

## DINITROL 515 A/B

adhesive system

### Characteristics:

DINITROL 515 A/B is an adhesive system consisting of the moisture curing adhesive DINITROL 515 A and the accelerating paste DINITROL 515 B with the following properties:

- good adhesion on paints
- less particles
- low odour
- excellent working characteristics
- very good standing properties
- high elasticity
- solvent and PVC free
- OEM approved
- ageing and weather resistant

Together with the corresponding pre-treatments DINITROL 515 A/B is particularly suited to bonding applications in the manufacture of trains, busses and trucks. Because of the excellent working characteristics and less particles, DINITROL 515 A/B is suited also for very good gap fillings. DINITROL 515 A is a polyurethane based adhesive which will cure also without the accelerating paste with ambient humidity to an elastic and aging resistant adhesive / sealant with the well known mechanical properties.

To facilitate a curing which will not depend on the ambient humidity and the geometric design of the bonding the accelerating paste DINITROL 515 B was developed.

Both products are adjusted to each other and the curing process will proceed simultaneously all over the bonding area. This is in contrast to one component adhesives where curing is governed by surface depending moisture access and diffusion controlled curing progress. This makes it possible to remove all kinds of fixation devices several hours after the adhesive application and the bonded parts can be transferred to other working procedures.

### Application:

The adhesive system may be applied by an equipment available on the market. DINITROL 515 A is extruded out of pails whereas DINITROL 515 B will be dosed out of pails and/or cartridges. The recommended mixing ratio is 100 to 5 (parts by volume). Mixing is achieved by static mixers with around 18 mixing elements. Application is at room temperature. The to be bonded surfaces must be cleaned and be primed according our recommendations.

The use of this product is suitable only for experienced users. Pre-tests are recommended for special applications.

Die in diesem Merkblatt gemachten Angaben sind das Ergebnis sorgfältiger Untersuchungen. Soweit sie sich auf die Anwendung beziehen, sind sie als Empfehlung zu betrachten, die dem Erfahrungsstand entsprechen. Wegen der Vielseitigkeit der Anwendungs- und Arbeitsweisen können wir jedoch eine Verbindlichkeit nicht übernehmen. Es wird daher ein vertragliches Rechtsverhältnis nicht begründet, und es entstehen aus eventuellen Kaufverträgen keine Nebenverpflichtungen.

All data and recommendations are the result of careful tests by our laboratories. They only can be considered as recommendation which correspond to the level of experience of today. The data are given in good faith. However, in view of the multiplicity of possible application and working methods we are not in a position to assume any responsibility or obligations deriving from the use of our products.

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### Further information:

The following publications are available on request:

- Safety data sheet
- DINOL pre-treatment chart

### Storage & Transport:

Store between 0 and 35°C, in closed packaging.

During transport the storage temperature may shortly (2 to 4 days) go below or above these limits. When this happens, the material has to be climatized at room temperature before application: Drums, hobbocs, cartridges and foil wraps need 1 to 2 days. Single cartridges and foil wraps need 3 to 4 hours.

### Available packagings:

Pail	50 litres	(A-component)
Pail	25 litres	(A-component)
Pail	25 litres	(B-component)
PE cartridge	1 litre	(B-component)
2K set is consisting of:		
Foil wrap	500 ml	(A-component)
PE-tube	35 ml	(B-component)

### Technical properties:

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<b>DINITROL 515 A</b>	reactive polyurethane
Appearance:	black paste
Density:	1.17 g/cm <sup>3</sup>
<b>DINITROL 515 B</b>	Accelerating paste
Appearance:	white paste
Density:	1.45 g/cm <sup>3</sup> ± 0.5
Mixing ratio (p.b.v.):	100 : 2 to 100 : 5 (515 A : 515 B) (V/V)
<b>DINITROL 515 A / 515 B</b>	
Sag resistance:	very good
Open time:	up to 30 minutes
Application temperature:	10°C – 40°C
Shore A hardness (DIN 53505):	approx. 50
Tensile strength (DIN 53504):	approx. 8 MPa
Elongation at break (DIN 53504):	approx. 600%
Tear strength (DIN 53515):	approx. 10 N/mm
Lap-shear-strength (DIN EN 1465):	approx. 5 - 7 MPa
G-modulus (DIN 54451):	approx. 1.3 MPa
Volume resistivity (DIN 60093):	approx. 10 <sup>6</sup> Ωcm
Glass transition temperature:	approx. -50°C
Temperature resistant:	
long-term:	< 90°C
short-term (approx. 1h):	< 130°C
Shelf life:	PE-cartridges 9 Monate Pails 9 Monate Foil wraps 12 Monate

<sup>1)</sup> 23°C / 50% rf

Health and safety information can be obtained from the material safety data sheet and the product label.

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