



## MK HS 302 TR

One-component, high quality, medium modulus, MS (Modified Polymer) based adhesive | sealant. Formulation isocyanates, solvents and PVC free. Adhesive in Transparent colour.

### TECHNICAL DATA SHEET – FEBRUARY 2023

TECHNOLOGY	MS POLYMER
SKIN TIME	10 ÷ 15 MIN.
HARDNESS	45 A
APPROVALS	ISEGA FOOD APPROVAL

### LIQUID PROPERTIES

### DATA

Technology	Terminated Silane Polymer
Colour	Transparent
Consistency	Thixotropic paste
Density @ 23°C	1.069 ± 0.05 g/ml
Viscosity @ 23°C	> 250.000 mPa.s
Application Temperature	+5 ÷ +35°C

### ADHESIVE BEAD PROPERTIES | MECHANICAL PERFORMANCE

Skin Time [ T° @ 23°C & 50 % R.H.   adhesive mass @ 10 grams]	10 ÷ 15 minutes
Polymerization Time [ T° @ 23°C   bond-line Thickness @ 2,56 mm   Target ≥ 0.40 MPa]	2.5 mm / 24 h
Accessibility	6 ÷ 12 h
Hardness Shore (DIN 53505)	45 ± 2 A
Modulus at Break (DIN 53504)	1.15 ± 0,50 MPa
Elongation at Break (DIN 53504)	>250 %
Tensile Strength (DIN 53504)	2.5 ÷ 3.0 MPa
Resistance to diluted acids and bases	Medium
Resistance to solvents, hydrocarbons	Good
U.V. Resistance	Excellent
Operating Temperature	- 40 ÷ + 90 °C
Approvals	EN 15651-1: F-INT ISEGA FOOD APPROVAL



## APPLICATION

- Before proceeding with bonding, prepare the substrates (see paragraph "recommendations").
- Apply the adhesive on one of the two surfaces to be bonded and assemble the components with great care.
- Remove excess glue before it cures.
- Allow the adhesive to react for the time necessary for it to develop sufficient resistance to handling.
- Notes for the user: The open time is the period of time for the positioning of the parts to be assembled after applying the adhesive and which guarantees good surface wettability. The fixing time is instead the minimum time required to reach an overlap shear strength  $\geq 0.40$  MPa. The volume of the adhesive and the application temperature have a direct effect on the open time by accelerating or slowing down the exothermic reaction. High temperatures and high volumes speed up the fixing reaction, low temperatures and thin layers of adhesive slow down this process.
- Good paintability with acrylic dispersion paints. The adhesion of the paint on the adhesive is subject to the composition of the paint itself, before painting it is advisable to carry out tests

## PROPERTIES AND USES

- Sealant for joints not subject to expansion, car parks, concrete, stone, porous and non-porous materials such as: polycarbonate, PS, PU, PVC, ceramic tiles, roofing in copper, zinc, aluminium, stainless steel, wood and glass.
- 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.
- Bonding of bus, truck and train ceilings.
- It is also suitable for bonding dissimilar metals in the trailer sector
- Used for crack repair and fill.
- Bonding of flooring systems.
- Excellent resistance to fatigue, shocks and loads.
- 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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**PROFESSIONAL BONDING SOLUTION**

