
Application: In combination with Acrydur™ coating resins, the adhesive agent permits a primer-free coating on hot galvanized, fire-zincd and bright metal surfaces as well as an adhesive primer for ceramic tiles.

Characteristics: The Acrydur™ Adhesive Agent improves the adhesion on metal and ceramic substrates. Due to the corrosive properties, the adhesive agent should be stored in the original packaging and only be added to the Acrydur™ resins immediately prior to application. Acrydur™ resin mixed with adhesive agent is not storage-stable!

Characteristic data:

Delivery form	liquid, strongly acidic
Density	10.098 lb/gal
Flashpoint	50 °F
Shelf life	Store only in glass- or polyethylene bottles, dark at < 65°F, maximum 6 months

Processing Notes:

Formulation: 0.2 - 0.3 % by weight on pure Acrydur™ resin.

Suggested
formulation:

1. Coating on iron sheet metal (defatted) app. 1 - 2 mm

100 ppW	Acrydur™ 418 N
0.2 ppW	Acrydur™ Adhesive agent
3 ppW	Acrydur™ Hardener powder 50 W

Broadcast with quartz sand (18 - 35 mesh)

Pot life (68°F)	app. 20 min
Curing time (68°F)	app. 60 min

An equally good adhesion is also obtained on other metals like aluminum, copper and zincd iron.

Attention: Layer thickness < 1mm lead to adhesive errors.

2. Coating on ceramic tiles, primed with following formula

100 ppW	Acrydur™ 112 N
0.2 ppW	Acrydur™ Adhesive agent
4 ppW	Acrydur™ Hardener powder 50 W

Pot life (68°F)	app. 10 min
Curing time (68°F)	app. 35 min

or

100 ppW	Acrydur™ 112 N
0.5 ppW	Acrydur™ Adhesive agent
0.3 ppW	Acrydur™ Accelerator B101
4 ppW	Acrydur™ Hardener powder 50 W

Pot life (68°F)	app. 10 min
Curing time (68°F)	app. 40 min

After this layer is cured an optional top layer of Acrydur™ 332 N or Acrydur™ 418 N can be installed.

Advice:

Adding of adhesive agent effects a retardation of hardening within the Acrydur™ resins and a heavier yellowing of the products. Therefore, we recommend to add approximately 0,2 to 0,3 % accelerator B 101 additionally and increase the proportion of hardener up to 3 to 4 %, as well, when putting in higher quantities of adhesive agent (> 0,5 %) or at temperatures below 68 °F.

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.