



Soudapur Duo A2/15

Product description

SOUDAPUR DUO A2 is a solvent-free PU adhesive based on two components.

Component A is SOUDAPUR DUO A2, component B is SOUDAPUR DUO B7.

SOUDAPUR DUO A2 is available in four variants, SOUDAPUR DUO A2/15, SOUDAPUR DUO A2/30, SOUDAPUR DUO A2/45 and SOUDAPUR DUO A2/120 which differ in processing time and potlife. The result is a very strong and resistant bond. The product does not contain any abrasive fillers and is suitable to be applied by mixing and dispensing devices.

Properties

- Fast strength build-up
- Very high final strength
- Filling characteristics (foam formation), suitable for the bonding onto uneven surfaces
- Hard elastic adhesive layer
- Universal applications
- Professional quality
- Solvent free

Applications

- Production of sandwich panels.
- Bonding of different foam types like polyether, polyurethane, polystyrene. Bonding of metal foils, felt, textile, cork, both mutually as on paper, wood, cardboard, chipboard and metal.
- Bonding of various metals.
- Bonding of synthetic foam materials.
- Firm bonding of the most varying material combinations such as wood, metal, plastic, stone, etc.

Technical data

Base	Polyurethane
Consistency	Liquid
Curing system	Chemical curing
Component A density	Soudapur Duo A2/15: ca. 1,52 g/ml
Component A viscosity	Soudapur Duo A2/15: 8000 - 13000 mPa.s
Component B density	SOUDAPUR DUO B7: ca. 1,23 g/ml
Component B viscosity	SOUDAPUR DUO B7: 100 - 400 mPa.s
Mixing ratio by volume	A:B = 78,3 : 21,7
Mixing ratio by weight	A:B = 81,5 : 18,5
Mixture viscosity	Mixture A+B: 5000 - 9000 mPa.s
Potlife	Soudapur Duo A2/15: 11-16 minutes (mixture of 100g)
Can be loaded after	ca. 8 hours
Consumption	200-500 g/m ²
Shear strength	ca. 8 N/mm ² (after 24 hours)
Application temperature	+15°C → +35°C

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Temperature resistance

-40°C → +80°C

Footnote: Skinning time and curing speed may vary depending on environmental factors such as temperature, moisture, and type of substrates.

Substrates

- **Substrate condition**
solid, free from dust, oil, grease, sand and other contaminants
- **Substrate preparation**
The surfaces should be degreased before bonding them together. Roughening of surfaces prior to application of the adhesive is needed for sheet metals, hard plastics and smooth surfaces. Aluminum surfaces or foils should be roughened, primed or pre-treated chemically. This also applies for other metals. Remove releasing agents or protection films of metals and plastics.
- **Substrate types**
Soudapur Duo A2/15 has a good adhesion to following substrates: Many porous and non-porous substrates, all usual substrates for bonding. Soudapur Duo A2/15 has no good adhesion or is not suitable for PE, PP, PTFE (Teflon®), bituminous substrates. We recommend a preliminary adhesion and compatibility test on every surface.

Application method

- **Application method**
Before usage, component A should be mixed thoroughly. Both components should be dosed in the correct mixing ratio and mixed into a homogeneous mixture. The mixing ratio (A : B) of 81,5 : 18,5 by weight or 78,3 : 21,7 by volume must be respected. If the mixing ratio is changed, pot life and mechanical properties of the adhesive will be different. Consider the instructions of potential dosing equipments. Clamping the materials together during curing is required in order to achieve the highest possible final strength. The press pressure depends on the materials and must be determined by testing. In general, the pressure that makes the parts fit is sufficient. Do not move glued pieces during pressing. The curing can be further accelerated by using a heated press, we recommend not to exceed 70°C.
- **Cleaning method**
Soudal Industrial PU Cleaner 6300 can preferably be used to remove uncured polyurethane adhesives. Uncured adhesives can be removed with Soudal Swipex, Acetone or Isopropanol. Cured product can only be removed mechanically.
- **Repair method**
Repair with the same material.

Health- and Safety Recommendations

Take the usual labour hygiene into account. Consult the packaging label and safety data sheet for more information.

Packaging/Logistics

Colour: Grey

Packaging: SOUDAPUR DUO A2 in 5kg, 20kg, 300kg and 1000kg. SOUDAPUR DUO B7 in 1,15kg, 4,6kg, 25kg and 225kg.

Shelf life: At least 12 months in original, unopened packaging in a cool and dry storage place at temperatures between +5°C and +25°C.

Remarks

- Potlife and processing time depend on the room temperature, the temperature of both components, the temperature of the substrate and the mixing quantity. Lower temperatures and smaller quantities lead to longer potlife and open time.
- The bonding of materials with different expansion coefficients must be evaluated as to their long-term behaviour, especially when exposed to fluctuating temperature ranges.
- In case of expected chemical, thermal or water exposure, project related testing is strongly recommended.
- The final bond strength is achieved after 7 days.

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This technical data sheet replaces all previous versions. The directives contained in this documentation are the result of our experiments and of our experience and have been submitted in good faith. It is general in nature and does not constitute any liability. Because of the diversity of the materials and substrates and the great number of possible applications which are out of our control, we cannot accept any responsibility for the results obtained. Since the design, the quality of the substrate and processing conditions are beyond our control, no liability under this publication is accepted. It is the responsibility of the user to determine by his own tests whether the product is suitable for the application. In every case it is recommended to carry out preliminary experiments. The manufacturer reserves the right to modify products without prior notice.