

DINITROL 505 FC-HM Plus

1-component polyurethan windscreen adhesive, high modulus, safe & quick

DINITROL 505 FC-HM PLUS is a 1-component, humidity curing, solvent free polyurethane adhesive. Cures to a high elastic, weather and ageing resistant bonding product for the replacement of automotive glasses.



- » Solvent & PVC-free
- » Good decking
- » Short cut-off string
- » Fast curing, short drive away times
- » Good non sag properties
- » High shear modulus, which increases the stiffness of the car body



Equipment

FOIL-WRAP TOOL PN 400 ml

Art. No. 1703000

MILWAUKEE TOOL 18V WIRELESS 1-P

Art. No. 1731900

MILWAUKEE TOOL 600 ML ADD-ON SET 1-P

Art. No. 1732000

INDUSTRIAL NITRILE GLOVES XL 10-P

Art. No. 1734100

DINITROL 505 FC-HM PLUS

Art. No.	Size	Package	Color	Art. No.	Size	Package	Color
12647	310 ml	Cartridge	Black	12664	400 ml	Foilwrap	Black
				12665	600 ml	Foilwrap	Black

a brand of



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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 misuse of our products. Therefore, a contractual legal relationship is not justified, and there are no secondary obligations arising from any purchase contracts.

DINITROL 505 FC-HM PLUS

Technical Details

Characteristics

DINITROL 505 FCHM Plus is a 1-component, humidity curing, solvent free polyurethane adhesive, cures to a high elastic rubber and weather- and ageing resistant bonding product for the direct glazing of automotive glasses.

In combination with the 1 step adhesion promoter DINITROL 525 PLUS, the adhesive can be applied after a short flash of time. By doing this, the working times per windscreen are significantly reduced.

Features

- High shear modules, which increases the stiffness of the car body
- Good decking
- Fast curing, short drive away times
- Black primerless, with the one step adhesion promoter
- Short cut-off string
- Good non sag properties
- Solvent & PVC free
- Low odour

Method of use

The application is done by extrusion out of foil wraps, hobbocks or cartridges. The recommended application temperature is 10 – 40°C. For uniform extrusion rates and application conditions, the application temperature of the adhesive has to be kept constant. This product is only suitable for experienced users. Preliminary tests are recommended.

Transport / Storage

Stored between 0° and 35°C (32 and 95°F) in closed packaging. During transport the storage temperature may shortly (2 – 4 days) go below or above these limits. When this happens, the material has to be acclimatized at room temperature before application: Packed cartridges & foil wraps need 1 – 2 days. Single cartridges need 3 – 4 hours. Cold single-cartridges may be stored for 1 – 2 hours at slightly increased temperatures up to 50°C (122°F).

Technical Data

Chemical base	reactive polyurethane prepolymer
Colour	black
Consistency	paste
Viscosity (23°C) (4mm / 4 bar) ¹	19 – 25 g/min (4 mm / 4 bar)
Density (DIN 53217-4)	1'180 – 1'250 kg/l
Skin formation time ¹	approx. 15 min
Curing rate after 24h ¹	3 – 4 mm (23°C / 50% r.h.)
Shore A Hardness (DIN 53505)	68
Tensile strength (DIN 53504)	approx. 9 MPa
Elongation at break (DIN 53504)	> 250 %
Tensile shear strength (DIN EN 1465) ¹	> 3.5 MPa (23°C / 50% r.h.)
Shear modulus ¹ (10% gliding):	2.5 – 3.5 MPa
Temperature resistance	< 80°C short-term (approx. 1 h): < 120°C
Shelf life (Storage <25°C)	Cartridges / Foilwraps: 12 months
Safe-Drive-Away-Time ¹ (FMVSS 212/208)	without airbag: 1 hour with passenger airbags: 1 hour
Available in	310 ml cartridge, 400 ml foil-wrap

1) 23°C / 50% rf

For all relevant safety advices please read the material safety data sheet or the packaging label.