

Technical Datasheet

Bostik, Inc.



ISOSET™ MAX1020 Structural Polyurethane Polymer Adhesive

Description ISOSET MAX1020 is a one component polyurethane adhesive. It is designed to be used for structural wood bonding applications, including glued laminated timber (Glulam), cross-laminated timber (CLT), and Finger-Joints. The adhesive cures under the ambient humidity and moisture within the wood to form a strong, durable bond. The adhesive has fire resistance and shear thinning properties (viscosity will decrease with increasing shear).

Typical Physical Properties

Appearance	Viscous liquid
Color	Light brown as supplied, wood tone color after curing
Solids, %	100%, Solvent free
Viscosity, Brookfield, cps, spindle #5, 10 rpm, 72°F (22°C)	17,000 – 37,000
Flash Point (Seta)	>285°F (>141°C)
Density, lbs/gal	9.8 – 10.3
Rheology	Shear thinning behavior

Use Instructions Please refer to the ISOSET MAX lamination guide for complete instructions on adhesive handling and application. To ensure smooth adhesive flow during application, the storage area where the adhesive container is kept should be maintained at a minimum temperature of 60°F (16°C). The adhesive is typically applied at ambient temperatures. Curing at elevated temperature reduces the cure time significantly, while cooler conditions slow down the cure. Similarly, relative humidity and wood moisture content have an impact on adhesive cure rate. Bonded assemblies will gain the majority of strength within 24 hours; however, it can take up to 7 days for the adhesive to reach full strength. Specific cure cycles can be determined for specific applications. The wood moisture content at the bonded surfaces would be no less than 7%. The adhesive is designed to be used in combination with Bostik's ISOSET MAX300 primer. Freshly planed wood surface is treated with primer before the adhesive is applied. It is recommended to wait a minimum of 20 minutes between primer and adhesive application; however, process with in-line priming can also be set up with adjusted cure parameters. Please refer to the ISOSET MAX300 Primer technical datasheet for primer application guidelines.

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Working Life	Working life of the adhesive is dependent upon ambient conditions. ISOSET MAX1020 offers 20 minutes of working life at 70°F (21°C) and 50% RH (relative humidity).
Assembly Time & Press Time	The components to be glued must be assembled together and the press force applied within 20 minutes after the start of adhesive application for typical conditions (70°F, 50% RH, 12% wood moisture). The minimum recommended press time is 50 minutes under these conditions. It is normal for the adhesive to foam slightly during assembly.
Handling	When using ISOSET MAX1020 , avoid direct contact with skin and eyes. Always where appropriate protective equipment and clothing to ensure safety. For essential health, safety, and handling information, please refer to Bostik's Safety Data Sheet prior to using this product. It is crucial that all supervisory personnel and employees thoroughly read and understand the Safety Data Sheets before using any Bostik products in your facility.
Clean Up	ISOSET MAX1020 can be cleaned using dibasic ester solvent.
Packaging	330 gallon totes, 55 gallon (208 liter) coated steel drums, and 5 gallon (19 liter) pails.
Recommended Storage	When stored at temperatures between 45°F and 75°F (7°C and 24°C), the shelf life of this adhesive is six (6) months from the date of shipment to the customer. Storing at higher temperatures decreases shelf life. Keep away from heat, direct sunlight and rain. Keep containers closed to prevent contamination. The adhesive reacts with moisture; therefore, keep containers closed tightly when not in use. Once opened, use as soon as possible. Desiccant cartridges or nitrogen blankets are used to avoid moisture contamination.

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DOT Label
Requirements

None

Notice

All information presented herein is believed to be accurate and reliable, and is solely for the user's consideration, investigation and verification. The information is not to be taken as an express or implied representation or warranty for which Bostik, Inc. assumes legal responsibility. Any warranties, including warranties of merchantability, fitness for use or non-infringement of intellectual property rights of third parties, are herewith expressly excluded.

Since the user's product formulations, specific use applications and conditions of use are beyond the control of Bostik. Bostik makes no warranty or representation regarding the results which may be obtained by the user. It shall be the sole responsibility of the user to determine the suitability of any of the products mentioned for the user's specific application.

Bostik requests that the user reads, understands and complies with the information contained herein and the current Safety Data Sheet.

More Information

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