25°C
Solids Content:	100%
Specific Gravity:	1.60
Shrinkage on cure:	nil
Colour:	Off White
Base:	Hybrid Polymer System
Hazardous Ingredients:	Non-hazardous
Flammability:	Non-flammable
Application Temperature:	+5°C to +35°C
Temperature Range:	- 40°C to +150°C

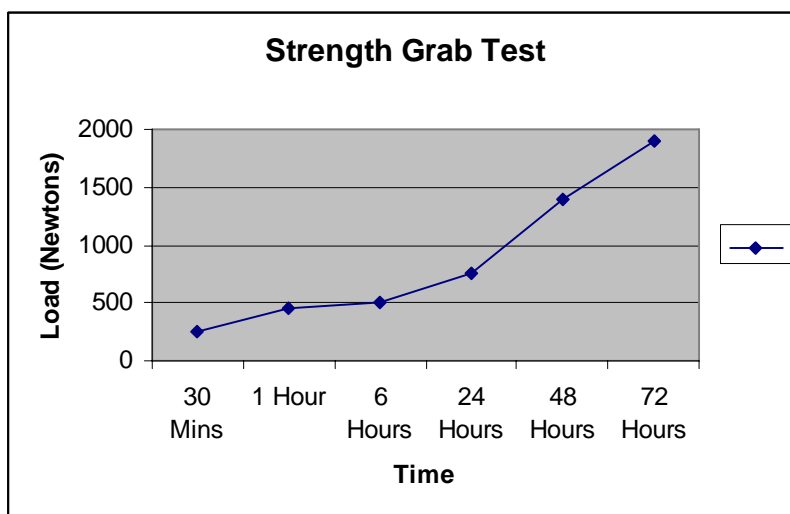
TECHNICAL DATA (Cont)

Skin Time:	30 mins at +23°C and 50% Rh
Cure Time:	3mm per 24 hours at +23°C and 50% Rh
Shore Hardness when cured:	40-45 shore A
Tensile strength	3.4 MPa / Nmm ²
Peel Test	Method ASTM C794
	Aluminium – 360 N.F
	Stainless Steel – 324 N.F
	Mild Steel – 356 N.F
	GRP – 346 N.F

SURFACE PREPARATION

Ensure that all surfaces are clean, sound and free from grease. Metal and plastic surfaces should be cleaned and degreased by wiping with a suitable solvent.

NOTE: **Penloc Solo** should not be applied to surfaces or in conditions that are below +5°C. At these temperatures, like most other moisture curing or aqueous adhesives the curing mechanism is suspended. To help improve/speed up cure time a very lightly damp cloth can be wiped over the metal substrate.



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