

TECHNICAL DATA SHEET – FEBRUARY 2023



MK 0130 N

One-component adhesive | sealant hygro-hardening polyurethane-based, with very high modulus, of high quality. Windshield bonding of cars (replacement or original equipment), buses and agricultural vehicles.

TECHNOLOGY	POLYURETHANE
SKIN TIME	25 ÷ 40 MIN.
HARDNESS	65 A
APPROVALS	FMVSS 212

LIQUID PROPERTIES

DATA

Technology	Polyurethane
Colour	Black
Consistency	Thixotropic paste
Density @ 23°C	1.230 ± 0.05 g/ml
Viscosity @ 23°C	> 300.000 mPa.s
Application Temperature	+5 ÷ +35°C

ADHESIVE BEAD PROPERTIES | MECHANICAL PERFORMANCE

Skin Time [T° @ 23°C & 50 % R.H. adhesive mass @ 10 grams]	25 ÷ 40 minutes
Polymerization Time [T° @ 23°C bond-line Thickness @ 2,56 mm Target ≥ 0.40 MPa]	4.0 mm / 24 h
Accessibility	6 ÷ 12 h
Hardness Shore (DIN 53505)	65 ± 2 A
Modulus at Break (DIN 53504)	7.50 ± 0,50 MPa
Elongation at Break (DIN 53504)	> 700 %
Tensile Strength (DIN 53504)	3.5 ÷ 4.0 MPa
Tear Strength	Approx. 30 N/mm
U.V. Resistance	ok by Primer
Water and Salt spray Resistance	Excellent
Operating Temperature	- 40 ÷ + 95 °C

Approvals

Pass crash test with dual security airbags
after 1 h @ 23 ° C and 50% relative humidity
FMVSS 212 standard

MASTIKOL SRL

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PROFESSIONAL BONDING SOLUTION



APPLICATION

- Before proceeding with bonding, prepare the substrates (see paragraph "recommendations").
- Fast and efficient solution for bonding windshields in the automotive manufacturing, especially where the necessity to move the assembly is immediate. Before proceeding with bonding, it is recommended to clean the windshield with MK ACTIVATOR to remove all silicone residues or other contaminants, then sand (to overcome the "orange peel" effect that could occur in the presence of residues of silicone). Repeat the degreasing operation a second time. Allow to dry for 10 minutes and then apply a thin and uniform layer of PRIMER MK 2001 with an applicator pad (or a 10ml tube with a disposable sponge applicator) to form a homogeneous film. Mix the primer well before using it.
- If packaged in a bottle: shake it thoroughly until the ball of the agitator moves, then shake for another 30 seconds
- If packaged in 10ml tubes: shake thoroughly for 10-15 seconds.
- Close the bottle immediately after use. Any contact of the primer with humidity causes it to harden. Consume the product within 24/48 hours after opening.
- Observe a drying time of 15 to 60 minutes depending on the temperature before applying the sealant. In the event that this time is exceeded, the application of the sealant can be carried out within a maximum of 24 hours, provided that the substrate is not contaminated (dust, grease, silicone).
- It can be extruded with a manual or pneumatic dispenser at a temperature between + 5 ° C and + 35 ° C.
- The speed of application can be improved if the product is slightly heated or by adding humidity. The triangular shape of the joint is determined by the shape of the nozzle. The windshield must be applied and pressed before the product has formed its skin i.e., within 40 min.

PROPERTIES AND USES

- MK 0130 N is intended for bonding windshields and side windows on vehicles with or without airbags in the automotive industry.
- Seals and joins different parts in the industry. Used in the car industry, containers, caravans, railway carriages, boats, ventilation and air conditioning systems, gluing mirrors, glass and for various applications in the nautical sector.
- Bonding and elastic sealing for bus, caravan, truck and train structures.
- Passes the crash test after 1 h standard FMVSS 212
- Its high thixotropy facilitates application on uneven surfaces (it does not sag).
- Good resistance to acids and bases and hydrocarbon solvents.

RECOMMENDATIONS

Substrate preparation

The substrates must be thoroughly clean, dry and free of oil, grease and dust which can certainly affect the quality of the bonding. Best cleaning by use of isopropyl alcohol MK-WIPES, MK Sol-Neo or MK Sol-13 in accordance with local regulations. Degrease the PVC and metal surfaces with a non-greasy solvent. Always check the compatibility of your solvents with the substrate to be bonded. If necessary, slightly sand or strongly abrade the surfaces to be bonded.

PRECAUTIONS FOR USE

Mastikol® products should be used following the normally precautions adopted during chemical substances handling. It is recommended to wear rubber or latex gloves and to protect the eyes adequately. Thoroughly clean the skin at the end of the work shift with warm soapy water. The use of solvents is not recommended. Dry yourself with paper wipes. It is recommended to ventilate the work area well. These precautions are detailed in the Safety Data Sheets relating to the individual products and should be referred to for a complete information.

STORAGE AND PACKAGING

It can be stored for nine months in the original and sealed containers kept in a cool and dry environment. Storage temperatures must be between 11°C and 23°C. Prolonged storage at a temperature above 23°C will reduce shelf life and the expiration date. Avoid direct contact with sunlight.

Cartridge 300 ml | Sausage 600 ml

20 LT Pails | 200 LT Drums for industrial dispenser.

NOTES

The information, in particular, the recommendations relating to the applications and use of Mastikol® products, are given in good faith and are based on current knowledge and experience of the products, when properly stored, handled and applied under normal conditions. Mastikol® assumes no responsibility for the results obtained by third parties for which there is no control over the method.

It is the customer's responsibility to confirm the suitability of the product for the application. As it is not possible to control the application, use or processing of the products; no liability is assumed in this regard. The customer must ensure that the use of the products does not infringe any third party intellectual property rights. Specifically, Mastikol® disclaims all express or implied warranties, including warranties of merchantability or fitness for specific purposes, arising from the sale or use of Mastikol® products. No liability is accepted for consequential or incidental damages of any kind, including loss of profit.

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