



LOCTITE GT20 PURBOND

Formerly known as
PURBOND GT20

December 2014

LOCTITE® GT20 Purbond

Physical Form: Liquid
Color: White
Odor: Slight
Volatiles (%): Approx. 56%
Viscosity: Approx. 5,000 mPa.s @ 22°C
pH: Approx. 6.5
Freezing Point: <5°C
Specific Gravity: 1.15 (Water=1)
Minimum Film Form Temp: Approx 5°C

CURATIVE COMPONENT – LOCTITE® GT205 Purbond

Appearance: Yellow/Brown liquid
Viscosity: Approx. 75 mPa.s @ 22°C
Specific Gravity: Approx. 1.2 (Water=1)
Refer to LOCTITE® GT205 Purbond data sheet for specific storage and handling instructions of this curative.

SUGGESTED USES:

Recommended for use in load bearing engineered wood components. Used for finger jointing, edge gluing, and lamination. LOCTITE® GT20 with LOCTITE® GT205 can be cold pressed, hot pressed, or radio frequency (RF) cured.

CERTIFICATIONS AND REGISTRATIONS:

LOCTITE® GT20 with LOCTITE® GT205 (100:15 ratio) has passed third party accredited testing of the following test standards:

ASTM D2559 (Strength, de-lamination, & creep resistance)
ASTM D1151 (Exposure No. 3; Vacuum-soak-freeze)
ASTM D1183 (Condition D; Ocean water soak)
ASTM D7247 (High temperature exposure)
CSA O112.9 (Strength, de-lamination, & creep resistance)
ASTM E119 (ALSC Method A finger jointed stud fire wall)
CSA O177-06 A.2 (Small Scale Flame Test)

MIXING INSTRUCTIONS:

The pot life of this 2 part adhesive is relatively short, therefore the use of a meter mixing unit, just prior to application, is recommended. Consult your Henkel representative and equipment provider for suitable mixing equipment. The recommended mixing ratio is 100 parts base component to 15 parts curative by weight (100:15). For manual mixing, stir the adhesive during curative addition and continue mixing for 2-3 minutes to ensure a uniform mixture.

POT LIFE:

A mixed pail of adhesive remains useable, depending upon application viscosity limits, for approximately 40 minutes at room temperature at the 100:15 adhesive to curative ratio. Pot life will decrease with higher temperatures and curative addition levels. Clean up with

warm soapy water before adhesive cures. Dried adhesive film can be removed mechanically.

APPLICATION METHODS:

The mixed adhesive can be applied by glue spreader or extrusion. For low volume applications it is also possible to mix in a pail manually and apply by brush or roller.

COATING WEIGHT:

Smooth clean surfaces:
40-110lbs/1000sq.ft. depending upon temperature and required assembly time.

ASSEMBLY TIME:

Assembly time is a combination of the time adhesive coated wood components lay openly exposed (open assembly time), plus the time these same coated parts lay in a vertical or horizontal stack with no added pressure (closed assembly time).

Open Assembly Time: 3 min maximum at 40 lbs/1000sq.ft. Open assembly time is longer at higher application rates.

Closed assembly time is controllable based on adhesive coat weight and temperature. A table below shows coat weights at various temperatures, and how this affects the **total** of both open and closed assembly time.

Total Assembly Times for Different Application Rates									
Coat Weight (Lbs/1000sq.ft.)	Assembly Temperature	40 Lbs	50 Lbs	60 Lbs	70 Lbs	80 Lbs	90 Lbs	100 Lbs	110 Lbs
		60°F	30 min	40 min	55 min	75 min	95 min	120 min	140 min
		70°F	25 min	35 min	50 min	65 min	85 min	105 min	125 min
		80°F	20 min	30 min	45 min	60 min	75 min	95 min	115 min
		90°F	20 min	30 min	40 min	55 min	70 min	85 min	105 min

PRESS TIME:

This factor will vary with temperature, coating weight, substrates, construction and equipment (hot press, cold press, RF). Cold set press cycles can range from 1.5 to 2.5 hours for edge and face gluing.

Press cycles for finger jointing, hot press, and RF press are significantly faster and can be determined through in-plant testing. Consult your Henkel representative for recommendations.

Press time can vary with changes in moisture content of wood and plant conditions (temperature and relative humidity) and curative addition. Components can undergo further processing after the press time of the adhesive has elapsed.

Minimum Press Times for Different Application Rates									
Coat Weight (Lbs/1000sq.ft.)	40 lbs	50 lbs	60 lbs	70 lbs	80 lbs	90 lbs	100 lbs	110 lbs	
Press Time @60°F	105 min	116 min	124 min	132 min	138 min	143 min	148 min	153 min	

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PRESS FORCE:

For finger joints the press force is dependent on finger length, as well as profile, and should be adjusted to deliver tightly fitting joints in accordance with your certifying agencies requirements. For face and edge joints a press force of 150 psi or greater is recommended.

FINAL STRENGTH:

Strength suitable for in-plant durability testing is achieved after app. 24 hours. Glued components must be stored at a temperature of approximately 68°F (20°C) during this time.

WOOD MOISTURE CONTENT:

The wood moisture content at the joint surfaces to be glued should not be less than 8%. 12% moisture content is the optimal condition for this product. The permissible upper limit of wood moisture content as well as differences between pieces to be joined is governed by the respective national product standards (i.e. ANSI/AITC A190.1).

STORAGE, HANDLING AND PRECAUTIONS:

Rotate stock using oldest materials first. Keep covered to prevent contamination. Do not mix with other adhesives. Protect from freezing. Shelf Life: For best results, use within 6 months from manufacture date, in unopened containers. Maximum stability is obtained if the adhesive is stored between 5-16°C. Viscosity will increase with time in storage. Refer to Material Safety Data Sheet.

ENVIRONMENTAL IMPACT:

Unusable adhesive and wash water is classified as liquid industrial waste and must not be sewered or sent to municipal landfill, without pretreatment. Every effort should be made to use unwanted product for its original, or for a similar end use. Clean adhesive equipment with a high-pressure water spray to minimize water usage. Maximize re-use of adhesive wash water. Review local sewage disposal regulations to determine optimum method for effluent pretreatment. Dried adhesive, or adhesive sludge from treated and filtered wash water, can usually be disposed of as solid waste into municipal landfill. Where municipal programs allow, recycle plastic pails (with metal handles removed) by removing hardened adhesive, or by wiping clean. Steel drums can be reconditioned or recycled when empty, but must contain less than 2.5 cm of product on the bottom of the container. Some drums may contain a plastic liner which must be removed before a drum can be considered to be empty. Plastic liners may be disposed of in municipal waste streams if essentially free from adhesive, other than that which may cling to the

surface. Your Henkel representative can suggest methods to minimize adhesive usage to reduce impact on waste disposal and recycling streams.

Note

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