

# Q PVC-adhesive

greenteQ PVC-adhesive for the fast gluing of hard PVC in construction

## Properties:

greenteQ PVC-adhesive is used in specialist companies in the following fields:

- Window construction: gluing of additional profiles such as window drips, drain and impact strips and roller shutter slats.
- Plumbing: gluing of pipes, gutters, etc.
- Exhibition display production: gluing of rigid foam boards made in hard PVC.

greenteQ PVC-adhesives offer good thermal resistivity and excellent UV resistance. greenteQ PVC-adhesive meets the weather resistance requirements for window construction following RAL guideline 716/1, part 1, section 3.2.5, which means that the adhesive does not yellow.

## Picture of product:



## Technical data:

Base:	Diffusion adhesive, vinyl chloride polymers in solvent
Colour of greenteQ PVC-adhesive (cured film)	white, transparent
Film properties of greenteQ PVC-adhesive (cured film)	tough hard, impact-resistant
Density (according to EN 542 at +20 °C)	approx. 0.99 g/cm <sup>3</sup>
Open time (at +20 °C, 50 % air humidity, application quantity 150 µm - glass)	approx. 60 s
Operating strength (gluing of stress-free strips)	approx. 2 to 4 min
Cure time (at +20 °C, 50 % air humidity; diffusion of the residual solvent might take up to 8 weeks)	approx. 24 h (~90 %)
Minimum working temperature	from +5 °C
Flash point	-14 °C
Autoignition temperature	+212 °C

## Surface preparation:

Before applying the adhesive, remove all dirt, grease, moisture and other residue from the adherend surfaces, preferably using greenteQ PVC-cleaner 20

or greenteQ PVC-cleaner 10. The cleaning cloths must be lint-free and non-colouring.

## Use instructions:

greenteQ PVC-adhesive is applied directly from the tube to one of the adherend surfaces (worm of glue). Join the parts to be glued together during the 'open time' (30 to max. 60 seconds) and press them together until the operating strength is reached. After 16 hours, the glued joint can be exposed to load; complete curing of the joint might take up to 8 weeks.

- For optimum fixture, we recommend always cleaning the adherend surfaces with a solvent-based cleaner of the greenteQ product range before applying the adhesive.
- When applying the adhesive, adjust the quantity to ensure that no adhesive escapes from the joint when the additional profiles are pressed together.

## PRODUCT DATA SHEET

greenteQ

ADHESIVES - PVC-adhesive

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Instructions for use, performance and product data, and all other technical data for greenteQ products are general guidelines only. They describe the performance characteristics and material composition of our products. However, they constitute no guarantee according to § 443 BGB. Due to the various application possibilities it is the user's sole responsibility to satisfy himself that the product is adequate for his intended purpose. Any technical consultation with VBH, whether verbal, written or in the form of test samples is for your information only and is absolutely non-committal.

## Use instructions:



The glued adhesive profiles must not be exposed to an increased temperature/direct sunlight ( $> +25\text{ }^{\circ}\text{C}$ ) for a period of 1 week. Otherwise, blisters might form in the acrylic layer!

### Application quantity for the gluing of strips:

Adherend surface width: 20 mm approx. 8 g/m  
Adherend surface width: 40 mm approx. 16 g/m

The open time and the required press time can only be determined by carrying out internal tests, as they vary greatly depending on the material, temperature,

application quantity, air humidity, moisture in material, adhesive film thickness, press pressure and other parameters. As a rule, add appropriate safety margins to the recommended values.

- Not suitable for the gluing of pressurised pipes.
- Diffusion adhesives cannot properly bridge gaps  $> 0.1\text{ mm}$ !
- When determining the application quantity, consider the thickness of the material, as adhesive might penetrate to the surface!

## Cleaning:



To clean utensils contaminated with not yet cured greenteQ PVC-adhesive, use greenteQ PVC-cleaner 10. To remove greenteQ PVC-adhesive from metal surfaces, simply peel off the hardened adhesive film, as the product does not

adhere to metal. To clean hard PVC profiles from greenteQ PVC-adhesive residue, let the adhesive dry and remove it with a scraper.

## Storage and delivery form:



Store in tight original container in a dry place at temperatures between  $+15\text{ }^{\circ}\text{C}$  and  $+25\text{ }^{\circ}\text{C}$  and protect against direct sunlight. Storability in sealed original container: 24 months; please note that the product becomes more viscous the

longer it is stored. Stir before application!  
Original container: 200 g aluminium membrane tube  
Shipping unit: Compartmented carton with 30 tubes or 50 tubes.

## Safety instructions:



See safety data sheet for greenteQ PVC-adhesive.

## Important notes:



greenteQ PVC-adhesive is not suitable for use on Renolit foil!

## General notes:



This product data sheet replaces all previous versions.