

# TECHNICAL DATA SHEET

## BONDAN FL20

Revision: 18.03.2021

Version: 1.001



### PRODUCT DESCRIPTION

BONDAN FL20 is a solvent-free, versatile, elastic, one-component adhesive and sealant for bonding vehicle bodywork, containers and vehicle manufacture, air conditioning and heating equipment, metal work and many other areas.

The product exhibits very good adhesion to glass, many metals (zinc, aluminum, steel, etc.), paints, priming coats, wooden materials, mineral substrates as well as thermosetting plastics and thermoplastics (except for PE, PP, PTFE and similar).

In the cured state, BONDAN FL20 feature high moisture and weather resistance and, thus, is very well suited for both indoor as well as outdoor applications. Moreover, the product is temperature-resistant in the range from -40 ° C to +90 ° C (and briefly up to +120 ° C).

### TECHNICAL PROPERTIES

Appearance	pasty
Color	black
Chemical basis	MS polymer, moisture curing
Viscosity at 25 °C	steady paste, spreadable
Density at 20 °C	≈ 1.61 g/cm <sup>3</sup>
Processing temperature	+5 °C to +30 °C

### CURING PROPERTIES

The curing rate depends especially on the humidity, curing temperature, gap, surface and material pairing.

Skin formation time	≈ 20 min
Curing speed	3 mm (on the 1st day); thicker layers require extended curing time
Weight loss (DIN 52451)	1 % (within 14 days)

### PROPERTIES IN THE CURED STATE

Hardness Shore A (DIN EN ISO 868)	≈ 60 (specimen thickness 6 mm, after 4 weeks)
Elongation at break (DIN 53504)	≈ 300 %
Tensile strength (DIN 53504)	≈ 1.9 N/mm <sup>2</sup>
Resistance to tear propagation (ASTM D624)	≈ 12 N/mm <sup>2</sup>
Temperature range	-40 °C to +90 °C (briefly up to +120 °C)

# TECHNICAL DATA SHEET

## BONDAN FL20

Revision: 18.03.2021

Version: 1.001



### DIRECTIONS FOR USE

- Clean, dry and grease-free surfaces ensure the maximum strength.
- Clean soiled surfaces with BONDAN Cleaner or an appropriate solvent. We dis advise the use of cleaners containing acetone.
- Ensure sufficient flash-off time when cleaning parts.
- The adhesion and compatibility with plastics and paints has to be checked individually on the original material. BONDAN FL20 can be used on most materials without a primer.
- Apply the adhesive to the substrate using a dispensing gun.
- The thickness of the applied layer must be adapted to the forces and movements which are to be expected. The parts must be joined and pressed on within the skin formation time. It is advisable to fix the components until the adhesive is fully cured.
- The curing time particularly depends on the humidity, temperature, gap, surface and material pairing.
- BONDAN FL20 can be painted over wet-on-wet. Preliminary tests are required with respect to painting. Coating of the adhesive reduces the access of humidity and, thus, slows down the curing process. The maximum movement absorption is usually limited by the paint.
- Tools must be cleaned immediately after use. Cured material can only be removed mechanically.

### STORAGE

- 12 months at +5 °C to + 25 °C in unopened original packaging
- Do not store above +25 °C

### PRODUCT LABELLING

See safety data sheet.

### PACKAGE UNITS

- For manual application 300 g cartridge

All information provided is based on our extensive tests and practical experience. The data are given for information only. Drei Bond cannot assume responsibility for the results obtained by others which methods are not under our control. It is user's responsibility to determine suitability for user's purpose of any product mentioned herein. Drei Bond disclaims all warranties expressed or implied, including warranties of fitness for a particular purpose, arising from sale or use of BONDAN products.