

## PATTEX PL 250 Premium fix (white)

### DESCRIPTION

One-part and flexible, multipurpose assembly adhesive for indoor and outdoor applications based on Flextec®-Technology.

### FIELDS OF APPLICATION

- PL 250 is multiple-substrate compatible including Brick, Ceramic, Concrete, Hardboard, Plasterboard, Plywood, Stone, MDF, Wood, Metal, UPVC, Glass, Plastics\*, painted surfaces\*, Mirrors\*\*.
- All absorbent and non-absorbent substrates are suitable. Except PE, PP, PTFE, acrylic glass, plasticized PVC, copper and brass. With coated substrates, a check of product suitability or professional advice is recommended. Wet surfaces are possible if it has the possibility to dry. Not recommended for permanent water immersion.
- Seam seals in metallic and wooden construction (no movement)
- Seam seals in ventilation & air-conditioning ductwork (no movement)
- Gluing of natural stones (e.g. windowsill –seat made from marble, granite) is possible, if the natural stone has a thickness of min. 10 mm.

\*Pre-test to determine suitable bonding, because of many different substrates. The adhesion of PL 250 on polystyrene foam (Styrofoam) can be significantly improved, by precoat with diluted wood glue. Mix wood glue about 1:1 with water and spread onto the substrate. After drying of the precoat, PL 250 is ready to apply.

\*\*Use mirrors acc. DIN EN 1036-1, ask for technical advice for large-scale objects.

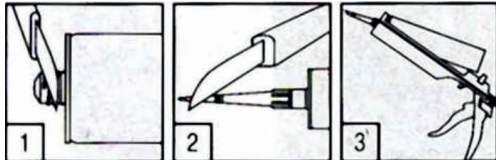


### MAIN BENEFITS

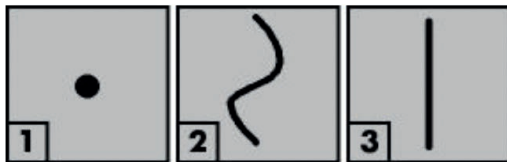
- Very high initial Tack of 350 kg/m<sup>2</sup>
- Correctable for a few minutes
- No stringing
- Moisture curing
- Non-slumping
- Interior and exterior use
- Multiple materials
- Sensitive materials
- Flexible bonding
- Porous- and non-porous surfaces
- Overpaintable and sandable once cured
- Isocyanate-free
- Solvent-free
- Gap-bridging
- Sound and vibration damping
- Weather and aging resistant
- Works on wet surfaces
- No shrinkage

## APPLICATION

Cut off tip of the cartridge above the screw thread (1). Screw on plastic nozzle and cut off the tip of the nozzle (2). Place cartridge into gun (3). Because of the very high tack formula, the product has a high resistance to extrude. Therefore, cut nozzle sufficient (min. 8mm diameter) or in a V-shape.



Apply adhesive onto the surface of one of the elements to be bonded: In spots (1) in order to smooth uneven surfaces, in wave-like form (2) for higher initial tack with large surfaces or in straight strands for smaller surfaces (3). In case of outdoor use, apply vertical strands.



Release gun after appliance to stop adhesive flow.

Use hand pressure to set the elements to be bonded into position. If necessary (e.g. heavy items and items under tension), use adhesive tape, wedges, or props to hold the assembled elements together for the initial hours (at least 24 hours) of curing. An incorrectly positioned element can be easily unfastened and repositioned in the first few minutes after application. Apply pressure again. Minimum thickness of the adhesive layer should be 1 mm to ensure ventilation.

### Important in case of 2 non-absorbent surfaces:

Adhesive must not form continuous areas as contact with air/moisture is necessary for adhesive setting. Make sure the adhesive strands do not merge!

### For filling applications:

Maximum joint width: 20mm.

Firmly extrude PL 250 into the gap and make sure that it is a full contact with the sides of the gap. Fill the gap and avoid air entrapment. Product should be tooled firmly against the gap sides to ensure good adhesion. After application, the product can be smoothed with soapy water (e.g. 5%-7% of Pril in water) before skinning.

Masking tape must be used where sharp exact lines or exceptionally neat lines are required. Remove the tape whilst the product has still not formed a skin. Use PL250 only for gaps/joints with no movement.

## SURFACES PREPARATION

The surfaces to be bonded must be clean, free from oils, grease, dust and loose particles and should be dry. Standing water on absorbent substrates should be first removed.

In case of soiled surfaces remove the soiling with an appropriate solvent or sand down surfaces and clean afterwards from dust. Before application, mask-off the adjacent area with foil or tape, if necessary. Check paint or coatings are firmly attached, if not remove it.

In cases of unknown materials or critical applications adhesions tests are recommended or contact our Technical Service.

Curing of the adhesive requires the intake of a small amount of moisture (either from the atmosphere and/or from the substrate).

## CLEANING OF TOOLS

Clean tools and application equipment immediately. Use water with plenty of soap, white spirit, ethanol, or other solvents for cleaning. The cured product can only be removed mechanically (e.g. with a knife or a scraper).

## AFTER CURING

When fully cured PL 250 can be painted, water-based acrylic paints are particularly suitable. We recommend pretest, because of the many different paints. Oxygen-curing paints (e.g. alkyd-resin) show longer drying/tackiness. 2K-Epoxy paints show bad levelling property.

## TECHNICAL DATA

### PL 250 Premium fix, uncured product

Raw material	Flextec®-Polymer (moisture curing silane-terminated polymer (STP))
Appearance	Off white
Odour	Mild, Alcohol
Application temperature:	+5°C to +40°C (substrate and ambient)
Consistency	Non-slumping paste
Density (ISO 2811-1)	~1,65 g/cm <sup>3</sup>
Skin formation time (23°C, 50% r. h.)	~10 minutes
Open time	~15 minutes
Curing speed (23°C, 50% r. h., bead 20x10mm)	~2 mm / 24 hours

### PL 250 Premium fix, uncured product

Initial tack	~35 g/cm <sup>2</sup>
Gap bridging capacity	Up to 20 mm
Shelf life	18 months

From date of production if stored in unopened original cartridges, in dry conditions and protected from direct sunlight at temperatures between +5°C and 25°C

### PL 250 Premium fix, cured product

Shore A hardness (ISO868)	~ 60
Modulus 100% (DIN 53504, S2)	~ 1,5 N/mm <sup>2</sup>
Elongation at break (DIN 53504, S2)	~ 100%
Tensile strength (DIN 53504, S2)	~ 1,6 N/mm <sup>2</sup>
Final Strength (DIN EN 205)	~ 2,0 N/mm <sup>2</sup> (lap-shear strength, wood/wood)
Service temperature	-30°C up to +80°C, 100°C for a short period
Coverage on flat surfaces	~ 300 g/m <sup>2</sup>
Shrinkage (ISO 10563)	~ -3%

## LIMITATIONS

It is recommended to test the compatibility of PL 250 in contact with painted surfaces or if PL 250 will be overpainted after application. Paints which crosslink in the presence of oxygen can show longer drying times, tackiness or discoloration, especially in case of alkyd resin paints. Do only paint over if product is fully cured.

Do not use PL 250 as a glazing sealant, on bituminous substrates or on building materials, which might bleed oils, plasticizer or solvents, which could attack the product.

Not suitable for applications with water pressure or permanent water immersion, e.g. in swimming pools below the water line, water pipes. Do not use PL 250 to seal bathtubs, washbasins or tiled walls/floors in bathrooms.

Product may only be used for mirror bonding if the mirror coating and the protective lacquer complies with EN 1036-1. In case of unknown mirror qualities and large projects, please ask mirror producer for an approval.

## SAFETY & DISPOSAL

Before using the product please see related Material Safety Data Sheet that is available on request.

## PACKAGING INFORMATION

Product Name	Packaging Size	Packaging Type	Pieces / Carton	IDH
Pattex PL 250 Premium fix White	440 g	Cartridge	12	2565441

## STORAGE AND SHELF LIFE

This product should be stored in dry conditions at temperatures between +10°C and 25°C. The product is not damaged by freezing but avoid high temperature-changing during storage.

**Shelf life: 18 months from manufacturing date.**