

# Q 2C-alu-adhesive

greenteQ 2C PUR reaction adhesive for the gluing of aluminium corners in window constructions.

## Properties:

greenteQ 2C-alu-adhesive is used by specialized window manufacturers for the gluing of aluminium corners in anodised and power-coated cladding and casement frame profiles of aluminium windows, doors and facade elements. Casement Sections glued with greenteQ 2C-alu-adhesive can be powder-coated. greenteQ 2C-alu-adhesive is used for the constructive bonding of GFR sandwich elements in the car manufacturing industry and other specialized companies. The product is also recommended for the industrial gluing of other

materials such as aluminium or HPL. Thanks to the dual cartridge and the greenteQ static mixing tube, greenteQ 2C-alu-adhesive is particularly easy to apply. greenteQ 2C-alu-adhesive is thixotropic, does not drip and is free of solvents. When fully hardened, it can be painted over. The product is weather-resistant.

## Picture of product:

## Technical data:

Base:	two-component PUR reaction adhesive, solvent-free (free of very volatile organic compounds with boiling point < +170 °C)
Colour of greenteQ 2C-alu-adhesive: beige cured film / bonding component / curing component	ivory / white beige / beige
Colour of greenteQ 2C-alu-adhesive: white cured film / bonding component / curing component	pearl white / white / beige
Film properties (of cured film)	tough, hard
Shore hardness (of film cured at +20 °C according to DIN 53505)	85 Shore D
Mixing ratio (volumetric)	A:B = 1.0:1.0 ml
Viscosity (at +20 °C) mixture / bonding component / curing component	low-viscous, pasty / low-viscous, pasty / low-viscous, pasty
Density (according to EN 542 at +20 °C) Mixture of greenteQ 2C-alu-adhesive white and beige	approx. 1.52 g/cm <sup>3</sup>
Pot life (100 g of mixture at +20 °C)	approx. 60 min
Working time (of dual cartridge with static mixing tube at +20 °C, with dual air application gun)	approx. 45 min (at +30 °C, the working time is reduced by approx. 50 %; at +10 °C, the working time is doubled)
Operating strength (e.g. glued corner bonds at +20 °C)	approx. 6 h
Cure time at +20 °C, 60 % air humidity to ~75 % final strength	approx. 24 h
Cure time to final strength	approx. 7 d
Minimum working temperature	from +7 °C
Tensile shear strength DIN/EN Al/Al (gap width 0.2 mm) at +20 °C / at +80 °C	approx. 18.0 N/mm <sup>2</sup> / approx. 9.0 N/mm <sup>2</sup>

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## Surface preparation:

Prior to gluing, the surfaces must be chemically treated or coated. Aluminium blank cannot be properly glued unless the adherend surfaces are suitably treated.

## Use instructions:

- When gluing materials of different elongation properties, the stress caused by fluctuations in temperature must be taken into account when assessing the long-term behaviour of the bonds.
- greenteQ 2C-alu-adhesive might become discoloured when exposed to sunlight. This does however not affect its bonding strength!

### MIXING METHOD I:

Screw the greenteQ static mixing tube (180.025/0043) onto the open adhesive cartridge. By operating the DLP 550 (968.946/0550) or DLP 900 (968.946/0900) air application gun (depending on the cartridge size), the adhesive is mixed to form a homogeneous compound in the static mixing tube and can be applied directly into the dry, dust-free and grease-free profile. Then the parts can be joined and pressed together until the operating strength is reached.

- For safety reasons (cartridge filling technology), do not use the first 20 g of mixed adhesive!

The working time is ~45 min at room temperature. After short breaks within the working time, fresh adhesive can be mixed in the greenteQ static mixing tube by dosing a new batch. This means that the same static mixing tube can be used for the entire work shift.

- At the end of the shift, leave the greenteQ static mixing tube (180.025/0043) on the cartridge and replace it only at the beginning of the next shift; you must again dispose of the first ~20g of adhesive dispensed from the tube!

### MIXING METHOD II:

Place the open adhesive cartridge in the air application gun DLP 550 (968.946/0550) or 900 (968.946/0900) (depending on cartridge size). Actuate the air application gun to dispense the two components into a mixing tray. You can now add bonding accelerator and/or colorants. The components are mixed to a homogeneous compound. Apply the adhesive with a spatula onto the dry, dust-free and grease-free adherend surface, using a spatula. Join the parts together and press them until the operating strength is reached.

Average application quantity: approx. 20 g/corner

The pot time and the required press time can only be determined by carrying out internal tests, as they vary greatly depending on the material, temperature, application quantity, moisture in material and other parameters. As a rule, add appropriate safety margins to the recommended values.

## Cleaning:

Uncured greenteQ 2C-alu-adhesive can be removed with greenteQ Alu-cleaner. Cured greenteQ 2C-alu-adhesive must normally be removed mechanically.

## Storage and delivery form:

Store in tight original container in a dry place at temperatures between +15 °C and +25 °C and protect against direct sunlight. Storability in sealed original container: 12 months

Original container: 550 g dual cartridge, 900 g dual cartridge  
Shipping unit: Carton with 6 cartridges

## General notes:

This product data sheet replaces all previous versions.