TECHNICAL DATASHEET

POLYURETHANE ADHESIVES
Two component

Casting compound
GAP FILLER SS10

Tough hard, filled, two-component, polyurethane-based resin with excellent electrical and mechanical properties.

The adhesive vapors are heavier than air and therefore sink when applied.

Technical properties uncured product (at 23°C ± 1°C)

Chemical basis:	Polyurethane
Colour: Component A Component B	 green brown
Viscosity mPas DIN53019/1:	Polyol 16.000 ± 1.500 Polyisocyanate 260 ± 90 Mixture 3.500 ± 400
Density g/cm^3: DIN 53217	Polyol 1,43 ± 0,03 Polyisocyanate 1,23 ± 0,03 Mixture 1,39 ± 0,03
Mixing ratio: weight	100:20 (Polyol:Polyisocyanate)
Processing temperature:	+10 °C till +40 °C, +24 °C ± 2°C optimal

Technical properties hardened and tempered product (16 h bei 80 °C)*

Colour:	Bamboo green
Shore hardness:	50 ± 3 D, DIN EN ISO 868
Linear expansion coefficient:	$90*10^{-6}$ K^{-1}, DIN 53752
Thermal conductivity:	0,45 W K^{-1} m^{-1}, DIN 52612
Temperature Index:	130 °C, IEC 60216
Fire behavior:	HB, UL 94

Curing*

The curing time at room temperature depends on the pot life, the casting volume, as well as the casting resin and mold temperature. By applying heat, the cure can be accelerated (e.g., 4 hours at 100 ° C).

Pot life:	270 ± 30s, depending on the dosing and mixing system
Curing time:	24 h

Processing

The adhesive is developed for automatic application. The processing is possible with a two-component metering and mixing equipment. For the processing in this metering equipment the validation needs to be done by the customer. This validation takes place on time to prevent production losses. These machines allow processing with a very short pot life. The polyol component must be stirred up for 5 minutes with 200 rpm prior start of dosing. Subsequently the polyol component in its original container is resistant to sedimentation for a maximum of 72h. Due to the hardener containing isocyanate compounds, an appropriate ventilation and filtering system is necessary. Polyol and Isocyanate component need to be used single-batch to guarantee the function of the adhesive.

Preparation

The parts to be potted should be clean, dry and free of grease.

Precautions

Before handling these products, the safety data sheets has to be read carefully.

GLUETEC GROUP
Germany | Poland | Slovenia

GLUETEC Industrieklebstoffe GmbH & Co. KG
Am Biotop 8a
97259 Greußenheim - Germany

Tel: +49 (0) 9369 / 9836-0
info@gluetec.de
www.gluetec.de

WIKO KLEBETECHNIK Sp.zo.o.
ul. Ekonomiczna 8
42-271 Częstochowa – Poland

Tel: +48 (0) 34 372 58 58
info@wikoklebetechnik.pl
www.wiko-technika-klejenia.pl/

GLUETEC d.o.o.

Plese 9
9000 Murska Sobota - Slovenia
Tel: +386 (0) 59 07 93 95
info@gluetec.si
www.gluetec.si

TDB_GAP FILLER_V07, created 11.02.2019

Packaging unit

Polyol:	5l bucket
Polyisocyanate:	3l bucket

Storage & Durability

The polyol and polyisocyanate components must be protected from moisture and should not be stored below + 5 ° C. The cheapest storage temperature is 15-25 ° C. In closed original containers, both components are at storage conditions, as described before, 6 months. Opened containers should be used up as soon as possible.

Note:

Please note the information and notes in our respective safety data sheets. The data contained herein are for informational purposes only and are believed to be accurate to the best of our knowledge. We assume no liability for the results. It is the user's own responsibility to take precautions to protect property and people from the hazards that may be encountered in handling and using these products. Accordingly, GLUETEC specifically disclaims any warranty, express or implied, including any warranty or fitness for a particular purpose. In particular, GLUETEC disclaims all liability for consequential or indirect damages of any kind.

* according to GLUETEC test method for polyurethane adhesives

GLUETEC GROUP
Germany | Poland | Slovenia

GLUETEC Industrieklebstoffe GmbH & Co. KG
Am Biotop 8a
97259 Greußenheim - Germany

Tel: +49 (0) 9369 / 9836-0
info@gluetec.de
www.gluetec.de

WIKO KLEBETECHNIK Sp.zo.o.
ul. Ekonomiczna 8
42-271 Częstochowa – Poland

Tel: +48 (0) 34 372 58 58
info@wikoklebetechnik.pl
www.wiko-technika-klejenia.pl/

GLUETEC d.o.o.

Plese 9
9000 Murska Sobota - Slovenia
Tel: +386 (0) 59 07 93 95
info@gluetec.si
www.gluetec.si