

1. PRODUCT DESCRIPTION

EKOPRODUR 1331B2 is a two-component polyurethane adhesive system for panel production.

POLY ingredient (polyol mixture).	EKOPRODUR 1331B2 POLY
ISO ingredient (isocyanate)	ISO KOMPONENT B

2. APPLICATION

EKOPRODUR 1331B2 is designed for bonding painted sheet metal with polystyrene, polyurethane or mineral wool panels on a continuous line.

3. COMPONENT CHARACTERISTICS

POLY CONSTITUTION - a formulated polyol mixture in the form of an oily liquid without suspension, straw to yellow in color.

ISO COMPOSITION - a mixture of aromatic polyisocyanates, mainly diphenylmethane diisocyanate. Brown-colored liquid, without suspended solids.

Parameter	POLY	ISO	Unit
Density at 20°C	1,11 ± 0,02	1,22 ± 0,02	g/cm ³
Viscosity at 20°C	400 ± 100	350 ± 100	mPa·s

4. FOAMING CHARACTERISTICS UNDER LABORATORY CONDITIONS

The reaction times and apparent density of the core were measured under laboratory conditions (at 20°C) with hand foaming in a laboratory vessel - stirring about 5000 rpm, stirring time about 10 s.

Parameter	Value	Unit
POLY:ISO component mixing ratio by weight	100 : 159	
Cream time	12 ± 2	s
Gel time	30 ± 3	s
Tack free time	37 ± 8	s
Apparent core density	31 ± 3	kg/m ³

5. RECOMMENDED PROCESSING CONDITIONS

The EKOPRODUR 1331B2 system can be processed manually or with low- and high-pressure foaming machines.

Parameter	Value	Unit
POLY:ISO component mixing ratio by weight	100 : 159	
Raw material temperature	18 - 22	°C
Ambient temperature	18 - 35	°C
Sheet temperature	20 - 40	°C
Press temperature	30 - 50	°C

The surfaces to be glued should be prepared in advance. They should be free of dust, oil, loose fragments and other agents that can reduce the adhesion of the adhesive.

When processing the system, it is necessary to take into account the instructions and information contained in the Safety Data Sheets of the ingredients.

6. PROPERTIES OF FOAM

The following results were obtained for the finished insulation product obtained from EKOPRODUR 1331B2 system by the in-mold pouring method:

Parameter	Value	Unit	Standard
Apparent core density	≥ 40	kg/m ³	EN 1602

The foam acquires its full mechanical properties after 48 h of seasoning.

7. PACKAGES

Metal drums of 216 dm³, IBC container of 1000 dm³. It is possible to deliver in other packaging agreed with the recipient.

8. RECOMMENDED STORAGE CONDITIONS

Both components of the system should be stored in tightly closed packages in dry rooms with a temperature of 15 - 25°C. Protect from moisture and direct sunlight. The shelf life of the POLY component in original sealed manufacturer's packaging, stored under recommended conditions, is **3 MONTHS** from the date of manufacture. For special shipments, please contact directly with the relevant person in the logistics department for correct selection (other requirements for packaging).

9. REGULATIONS

- EKOPRODUR 1331B2 does not contain ozone-depleting foaming agents, in accordance with the European Union regulations on the marketing and use of controlled substances - Regulation (EC) No. 1005/2009 of September 16, 2009.
- Transport regulations apply in accordance with section 14 of the Product Safety Data Sheet.

10. ADDITIONAL INFORMATION

Please refer to the data sheet for both components of the system. The data contained in this technical information are based on the results of our laboratory tests and practical experience and do not constitute a guarantee of the properties of the final finished product. The results obtained may differ from those given when the product is used under conditions other than those assumed. Therefore, we recommend that you conduct your own tests to verify the suitability of the product for a given application. The use of the foam and the conditions of its application are not controlled by the manufacturer, the responsibility for their correct selection rests with the contractor. Guidelines for use of the system are contained in this document and in the Safety Data Sheets (SDS) of the individual components. Failure to comply with the conditions recommended by the manufacturer may adversely affect the processing of the system and the parameters of the finished product.

IMPORTANT: We are happy to provide technical and substantive assistance in the implementation and application of EKOPRODUR 1331B2 polyurethane system. At the same time, when necessary, we assist in the adjustment and selection of relevant parameters. For all matters related to the purchase and application of EKOPRODUR 1331B2 polyurethane system, we encourage you to contact your technical and sales representative directly or by writing to prodex@pcc.eu.