



Used as a contact adhesive, **GLUKON**<sup>®</sup>poly offers permanent bonding of XPS/EPS/foam together and with a wide range of different substrates. **GLUKON**<sup>®</sup>poly stands out due to the fine spray pattern, rapid flash-off time, long open time and very high initial adhesion.

**GLUKON**<sup>®</sup>poly can be applied on one side for fixing (e.g. for carpet tiles) or on both sides as a contact adhesive. The adhesive also remains flexible after hardening. **GLUKON**<sup>®</sup>poly is used wherever lightweight, pressure-sensitive materials, e.g. XPS/EPS, are to be bonded or materials need to be fixed quickly.

- + The spray adhesive satisfies the requirements of the French VOC regulation for class A+
- + Based on the emission test, the spray adhesive satisfies the requirements for VVOC, VOC and SVOC emissions in accordance with the testing and evaluation scheme of the Committee for Health-related Evaluation of Building Products (AgBB evaluation scheme).



## MATERIALS

**GLUKON**<sup>®</sup>poly is suitable for bonding polystyrene/Styropor<sup>®</sup> together and for bonding with other materials such as XPS, foams, textiles, real leather, metal sheets, wood, MDF, chipboard, the majority of plastics and much more.

## FEATURES

- + Adhesive is applied quickly and easily
- + Mobile, ready for immediate use without power or compressor
- + Pressure-sensitive contact adhesive
- + Spraying method: Web spray
- + Flash-off time: approximately 1 minute depending on ambient temperature/humidity
- + Open time: approx. 12 hours
- + The cured adhesive is not flammable
- + Dichloromethane-free, Toluol-free

## TECHNICAL DETAILS

- + Description: Solvent-based sprayable adhesive
- + Colour: Transparent-yellowish
- + Solid content: approx. 28 %
- + Resistance to temperature: approx. 65°C (brief period)
- + Shear strength: >85 psi
- + Coverage per 13 kg pressure container: approximately 80 - 100 m<sup>2</sup> (application on both sides)
- + Coverage per 500 ml tin: approximately 3 - 4 m<sup>2</sup> (application on both sides)

## INSTRUCTIONS FOR USE

Before every job, it is necessary to check whether the selected adhesive is suited to the requirements profile of the materials used and the intended site of use!

The materials to be bonded must be unstressed, dry, clean and without dust, grease and cracks. Use only acetone for de-greasing or isopropanol in the case of sensitive surfaces (e.g. plastic or plexiglas). The suitability of the selected cleaner should be checked for compatibility beforehand on a non-visible surface. For optimum bonding, metals and smooth surfaces must be cleaned and degreased with a lint-free cloth. It is then necessary to roughen the materials by cross-grinding with sandpaper (recommendation: aluminium oxide, 100 grade). After that, degrease the materials once again.

To ensure optimum results, the adhesive should be used at temperatures of 15 - 25° C (ideally 20° C). This also applies to the materials to be bonded.

With first use, connect the hose and gun to the container. Then slowly open the container valve and check the system is leak-tight. The system is now ready for operation. To apply the adhesive, hold the gun approx. 10 cm (hand width) above the application surface. The rule of thumb for correct application here is: Spray jet width = distance to the workpiece. Apply the adhesive evenly. Avoid puddles of adhesive (solvent build-ups).

**For contact bonding**, always apply the adhesive crosswise to both sides to be bonded (surface 1 vertically, surface 2 horizontally). Application quantity (both sides) approx. 23g/m<sup>2</sup> dry. Double application is recommended around edges or on very absorbent substrates, e.g. foam, wood panel materials and concrete. Allow the adhesive to dry for approx. 1 minute until the solvents have flashed off completely (finger test). Compliance

with the flash-off time is extremely important and must be **precisely** observed! The open time is approx. 12 hours. Now the materials can be placed. It will not be possible to shift the materials afterwards! Then press/roll the materials together firmly (contact pressure approx. 2.5 - 3 kg/cm<sup>2</sup>). **High contact pressure is essential for optimum bonding!** The materials can be further processed immediately. It takes about 24/48 hours until the adhesive is completely cured. **The adhesive is applied on one side for fixing.** Application quantity approx. 11g/m<sup>2</sup>/dry. Allow the adhesive to flash off sufficiently again. It is now possible to fix together the parts to be joined. Fixed parts can be removed and their position corrected if necessary. **Important: Not final bonding strength!**

Lock the spray gun after use. The valve on the adhesive container must **NEVER** be closed unless the container is being replaced with a new one or it is closed for transport to the construction site. Please use **GLUKON**<sup>®</sup>Citrus Cleaning Spray for removing adhesive residues from surfaces. Before use, please read our Glukon instructions for use (enclosed with the container), which are also available to download from: [www.glukon.de](http://www.glukon.de)

**Important information:** Depending on the raw material base, some cleaning agents may attack the adhesive and for this reason avoid directly spraying onto the adhesive joints when cleaning soiled surfaces. **Recommendation: Do not apply the cleaning agent directly to the workpiece, but rather apply it to a lint-free cloth and clean the surfaces with this. Do not use GLUKON**<sup>®</sup>poly for bonding plasticising materials such as PVC, CV coatings, vinyl and artificial leather!

#### APPLICATION CHECKLIST

- + Does the selected adhesive match the requirements profile and the intended site of use?
- + Are the materials to be bonded correctly acclimatised (at least 48 hours) or adjusted to the prevailing climatic conditions at the place of installation?
- + Are the materials to be bonded dry, clean and free of dust and grease? Degrease only with acetone or isopropanol. Metals and smooth surfaces should be additionally roughened and then degreased again.
- + Do the application temperatures of the adhesive, the materials and the environment fall inside the permissible parameters (15 - 25 °C)?
- + Are you sufficiently familiar with how to apply the adhesive? Distance between the spray gun and the workpiece, spray jet width and spraying speed? Please visit our website: [www.glukon.de/anwendung](http://www.glukon.de/anwendung) and watch our application video for further information.
- + Do you know the respective flash-off times and open times for the adhesive to be used? These must be adhered to!
- + Are the materials free of tears or similar damage?
- + Has the work process been thought through? Can dirt be ruled out when applying the adhesive?
- + Is the system ready to use? Is the product well shaken? Pistol and nozzle should spray without problem.
- + Is the correct nozzle being used? Please only use our Glukon standard nozzle with our web spray adhesives.
- + Are pressure rollers or veneer hammers ready? High contact pressure is essential for optimum bonding!
- + Is health and safety ensured?

#### HEALTH & SAFETY / SAFETY INSTRUCTIONS

- Processing must only be performed by competent individuals.
- Personal protective equipment should be worn in areas without sufficient ventilation when working with GLUKON<sup>®</sup> poly.
- **The Technical Rules for Hazardous Substances (TRGS 610) and the Hazardous Substance Regulations are to be complied with.** Before using solvent-based adhesives, check whether alternative adhesives with a less harmful risk profile can be used. The risk assessment required for this is to be saved in writing. Please also observe our safety data sheets in this regard. Directly breathing in the solvent should be avoided.
- With incorrect use there is a risk of an explosive gas/air mixture forming. There is a danger to life in this case!
- Good ventilation of the workplace/site must be guaranteed or ensured by means of suitable technical measures (e.g. ex-protected extraction unit). When working over large areas and in case third parties enter the workplace/site, signs stating 'Danger of Fire and Explosion! Entering with a naked flame as well as smoking and the use of ignition sources is strictly prohibited!' must be put up.

#### STORING AND HANDLING THE GLUKON<sup>®</sup> CONTAINER

Must be stored at a temperature between +10 °C and +50 °C. The container is under pressure. Protect containers from direct sunlight and heat sources. Do not store on a cold concrete floor. Avoid damage to the container or penetration by foreign objects. The containers may not be refilled! Transport containers in an upright position and secure against shifting/toppling. Close container valve when transporting. Protect containers from rain. Handle containers carefully. Do not throw or drop. Only store in well-ventilated rooms. Containers showing damage from the outside, such as dents or

valve damage, are to be disposed of professionally. Do not stick objects in the spray head! Please also refer to the safety datasheet (Point 7 and Point 14) for our GLUKON<sup>®</sup> containers! GLUKON<sup>®</sup> can be stored under the recommended conditions for at least 18 months.

**ATTENTION! SHAKE/ROLL THE CONTAINER WELL FOR AT LEAST 1 MINUTE BEFORE FIRST USE AND IF NOT USED FOR EXTENDED PERIODS. PROTECT FROM FREEZING. ENSURE THE CORRECT TEMPERATURE WHEN WORKING! (min. +15°C).**

#### DISCLAIMER

We always recommend trying the adhesive on your materials first. Please refer to our technical leaflets and the adhesive recommendations of the respective material manufacturer. It is important to test all materials to be bonded before production. The person using the product is responsible for checking whether **GLUKON<sup>®</sup>poly** is suitable for the respective application. **Industrial adhesive. Exclusively for commercial applications.**

The above details are based on results in practice and tests undertaken by us. As we have no influence on the choice of materials or the conditions of use, all details are non-binding information and, as such, no guarantee of characteristics. This also applies to instructions from our technical advice service. Publication of this technical leaflet renders all previous ones invalid.

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