

Basis	Bonding agent
Resin	Bonding agent HV 55 Comp. A
Hardener	Haftvermittler HV 55 Comp. B
Colour	green

Applications

- Mould and tool making in concrete industry

Properties

- Good bonding on:
 - Steel
 - Stainless Steel
 - Aluminium
 - flexible PU casting resins
 - Wood

Processing data

Product		Mixture Bonding agent HV55/Comp. A+B	Resin Bonding agent HV 55 Comp. A	Hardener Haftvermittler HV 55 Comp. B
Colour		green	green	brown
Mixing ratio	p. b. w.		100	25
Viscosity at 25°C	mPas	pasty	pasty	100 ± 30
Density at 20°C	g / cm ³	1,65 ± 0,05	1,73 ± 0,05	1,24 ± 0,02
Pot life 200 g / 20°C	min.	25 - 35	-	-

Physical data

Properties	Inspect. requirem.	Unit	Value
Flexural strength	EN ISO 178	MPa	68 ± 5
Flexural elongation at break	EN ISO 178	%	1,20 ± 0,1
Flexural modulus	EN ISO 178	MPa	6700 ± 500
Impact resistance (Charpy)	EN ISO 179	kJ/m ²	5,5 ± 0,5
Compressive strength	EN ISO 604	MPa	85 ± 5
Shore hardness	DIN ISO 7619-1	Shore D	90 ± 3
Heat resistance (HDT)	DIN EN ISO 75 B	°C	80 ± 3

Sales units (packages)

Units	Comp. A	Bonding agent HV 55 Comp. A	0,960 kg
	Comp. B	Haftvermittler HV 55 Comp. B	0,240 kg

Processing instructions

The temperature of the material during working should be between 18 and 25°C. Re-close carefully the containers after use.
The mixing ratio of resin and hardener according to the data sheet must be observed
The surface must be roughened and be free of dust and fat. The HV 55 can be applied with a brush or with a roll.

Use as adhesive:

Apply the adhesive in a thin layer on formwork and matrix. The bonding can be made directly. We recommend to put weight on the matrix or to stretch it in order to get a better contact surface.

Use as bonding agent:

Apply a thin layer of bonding agent on the roughened, clean surface and let it gel for approx. 30-35 minutes, so that the surface is still sticky but not damp. Then cast the elastic PU resin.

Any resin residues on the stirrer can easily be removed with a cleaning agent.

In General

The Bonding agent HV 55 is an easy-to-use two-components polyurethane system. It is very good suitable as a bonding agent between back structure and elastic PU casting resins. Moreover it can be used as a matrix adhesive for the application of elastic PU structure matrix on a formwork.

Storing

At appropriate storage 18-25°C.

Occurring crystallization due to disadvantageous storage conditions can be made return by warming up the material at approx. 60° C.

Opened containers should be closed immediately after use and be protected against moisture. This material should be used up as soon as possible.

Shelf life: see labels

Safety measure

Please follow the precaution instructions of the Government Safety Organisation of the chemical industry when working with this material. Please follow safety advices !

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.

In case of further questions please do not hesitate to contact our Department for Product Safety.

The instructions and recommendations are given in good faith and are based on long experience and careful tests. Since the conditions of use are beyond our control, and due to versatility of applications and working methods, we can't give any guarantee. All information are non-binding and are no guarantee for special characteristics or properties of the product. Despite information given from **ebalta** the customer has to make his own tests regarding applications and processing. If any special warranty is requested, written agreement on this subject is essential.