

**Description**

**TIC 5022S PU Adhesive** has strong Adhesion for attachment of Cellular Glass and Polyurethane, Polyisocyanurate that is two elements type of adhesive, which does not contain any flammable materials such as Solvent.

**TIC 5022S PU Adhesive** can be used for low temperature insulations system and joint sealant or adhesion for all Insulation materials including Polystyrene. This product is paint with Air spray for wide space in short time and drying time and pot life can be controlled by users for their convenience.

**TIC 5022S PU Adhesive** is designed for maintaining of its viscosity 10,000 - 20,000 to form most suitable film on Insulation Materials.

**TIC 5022S PU Adhesive** contains no asbestos, lead, mercury or mercury compounds.

**Properties**

Property	Specification	Test method
Color	Beige(part A, paste) / Brown(part B, liquid) / Beige(mixed)	TSTM-01
Application	Brush or airless spray	TSTM-06
Density	Part A - 1.45 ± 0.05 Kg/ℓ Part B - 1.22 ± 0.05 Kg/ℓ Mixed (A&B) - 1.40 ± 0.05 Kg/ℓ	ASTM D 1475
Volume non-volatile	99 ± 1 % (mixed)	ASTM D 1644
Weight non-volatile	99 ± 1 % (mixed)	ASTM D 1644
Coverage	2.83 Kg/m <sup>2</sup> (2.02 ℓ/m <sup>2</sup> ) Dried film thickness: 2.0 mm	TSTM-07
Mixing ratio	Weight - part A : part B = 4 : 1 Volume - part A : part B = 3.5 : 1	TSTM-16
Pot life	1 ~ 2 hours (25±2°C, 50±2% RH)	TSTM-09
Drying / curing time	Set to touch: 6 hours Dry through: 24 hours Curing time: 48 hours Maximum strength: 7 Days	ASTM D 1640
Service temperature limits	(Temperature at coated surface) -196 °C ~ 100 °C (-321 °F ~ 212 °F)	TSTM-04
Wet flammability	≥ 93 °C (200 °F)	ASTM D 3278
Lap shear strength	≥ 2.0 MPa	ISO 4587

**Limitations**

Store and apply between 4 °C (40 °F) and 38 °C (100 °F).

Pot life will be longer at lower temperatures, shorter at higher temperatures.

Part B is sensitive to moisture and humidity. Keep container tightly sealed when not in use.

Do not heat part A, part B, or the mixed material to above 38 °C (100 °F).

**Application**

**Material Preparation**

DO NOT THIN. Stirring should not be necessary, but if Part A has remained undisturbed for any extended period, stir well. Do not use sticks or paddles, which could splinter or otherwise contaminate the product.

Containers must be kept closed and in dry storage when not in use. Blend only the amount of material, which can apply in 1 hour. Mixing should be continued for 3 minutes maximum with a suitable air or electric mixer operating at low speed, until the TIC 5022S PU Adhesive is smooth and completely homogeneous. Do not over mix. Do not heat part A, part B, or the mixed material to above 38 °C (100 °F). Exposure to vapors of heated product may be harmful. Heated vapors are potential respiratory and skin sensitizers, and possible eye irritants. Provide adequate ventilation in enclosed areas.

**Application**

Apply only to clean dry surfaces. TIC 5022S PU Adhesive may apply to either or both surfaces at the recommended coverage rate. Surfaces must be bond within 1 hour after application of the adhesive. On rough surfaces, a thicker application of TIC 5022S PU Adhesive is required as necessary to assure complete contact between the insulation and the substrate.

**Clean-up**

Before adhesive cures, clean tools and equipment with chlorinated solvent (non-flammable) or mineral spirits (flammable). Dried TIC 5022S PU Adhesive is extremely difficult to remove.

**Note**

**Important:** We make no other warranties and expressly disclaim any warranties of merchantability or fitness for a particular purpose. If a product fails to meet this limited warranty, purchaser's sole and exclusive remedy is replacement of the product or, at our option, refund of the purchase price. Our acceptance of any orders for the product is expressly conditional upon purchaser's assent to the terms on the applicable invoice.

**Adequate Tests:** The information contained herein we believe is correct to the best of our knowledge and tests. The recommendations and suggestions herein are made without guarantee or representation as to results. We recommend that adequate tests be perform by you to determine if this product meets all of your requirements. The warranted shelf life of our products is six months from date of shipment to the original purchaser.

**TIC CORPORATION**

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