SPC-M230

Sandwich Panel Line Adhesive

Technical Data Sheet

Features & Benefits

- For continuous machine lines
- Second-scale reaction profile
- Speed matched to line rate
- Colour-steel EPS core panels
- Gap fill up to 5 mm
- Handling in 10-15 min
- Bulk drum supply

Description

SPC-M230 is a two-component polyurethane adhesive for continuous sandwich-panel production lines, especially colour-steel panels with an EPS core.

FOR INDUSTRIAL USE ONLY

Physical Properties of Uncured Adhesive

	SPC-M230 A	SPC-M230 B
Chemical composition	Blended Polyol	Polymeric MDI
Appearance	Light Yellow Homogeneous Liquid	Dark Brown Viscous Liquid
Viscosity @ 25 C	800 +/- 100 mPa.s (cP)	200 +/- 50 mPa.s (cP)
Mixing Ratio (W)	A:B = 1:1.1 / 1:1.25 / 2:1	

Typical Curing Properties

Cream time (20 C)	8-12 seconds
Gel time (20 C)	28-32 seconds
Cure time (20 C)	48-52 seconds
Handling time	10-15 min (steel)

Typical Performance of Cured Adhesive

Bond strength	0.1 MPa - EPS core failure
Handling strength (ISO 4587)	0.3 N/mm2 in 10-15 min
Maximum gap fill	5 mm (0.2 in)
Full cure	8-36 h depending on temperature
Density	1.5-1.8 g/cm3

*Bond strength 0.1 MPa corresponds to failure of the EPS core, not of the adhesive layer. Reaction speed is temperature sensitive - use a retarder at high ambient temperature and an accelerator at low temperature, and state the line temperature when ordering.

The information and recommendations herein are believed accurate, but no guarantee is made. Purchasers must test the product under their own operating conditions. Products are sold without warranty of merchantability or fitness for a particular purpose, express or implied.

FOR PROFESSIONAL OR INDUSTRIAL USE ONLY. KEEP OUT OF REACH OF CHILDREN

Additional Information

This product is not recommended for use in contact with strong oxidizing materials. It may affect some thermoplastics; users must check compatibility with such substrates.
Information regarding safe handling may be obtained from the Safety Data Sheet.
All materials should be handled in accordance with good industrial hygiene.

This Technical Datasheet (TDS) offers guideline information and does not constitute a specification.

Surface Preparation

Surfaces should be clean, dry and grease-free before applying the adhesive. Metals such as aluminium, copper and their alloys benefit from light abrasion to remove the oxide layer.

Directions for Use

1) Surfaces must be clean, dry and free of oil and dust.
2) Meter A:B at the specified ratio; calibrate the metering unit at least weekly.
3) Pour or spread onto the facing with the glue-spreading machine.
4) Close the panel and run it into the double-belt press.
5) Tune reaction speed to line speed and ambient temperature; state operating temperature when ordering.
6) Handling strength in 10-15 min; full cure in 8-36 h depending on temperature.

Video Links

EPS foam-to-metal panel bonding

https://www.youtube.com/watch?v=tdEDm6-z2yE

Continuous sandwich-panel line dispensing

https://www.youtube.com/watch?v=apDu54_RZKk

Storage & Packaging

(1) Store in a ventilated, water- and moisture-proof place.
(2) Packaging: component A 220 kg; component B 250 kg per steel drum.

APPLICATIONS



Colour-Steel EPS Panel



Continuous Panel Line

Construction Method

(1) Reaction speed is highly temperature-sensitive: higher temperature gives a faster reaction.

(2) At high ambient temperature, add a retarder; at low temperature, add an accelerator. Dose the additive into component A.

(3) Reaction speed can be matched to line speed. State the manufacturing temperature when enquiring; use the slow grade for distant customers or changeable climates.

The information and recommendations herein are believed accurate, but no guarantee is made. Purchasers must test the product under their own operating conditions. Products are sold without warranty of merchantability or fitness for a particular purpose, express or implied.

FOR PROFESSIONAL OR INDUSTRIAL USE ONLY. KEEP OUT OF REACH OF CHILDREN