

TECHNICAL DATASHEET

MULTIBOND

36-48252

Product:

Multibond Transparent is a high-quality, durable elastic MS-Polymer based glue and adhesive with a crystal clear transparency.

Applications :

Multibond Transparent bonds without primer on almost all materials occurring in the building industry, such as aluminium, galvanized and stainless steel, zinc, copper, natural stone, concrete, brick, cement based cover sheeting, volkern, wood, gypsum, glazing, various synthetic materials, etc. Extremely useful for gluing and sealing different coloured backgrounds. Suitable for use as a universal glue and adhesive for sealing seams, connecting and movable joints. Multibond transparent's bonding capacity improves markedly during the course of time. Examples of applications are:

- Sticking handles to glass doors
- Bonding and sealing show windows and display cabinets
- All gluing work where transparency is necessary
- Gluing work in veranda's, bathrooms, kitchens, etc.

Multibond Transparent should not be used with:

- Joints that are exposed to constant submersion under water
- Joints with a width or depth < 5 mm
- Swimming pools containing chlorine, with constant submersion under water
- Bitumen: use our Paraphalt for this purpose

Multibond Transparent is not suitable for gluing PE, PP, PA, Teflon[®] and bitumen. Proper ventilation during processing and during the hardening is important.

Properties:

- Sealing and gluing
- Crystal clear transparency
- Excellent bonding on most building materials
- Bonds even on moist backgrounds
- Solvent and isocyanide free
- Extremely strongly when completely dry
- Permanently elastic
- Does not cause any corrosion in metal joints
- Can be used inside and outside
- UV and weather-resistant
- Suitable for natural stone
- Neutral, odourless glue
- Mould resistant
- **After vulcanisation:**
- Multibond Transparent dries into a durable elastic and strong adhesive connection under the influence of humidity. The tensile stress at 100% elongation is 1,1 N/ mm² (ISO37), the maximum tensile stress is > 2,2 N/ mm² (ISO-37) (0,7 N/ mm² (ISO-8339), the shearing force amounts to 1,5-3N/mm² depending on the glue construction. Refer to the Technical characteristics for additional information concerning the strength qualities.
- Stretch with breakage ca. 230% (DIN 53504/ISO 37)

Joint dimensions:

Joint width	Joint depth:	Acceptable variance
6 mm	6 mm	± 1 mm
8 mm	6 mm	± 1 mm
10 mm	6-8 mm	± 2 mm
15 mm	10 mm	± 2 mm
20 mm	10-12 mm	± 2 mm
25 mm	15 mm	± 3 mm

Technical characteristics:

- Basic ingredient: MS-Polymer
- Drying system: By means of humidity
- Drying speed: 2,5 to 3 mm/24 hour at 23°C and 50% R.H.
- Number of components: 1
- Skin formation: 15 to 20 minutes at 23°C and 50% R.H.
- Density: ca. 1,06 g/ml (ISO 1183)

- Shore A : 35 (+/- 5) (ISO-868)
- Maximum allowed distortion: 25%
- Module at 100% stretch: 0,700 N/mm² (ISO-8339-40)
- Module with breaking: 0,800 N/mm² (ISO-8339-40)
- % stretch with breakage: 150% (ISO-8339-40)
- Shearing tension 2,1 N/ mm² (DIN 53283)
- Solvent quality: 0%
- Isocyanate quality: 0%
- Dry matter quality: ca. 100%
- Processing temperature of +5°C to +40°C, do not process below +5°C.
- Temperature stability -40°C to +90°C
- Moisture resistance: very good
- Frost stability: not sensitive to frost

Packaging & Colour:

25 cartridges of 290 ml per box: transparent

Storage and stability:

Keep cool and in the sealed packaging.

Shelf life of opened packaging is limited.

9 months in the sealed packaging at 23°C

- Paintable with most water and solvent based paints. Is paintable wet on wet. After 48 hours, the surface must be cleaned first before it can be painted. Pre-testing is necessary. Alkyd paints require an extended drying time.

Processing:

Support: The support must be fixed and rigid enough. The support does not have to be completely dry (damp).

Pre-treatment: The materials to be glued must be clean, dust and grease free. If necessary, degrease using Top Cleaner, MEK, alcohol, or ethanol. It is advisable to do bonding tests. It is the user's responsibility to check whether the product is suitable for his application. Our technical department could be consulted, if necessary.

Application: Apply Multibond Transparent with the supplied nozzle in strips or dots to the support or on the element to be bonded. The strips must be applied in vertical rows. For information regarding the mutual distances between the glue strips, refer to "adhesive quantities". DL-Chemicals advises a gap of 3,2 mm between the parts to be bonded, to allow the glue to smooth out any distortions (especially important in exterior use or under humid conditions). To achieve this space, spacer blocks or pieces of foam tape with a thickness of 3.2 mm may be used. If the adhesive layer does not have

to take up any, or only have to take up a slight mutual distortion between the construction parts, a thinner adhesive layer (at least 1.5 mm) will suffice (for example in interior applications).

Open time: Apply the part to be glued as quickly as possible, at the latest within 15 minutes (this depends on the temperature and relative humidity level). The material can at this stage still be adjusted, but then it should be pushed down well or tapped with a rubber hammer.

Cleaning: Any glue that may protrude along the edges can be removed using a stopping knife.

Drying time and strength:

Multibond Transparent combines the benefits of a tape with that of a reactive adhesive system:

After drying under the influence of humidity, Multibond 600 vulcanizes into a permanently elastic and very strong adhesive connection.

Initially:

Internal strength (direct) > 0,0004 N/ mm²

Strength per m² adhesive surface > 400 N (> 40 kg)

After one hour, the strength has increased threefold:

Internal strength (after 60 minutes) > 0.0012 N/mm²

Strength per m² adhesive surface > 1200 N (> 120 kg)

Safety:

Please consult the safety information, which is available upon request