

TECHNICAL INFORMATION  
2-K ADHESIVE



## 2-K ADHESIVE

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### Important Information:

Please consider our General Terms and Conditions and the general notes of the Technical Information Sheet! No liability is accepted for any errors! The information is provided to our best knowledge and experience. This information is, however, no warranty for any properties of the material. We provide this information without obligation, also regarding the rights of third parties. The user has to make sure that the material is appropriate for the respective application.

## 1 Main characteristics / Fields of applications

- Used for mounting of tactile markings for the guidance of visually handicapped pedestrians;
- A cold plastic product based on methyl methacrylate resins (MMA).  
The curing is achieved by mixing with organic peroxides;
- Suitable for bituminous surfaces (e. g. mastic asphalt, asphaltic concrete) and also concrete pavements (priming required).
- For outdoor and indoor use

## 2 Technical Data

<b>Colour</b>	White, other colours upon request.	
<b>Specific weight</b>	1,6 – 1,8 kg/l	
<b>Mixing ratio</b>	100 : 1 with solid hardener Attention: In order to ensure a proper chemical reaction, the weight% of the hardener quantities must not fall short of 0.5 or exceed 2.	
<b>Curing time</b>	Depends on the climatic conditions (cf. "Table Pot-life/ Curing time"! ) The markings generally have to be checked for overroll-ability before being open to traffic.	
<b>Pot-life</b>	10 – 15 min. (depending on hardener quantity added and air, material, and surface temperatures; cf. "Table Pot-life/ Curing Time"!)	
<b>Storage stability</b>	6 months When unmixed in sealed original packaging, sheltered from frost and direct sun exposure!	
<b>Standard packaging</b>	2-K ADHESIVE – Tin container with 5 or 10 kg content Solid hardener – Plastic bags of 100 g filling weight	
<b>Identification</b>	Attention: The hardeners used for cold plastic are organic peroxides. They must be packaged, transported and stored separately from the cold plastic material. The regulations and instructions concerning appropriate transport, handling, storage, first aid measures, toxicology and ecology are stated in detail in our material safety data sheets! The Instructions stated on the product label and in the material safety Data Sheet must be followed.	
<b>Air temperature</b>	5 °C – 40 °C	
<b>Surface temperature</b>	5 °C – 45 °C	
<b>Relative humidity</b>	Below 75 % and below dew point (consult dew point table)	
<b>Layer thickness / Theoretical consumption</b>	The actual consumption depends on the applied layer thickness and the type and state of the surface, with the following to be used as guidelines:	
	<b>Wet film build</b> 2000 – 2500 µm	<b>Theoretical consumption</b> 3 – 4 kg/m <sup>2</sup>

## 3 Processing Instructions

### 3.1 Preparation of 2-K ADHESIVE

2-K ADHESIVE must be homogeneously stirred in its original container before processing! Then the hardener is mixed with the base component (2-K ADHESIVE) at the indicated mixing ratio while using an appropriate stirring device. Never prepare more material with hardener than is needed for the application (observe pot-life). Pot-life and curing times may be strongly influenced by material, ambient and surface temperatures. High temperatures reduce pot-life and curing times, low temperatures will prolong them. It is possible to influence the reaction time to a certain extent by altering the hardener quantity. Based on the usual addition of 1 % hardener, the table "Pot-life/Curing times in relation to material and surface temperatures" indicates several reaction times as influenced by hardener quantity and temperature.

### 3.2 Pot-life and curing times of 2-K ADHESIVE depending on material and surface temperatures

Temperature °C	Solid hardener quantity (weight %)	Potlife (minutes)	Curing time (minutes)
0	2	16	30
5	2	14	27
10	2	12	26
15	2	10	25
20	1	15	25
25	1	10	20
30	1	6	16
30	0,5	14	23
40	0,5	12	22
45	0,5	10	20

### 3.3 Thinner

Attention: 2-K ADHESIVE must be processed without adding thinner.

### 3.4 Cleaning of equipment

Cleaning must be done before the complete curing of the material by using special cleaner for marking machines. (Art. No.: 3086).

## 4 Surface pretreatment

### 4.1 General information

The surface must be dry, clean, and free from grease, oil and loose gravel and other contaminations. The surface must be checked for their carrying capacity and old markings should be removed with appropriate mechanical procedures.

### 4.2 Concrete /concrete-bound surfaces

The pavement components in new surfaces that prevent good bonding (fine mortar layer, concrete slurries) must be appropriately removed (e.g. with high pressure waterjet, fine millcut, or similarly effective methods). Before applying 2-K ADHESIVE, the concrete or concrete-bound surfaces must be treated with primers (2-component EP-primer Art.-No.: 8609000 or 2-component primer B71 for concrete Art.-No.: 8010). This also prevents the formation of bubbles which is likely to occur with non-primed applications on concrete. A sufficient covering of the concrete surface with primer is essential to attain an optimal bond between adhesive and concrete. Primer consumption may vary depending on the concrete porosity. The humidity of the concrete must not exceed 4 % when applying the marking.

### 4.3 Bituminous surfaces

Any loose components such as chippings must be removed.

## 5 Application procedure

1. Use templates or adhesive tapes to improve the formation of sharp edges and borders of the markings
2. Apply 2-K ADHESIVE manually with screed box, trowel, spatula/spatula with teeth. Adhesive must be applied so as to obtain a 100 % coverage on the back of the tactile marking.
3. Put the tactile marking on the adhesive fresh layer and press gently.
4. Remove templates or adhesive tapes before final curing of adhesive.
5. Check for overroll-ability before being open to traffic.

**NOTE:** *All this information regarding the performance and use of the product have a general character, therefore we recommend the testing of the product 2-K ADHESIVE in the specific conditions of the beneficiary.*

*Please contact the producer for further information.*

*The decision regarding the utilization of the product 2-K ADHESIVE is exclusive of the user.*