Technical Data Sheet

F6

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1. Purpose

F6 is designed for gluing of car and industrial filter elements. The adhesive produces hard and solid joint with slightly elastic properties. Its characteristic assures very good mechanical properties and efficient vibrations absorption. Fully cured joint is resistant to diesel oil (tested for 96h at 40°C) and engine oil (tested for 96h, 140°C).

2. Physical and chemical properties

	F6 A (polyol component)	F B (isocyanate component)
Form	beige suspension	brown liquid
Viscosity at 25°C [mPas]	3500 ±100	200 ±50
Density at 20°C [g/cm^3]	1,55 ±0,05	1,23 ±0,02

3. Technological properties*

Component mixing ratio recommended:

	by weight	by volume
F6 A	100	100 D
F B	25 ±1	30 ±1,5

The adhesive use with different mixing ratio can cause the reaction time changes or the joint flexibility and mechanical strength changes.

Reaction times of 80,0g F6 A and 20,0g F B mix measured in a cup at 19 – 21°C temperature and 50 % of air relative humidity:

Application time:	80 – 100 s
Initial curing time:	3 – 5 min
Free rise density:	1400 –1500 kg/m^3
Joint hardness :	65 - 75°Sh D

The adhesive sets as a result of chemical reaction of F6 A and F B components, therefore accurate mixing both components in given weight ratio is very important. Glued filter elements should be set together not later than 80-100 s after the adhesive components mixing. In practical manner it means filter material should be placed in the adhesive before the adhesive gelation starts. Such procedure provides maximum joint strength obtainment. Joined elements should be kept in the same position for time necessary to get the initial joint curing. It takes place 3 - 5 minutes after the components mixing depending of glue amount. Those technological times were obtain under model conditions and might be much shorter while working with mechanical high-speed mixer mixing machines.
Time for full strength of the joint obtainment is 24 h.

4. Processing conditions

F6 A component should be mixed once again before use; it is especially important after pretty long store time. Glued surfaces should be dry, free of dirt and degreased, if necessary.

Processing temperature range:	10-80°C
The product should be stored in tightly closed containers at	10 – 35°C
Expiration date for use:	6 months

5. Application safety

F6 A is not classified as dangerous substance. F B is harmful substance. One should read carefully the product Safety Data Sheet before its applying. Standard protective clothing should be wear at work with the adhesive. Freshly get dirty places should be washed off with ACT solvent. Set adhesive can be removed mechanically

***Notes**

Data presented in this information have been obtained in model conditions. The results obtained when operating in other conditions can be slightly different from published.

Every time the user is obliged to check the product and auxiliary agents usefulness for his intentional use.

The user is obligated to have a valid technical data sheet and safety data sheet of the product, which is provided by the manufacturer during the sale and every time on the customer's request.

Prior to processing the user must carefully read aforementioned documentation and follow the rules of procedure for product use.