

1. CHEMICAL COMPOSITION

Prepolymer based on diphenylmethane diisocyanate (MDI)

2. TECHNICAL REQUIREMENTS

NCO group content, % (m/m)	7.0 – 8.0 (PN-EN 1242:2013-06)
Dynamic viscosity at 25°C, mPa·s	2000 – 3500 (ASTM D4878-23, met. A)
Appearance at 25°C	liquid, light yellow to amber

3. INFORMATIVE DATA**

Density at temp. 25°C, g/ml	1.05 – 1.08
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**This information data does not constitute technical requirements and cannot be the basis for a complaint.

4. APPLICATION

One-component polyurethane adhesive with good joint stiffness and maintained flexibility. Does not contain volatile organic solvents.

ACTIVE PLAY AS H 8027 is used for the production of cold and hot molded elements from SBR or EPDM rubber granulates. Before use, the rubber granulate should be moistened with prepolymer and then placed in a mold so that the product hardens during the pressure of the press under the influence of temperature and humidity. The properties of the molded element, for example plates, depend on the size and composition of the rubber granulate and the amount of one-component polyurethane adhesive. In the case of a molded process it also depends on the degree of compression during curing. ACTIVE PLAY AS H 8027 is used to produce, among others: weights and similar products made of SBR and EPDM rubber granulates.

5. RECOMMENDED PROCESSING CONDITIONS

Adhesive consumption is from 7 to 15 % depending on the amount of granulate and the SBR or EPDM fraction used. Most often, the process of curing the ACTIVE PLAY AS H 8027 adhesive in molded applications is carried out „hot” at higher temperatures ranging from 70 to 150°C depending on the technology used. Higher temperatures and humidity shorten the curing time, but too high temperature can lead to the formation of brittle parts. In order to obtain better color stability, curing technology should be used at a lower temperature and with a higher moisture content by adding an appropriate amount of water to the rubber granulate at the stage of mixing it with a one-component adhesive. The molding time depends on the temperature of the mold and the humidity of the granulates. Water, catalyst or solutions of both can be used to speed up the curing process. Rubber granulate for example SBR or EPDM should be thoroughly mixed with the adhesive in a suitable mixer. The quality of the application depends on the right choice of granulate. Make sure that the rubber granulate is fully compatible with the adhesive. The use of inappropriate granulate will limit or even prevent the curing of the adhesive. The application properties depend on the particle size of the rubber granulate (fraction), the composition and quantity of the one-component polyurethane adhesive and in the case of molding process also on the degree of compression during curing.

6. ATTENTIONS

Polyurethane adhesives are formed from aromatic isocyanates based on diphenylmethane diisocyanate (MDI), which contain an unsaturated (aromatic) bond structure. Their film is not resistant to UV light and may cause color change when using light colors of EPDM granules. This behavior is typical of all adhesives of this type. Note that EPDM granulate also affect color stability.

7. PACKAGING

ACTIVE PLY AS H 8027 is delivered in metal drums of 216 l, IBC containers of 1000 l. At the customer's request, we can deliver the product in different quantities and packaging.

8. STORAGE

Store in a dry room at a temperature from 18°C to 28°C. Protect against moisture, direct sunlight and frost. The product should be stored in tightly closed containers. ACTIVE PLAY AS H 8027 reacts with moisture in the air. It is recommended to close containers tightly after use. Use the product as soon as possible after opening container.

9. EXPIRATION DATE

The shelf life in the manufacturer's original sealed packaging, stored under recommended conditions, is 6 months from the date of production.

10. TRANSPORT

Product may be transported at temperatures above 10°C. In case of lower external temperatures, product in barrels and containers is shipped in isotherms maintaining the delivery temperature from 18 to 25°C.

ADR/RID, IMDG, ICAO/IATA transport regulations do not apply to the transport of this product.

11. CLASSIFICATION AND LABELLING

This technical specification is only valid in conjunction with the current product safety data sheet. Any updates to safety-relevant information, in accordance with statutory requirements, will only be incorporated into the product safety data sheet.

The information contained in this document is given in good faith, based on our current knowledge and experience. The right is reserved to make changes to the Technical Specifications as a result of technological progress and product improvement by the manufacturer. The product is intended for the purposes described in this technical specification, for industrial use and by professionals. If the Buyer wishes to use the product for purposes other than those indicated herein, the Buyer should contact PCC Rokita for consultation. We are not responsible for the manner and purpose of using our products, technical assistance and information provided (whether verbal, written or in the form of production assessments), including in the form of proposed studies and recommendations. It is therefore essential to test our products, assess the level of technical support and information provided in terms of your own needs and your own production, and check that our products, technical support and information provided are applicable and can be used in the intended applications. This analysis, adapted to the conditions of use of the product, should at least take into account the conducting of application tests and the appropriateness of the proposed solutions from a technical point of view, taking into account safety requirements, health issues and environmental protection. Unless otherwise stated in writing, our products are offered in accordance with the company's standard terms and conditions of sale made available on the website. All information, including that of a technical support nature, is provided without warranty of any kind and is subject to change without notice. The parties expressly agree that the Customer accepts and expressly releases us from any liability in tort, contract or otherwise for events arising in connection with the use of our goods as well as information and support. Any statements and recommendations not included in this document are unlawful and non-binding. Nothing in this document shall be construed as a recommendation to use the products in a manner contrary to the patent claims for materials or methods of use.