

## Technical Data Sheet

### ZM-32-1

#### ONE-COMPONENT POLYURETHANE ADHESIVE

Issue date: 2015.02.06

Revision: 2016.09.06

#### 1. Purpose

ZM-32-1 adhesive is designed to bond together elements made of flexible foams and fibrous materials.

#### 2. Physico-chemical specification

State of aggregation	liquid
Colour	yellowish
Viscosity at 25°C [mPas]	7000 – 12000
Density at 20°C [g/cm <sup>3</sup> ]	1.05 – 1.15

#### 3. Technological properties

ZM-32-1 polyurethane adhesive hardens by reaction with moisture contained in air and glued materials. The joint slightly foams in the course of bonding. The adhesive hardening times get shorter with temperature increase and also with air and glued materials humidity increase. After bonding the adhesive makes flexible joint resistive to temperature in the range -40 to +80°C.

#### 4. Processing conditions

Glued surfaces should be free of dirt and degreased, if necessary:

Application temperature range	+5 to +40°C
Optimum humidity	50 - 80 %
The adhesive consumption	0.05-0.30 kg/m <sup>2</sup>
Time for full strength of the joint achieving	24 h
Storage temperature recommended	+15 to +25°C

The adhesive should be stored in tightly closed containers. One should open the container, take necessary volume of the adhesive and close it tightly again.

#### 5. Application method

The adhesive is mainly intended for mechanical application (rollers). Spread adhesive should be bedewed with water mist for uniform hardening on the whole glued surface. Both glued elements should be tightened together after adhesive and water mist applying and kept under load until the joint hardens. The adhesive consumption value is 50 – 300 g/m<sup>2</sup> and it depends on glued materials texture. The time for glued elements assembly and pressing is 45 minutes; the joint requires 6 hours for hardening. After bedewing with water mist open time gets shorter to 30 minutes and hardening time gets shorter to 4 hours.

#### 6. Application safety

ZM-32-1 is harmful substance. Read carefully Safety Data Sheet of the product before use. Wear standard protective clothing when operating with the adhesive. Wash off fresh contaminations with solvent. Hardened 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 safety data sheet of the product, which is provided by the manufacturer during the sale and everytime on the customer's request.**

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