

## 2-Component SE Polymer flexible, non-ageing 2-component adhesive

**690.00**

**Application:** For flexible bonding of plastics, metals and caoutchouc materials, also for sealing seams and as casting compound. Preliminary customer testing is absolutely necessary.

**Basis:** Hybrid system of epoxy resins and silane-terminated polymers.  
Free of plasticisers, isocyanates, solvents and silicones.

**Characteristics/  
Directions  
for Use:** Pasty compound which flows and spreads well. Application to one of the substrates, then fix both substrates for approx. 2 h at RT. Increasing the temperature will reduce the curing time. Curing is bubble-free, no reaction shrinkage. After approx. 24 h, 50 % of the final strength will already be achieved. Complete cure within 1 week at RT, independent of the adhesive application thickness.

The surfaces to be bonded have to be clean, dry and grease-free. Application is carried out using a 2-component cartridge with a static mixer (at least 18 to 24 elements). A suitable type of gun would be a squeezeout piston type for cartridges, which can be operated manually or by electronic controls. We do not recommend using guns operating with compressed air, since the air jet exerts uncontrolled pressure on both chambers, and this may prevent a homogenous mixing result. Larger quantities can also be mixed homogeneously in a clean container and then applied with a toothed spatula within the pot life. Can also be applied with automatic 2-component dispensing systems.

Bonding results depend on the material properties and processing conditions. We therefore recommend preliminary customer trials

### Technical Data:

	<b>Component A 690.01</b>	<b>Component B 690.02</b>
Colour:	white	black
Density [g/cm <sup>3</sup> ]:	approx. 1.12	approx. 1.28
Solid content [%]:	approx. 100	approx. 100
Mixing ratio [by volume]:	2	1
Mixing ratio [gravimetric]:	100	57
Data of the mixture:		
Viscosity [mPas]:	approx. 50,000	
Processing time [minutes]	approx. 25 – 30	
Appearance:	blackish-gray	

**Thinner:** May not be thinned.

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01/16 All data indicated are characteristics represented as average values. Our technical data sheets are constantly revised to represent the latest state of technology. This edition is replacing all previous ones, and is valid on the date of compilation.  
**Please turn page for additional information.**

- Cleaning:** Before curing the prepolymer can be cleaned with a solvent-soaked rag for instance using Jowat® Thinner 401.30, after curing only mechanical removal (emery paper).
- Storage:** In properly closed containers, cool and dry (15 – 25 °C). Best-before date, please refer to label on the packaging unit.
- Packaging:** 180 ml / 205 g cartridges (analogues to common silicone cartridges). Both components are also available in 11.2 kg / 6.4 kg pails for manual processing and in 200 l drums for industrial mixing and dosing units. Other types of packaging and units upon request.
- Remarks:** For further information concerning handling, transport and disposal, please refer to the Safety Data Sheet.  
Our information on this data sheet is based on test results from our laboratories as well as on experience gained in the field by our customers. It can, however, not cover all parameters for each specific application and is therefore not binding for us. The information given in this leaflet represents neither a performance guarantee nor a guarantee of properties, nature, condition, state or quality. No liability may be derived from these indications nor from the recommendations made by our free technical advisory service.

## **Jowat Information**

Gluing as one of the most efficient methods of bonding is constantly gaining importance and expanding into new areas of application. At the same time, the number of substrates to be bonded is also growing at an unprecedented rate. New methods and equipment to process adhesives are developed.

The in-house R & D departments of Jowat are responding with intensive efforts to keep pace with these constant changes. A highly qualified team of chemists and engineers is using the latest techniques and brightest ideas to provide the utmost in advice our customers and to make sure that they get the adhesive which meets their needs.

Our information is based on test results from our laboratories as well as on experience gained in the field by our customers. This advice, however, cannot cover all eventualities for each specific application and as such is not binding for us. Please, contact our technical service department in each case to find out what the actual technical state of development for the respective product is, and request the latest data sheet. Any use of our product without this precautionary measure would be your sole responsibility.

The processing company itself must therefore test the adhesives manufactured by us for suitability in each individual case. This applies to the first use of a sample as well as to modifications during an ongoing production.

We are therefore requesting all our new customers to test our adhesives for suitability on original parts at conditions equal to normal processing conditions. The bond has then to be subjected to the actual stress which it would undergo when in use and has to be assessed. This test is absolutely necessary.

Customers who undertake modifications during a running production are requested to pass this information on to us. Please notify us when machines are set to new parameters as well as when the substrates to be bonded are changed. Only then will Jowat be able to provide our most up-to-date information to the processor using our adhesives.

The information given in this leaflet is based on practical experience and on results of tests in our laboratory, and does in no way constitute any guarantee of properties. No liability may be derived from these indications nor from the recommendations made by our technical advisory service.