Acrydur® 116 (GB)

Fast-curing 2-component- adhesive primer
for use on asphalt substrates

PLASTI CHEMIE International GmbH

Application Acrydur® 116 serves as an adhesive primer for the application of Acrydur® coatings, especially on filled asphalt/bitumen substrates.

Characteristics: Acrydur® 116 is a reactive methacrylate resin that also cures quickly even at low temperatures.

Characteristic of the resin as delivered:

Property	Measuring method	Approx. value
Viscosity at 23 °C	DIN 53 015	180-240 mPa · s
Flow time at 20°C, 4 mm cup	DIN 53 211	30-40 sec
Density D^{20}	DIN 51 757	0.97 g/cm³
Pot life at 20°C	ca. 5 min	
Curing	ca. 12 min at 20°C	
Form of delivery	slightly, cloudy, liquid	
Shelf-life	dark at < 20 °C 6 months maximum	
Bundle	180 kg drums 25 kg, 10 kg pails	

Characteristic of the resin in the hardened state:

Property	Measuring method	Approx. value
Strain at break	EN ISO 527	~3%
Tensile strengh	EN ISO 527	~ 9.8 MPa
E-modul	EN ISO 527	300 MPa
Water absorption, 4 days	DIN 53 495	0 mg
Shore-D	DIN 53 505	65-80 Units

Initiator/Hardener: Hardening powder 50W (BPO), depending on temperature

Processing Notes:

Processing: The surface must be dry (max 4% residual humidity), firm, solid and free of dust, grease and oil.

Acrydur® 116 can be processed with Acrydur® Hardener 50 W. The quantity of hardener must be adjusted to the respective object temperature (see table). At temperatures below - 0°C, accelerator B101 can be added additionally ~ 0.5% at 0°C up to 3 % at -30°C with retention of 6 wt.% hardener powder.

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After the hardener has been stirred in, the primer is poured onto the substrate and applied with a short pile paint roller. A notched rubber squeegee can be used for rapid distribution of large quantities. Apply at a rate of 0,3 kg/m² to 0,6 kg/m² depending on the density and porosity of the substrate. In all cases, continue to apply the primer until saturation occurs to obtain a continuous resin film. On extremely porous absorbent substrates, prime twice to achieve a thin but closed film that bonds the broadcast material. We recommend slightly broadcast the primer with quartz sand (size (particle size 0.7 - 1.2 mm). If only thin sealers are to be applied, we recommend using quartz sand in size 0.4 – 0.8 mm. This step ensures an absolutely solid bond between primer and the subsequent coating.

Mix Ratio:

8 L primer Acrydur® 116
160 mL – 200 mL (2 - 2,5 wt.%) hardener 50 W at 20 °C ground temperature

Amount of Hardener depending on temperature:

Further coating layers with Acrydur® must only be applied after the previous layers have completely cured.

Temperatur [°C]	Hardener [Vol%]	Hardener [wt%]	Pot life [min]	Curing time [min]
+0	6.0	4.0	ca. 5	ca. 25
+5	5.0	3.3	ca. 5	ca. 20
+10	4.0	2.6	ca. 5	ca. 15
+15	3.0	2.0	ca. 5	ca. 12
+20	3.0	2.0	ca. 5	ca. 12
+25	3.0	2.0	ca. 5	ca. 8

- Hardener quantity calculated according to Acrydur® 116
- Temperature refers to resin, surface and air temperature

Note:

Weight to Volumetric conversion of Hardener
1 cm³ of Acrydur® Hardener 50 W weighs 0.65 g
1 g of Acrydur® Hardener 50 W = 1.54 cm³

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Attention: Hardener levels below 1 % by weight may cause polymerization failure!

Storage: The handling-regulations for highly flammable materials apply to methacrylate – resins. Acrydur® resins should be stored cool, away from direct sunlight and preferably at temperatures between 15 – 20 °C. During storage, paraffin particles and fillers may precipitate. Thus, before processing, containers must be well agitated before use. Please refer to our Safety Data Sheets.

Industrial safety:

Provide adequate ventilation during work. During processing, observe the regulations of the Hazardous Substances Ordinance, the instructions of the Federal State Committee for Occupational Safety and Safety Technology (LASI), and our safety data sheets.

VbF: A I

GISCODE: RMA 10

HS-Code: 3208 2010

CE-labelling

CE	
Plasti Chemie Produktionsgesellschaft mbH • Falgardring 1 • 08223 Falkenstein • Germany	
EN 13813, SR-B2, 0-AR0, 5-IR12	
Acrydur® 116	
Synthetic resins for internal uses (Application in accordance with the newest technical information)	
Reaction to fire:	E_{fl}
Wear resistance (Abrasion Resistance):	AR 0.5
Impact resistance:	IR 12
Tensile bond strength:	B 2.0

Data concerning our products and devices as well as concerning our data and procedures are based on an extensive research work and an application technology experience. We obtain these results, with which we do not take over adhesion going beyond the respective single contract, in word and writing after best knowledge, reserve ourselves we however technical changes in the course of the product development. Beyond that our application technology service stands when desired for large consultation as well as for co-operation with the solution manufacturing and application technology problems for order. That does not relieve the user however to examine our data and recommendations before their use responsible for the own use. That applies - particularly for deliveries to foreign markets - also regarding the keeping of patent rights third as well as for applications and procedures, which are not expressly in writing indicated by us. The case of loss our adhesion is limited to indemnifications of same extent, as they plan our general terms of delivery and sales with lack of quality.

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