Technical Data Sheet

LOCTITE® UR 7228

May 2022

Product description

LOCTITE® UR 7228 provides the following product characteristics:

Technology	Polyurethane
Product type	PU adhesive
Cure	Humidity
Condition	Solvent free
Components	One component
Application	General assembly
Appearance	Brown

LOCTITE® UR 7228 is a solvent-free, moisture curing one-component adhesive based on polyurethane. At room temperature and the required humidity in the joint sufficient strength will be obtained after approximately 10 to 15 minutes.

For faster curing LOCTITE® UR 7228 can be cured in a heated press. Maximum temperature must not exceed 70 °C.

Application areas

LOCTITE® UR 7228 is used for the manufacture of sandwich elements with porous substrates (e.g. wood) which contain humidity. The substrates can be bonded to one another or to metals, laminated panels, various plastics, rigid foams made of polystyrene, polyurethane and others.

LOCTITE® UR 7228 is certified by UL.

LOCTITE® UR 7228 door adhesive for use with swinging - type fire doors of the hollow-metal steel stiffened and composite type doors, rated up to and including 3 hours.

Technical data

LOCTITE® UR 7228:

Consistency	liquid
Density (g/cm^3)	~1.15
Viscosity, Brookfield - RVT, 20°C, mPa.s * Henkel method 10	5500 - 10500
Open time , 23°C, 50% rh, min	7 - 9
Initial setting time, min	10 - 15
Final setting time, (23°C) , days	1
Consumption, g/m^2	100 - 200
Tensile shear strength at -40 °C, MPa	>7
Tensile shear strength at 20 °C, MPa	>6
Tensile shear strength at 80 °C, MPa EN 1465 (wood / wood bonding)	>3
Service temperature, °C	- 40 - 80
Short exposure (up to 1 h), °C	100

All technical data based on Henkel test method. Data with * are specified.

Direction for use

Preliminary statement

Prior to use it is necessary to read the **Safety Data Sheet** for information about precautionary measures and safety recommendations. Also, for chemical products exempt from compulsory labeling, the relevant precautions should always be observed. Please also refer to the local safety instructions and contact Henkel for analytical support.

Pretreatment

The substrate should be clean, dry, free of dust, oil, grease and other contaminants. The usage of suitable primers on metal surfaces can improve the adhesion and/or the long-term bond stability. The surface of plastic materials should be cleaned, so as to remove any kind of release agents present on the substrate surface. An improvement of the adhesion can be achieved by grinding or sandblasting the surface.

Application
Application temperature: 10 to 35 °C

LOCTITE® UR 7228 is applied to the substrate by spatula or doctor blade, but can also be applied by spraying or rolls.
When bonding substrates without sufficient humidity or which are not moisture permeable, the required amount of moisture has to be provided by other methods.
A proven procedure is the combined spraying of the adhesive simultaneously with water in a fine mist.
In the case of separate adhesive and water mist application, the water must not be sprayed onto the bare metal but on the other substrate or ideally on the adhesive.
Bonding surfaces should be brought together immediately after adhesive application, assuring sufficient contact pressure while curing, preferably in a press.
Since LOCTITE® UR 7228 cures by reaction with humidity, open containers must always be properly sealed and protected against moisture immediately after taking out the quantity needed.
For the same reason we recommend to use up opened containers as soon as possible.

Cleaning
Fresh, uncured material (cleaning application equipment, substrate contamination etc.) can be removed with LOCTITE® SF 8040; cured adhesive can only be removed mechanically.

Storage
When properly stored in a cool, dry location, with the container tightly closed when not in use, this product will have a shelf life of at least 9 months.

Recommended storage: 15 - 25 °C. Storage below 10 °C or greater than 50 °C can adversely affect product properties.

LOCTITE® UR 7228 is frost-sensitive.

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