



The Glue People

Trade Grade Products Ltd
10 Victory Close
Woolsbridge Industrial Park
Three Legged Cross
Wimborne, Dorset, BH21 6SX

Tel 01202 820177
Fax 01202 814011

TradePUR EM400

Two part easy mix polyurethane adhesive.

General Description

A two-component polyurethane adhesive. The formulation has been designed to give ease of mixing for notched scraper applications.

This filled adhesive has been formulated for the bonding of uPVC laminates, timber based products, plastic coated metal sheets, and many other sheet materials. The material has thixotropic properties to avoid slump of adhesive while positioning laminates to be bonded.

EM 400 is ideally suited for repairing caravans where repositioning is required as EM400 will give a better 'slip' than most of this type of adhesive. E.g. where new panels are applied, then pushed up under a lip on an existing panel.

Application

Preparation

Surfaces must be clean, dry and free from any contaminants liable to impair adhesion. Metal surfaces such as galvanised steel and untreated aluminium may require the use of a primer in order to obtain a satisfactory bond. New build structures should be allowed to dry out for at least 6 weeks prior to application of EM400 and should then have a moisture content on the surface and in the core of less than 14%. Very porous substrates may be sealed with a dilution of PVA. Ensure that the PVA is completely dried out (at least 8 hours) prior to application of EM400.

All materials should be allowed to acclimatise for at least 24 hours before bonding. The sheeting, air temperature, and substrate should all be close to the final operational temperature of the building prior to application to avoid stresses from expansion of the plastic sheeting.

Method of application

TradePUR EM400 is supplied as a 6.5 kg pack. The mix ratio is 5.88 : 0.624 by weight. Normally, Part A is contained in a 5L bucket and part B in a 0.5L sachet. Once mixed the pot life is 30 minutes @ 20°C (Longer at lower temperatures.) and so substrate preparation should be complete before mixing. Add all of the part B to the part A and stir until a uniform colour is achieved ensuring that the sides are scraped down often during mixing. When mixed, apply the adhesive to one surface only. Apply to PVC sheet with a 6mm notched trowel and apply immediately to the substrate smoothing outwards from the centre. Flat plastered walls can have 4-5mm. Leave to cure for at least 4 to 6 hours before removing the protective film.

Bonding / Pressure range

Apply pressure as necessary to hold the substrates in contact until curing has occurred. Allow 4-6 hours for full cure (longer if temperatures are below 15°C). Mixed adhesive should be used within 30 minutes.

Coverage

For cladding walls with PVC sheeting, use 1 x 6.5Kg kit for every 2.5M² sheet. Use an 8Kg kit for 3m sheets.

Physical Data

Base	Polyurethane
Viscosity @ 20°C	Part A: Paste Part B: Low viscosity liquid
Specific gravity @ 20°C	Part A: 1.62 – 1.67 Part B: 1.21 – 1.24
Chemical resistance	Resistant to water, dilute acids and alkalis and aliphatic oils.
Solvents	None.
Flammability	N/A
Service temperature	-40°C to +130°C
Application temperature	Minimum +10°C Maximum +30°C
Storage life @ 25°C	12 months in unopened containers. Store between 5°C and 25°C.

Important Notice

Data contained in this document is for information only and is believed to be reliable. Trade Grade Products Ltd (TGP) cannot assume responsibility for results obtained by others over whose methods we have no control. It is the user's responsibility to determine suitability of the product for any specific purpose and TGP is pleased to provide a sample upon request.

Before using this product ensure that you have been supplied with and have read carefully the following information.

- The hazard label (complying with latest CDG/CPL regulations) applied to the container.
- Material Safety Data Sheets, TradePUR EM400 A and B.