



Parabond 600

Elastic glue and adhesive with extremely high initial bonding

Product:

Parabond 600 is a high-quality, quickly drying, durable MS-Polymer based elastic glue and adhesive with a very high initial bonding.

Applications:

Parabond 600 has a very high initial strength and bonds without primer on almost all materials occurring in the building industry, such as aluminium, galvanized and stainless steel, zinc, copper, natural stone, concrete, brick, cement based cover sheeting, volkern, wood, gypsum, glass, glazing, various synthetic materials, etc. Extremely suitable for gluing and fitting of safety glass in the banking industry, fitting of cable ducts, mitres in aluminium windows, mirrors. It is suitable for use as universal glue and adhesive for sealing seams, connecting and movable joints. It is extremely suitable for the structural gluing of panels and elements in the professional facade, interior and ceiling construction. Welding or stamping is in most cases not necessary. Examples of applications are the vertical or horizontal gluing of:

- Wall cladding elements and ceiling panels (interior)
- Sound isolation panels (mineral wool, wood-wool cement, plastic foams)
- Thermal isolation panels (PUR, PIR, PS)
- Casings and frames in building construction
- Wooden and plastic laths, ornaments, frames
- Doorsteps, windowsills, skirting boards and cover plates
- Complete construction elements (such as roofing and facade elements) in frames

Parabond 600 should not be used with:

- Joints that are exposed to constant submersion under water
- Joints with a width or depth < 5 mm
- Swimming pools containing chlorine, with constant submersion under water
- Bitumen: use our Paraphalt for this purpose
- Polycarbonate and polyacrylate: Use our Parasilico PL for this purpose

Parabond 600 is not suitable for gluing PE, PP, PA, Teflon® and bitumen.

Proper ventilation during processing and during the hardening is important.

Properties:

- Sealing and gluing
- Extremely high initial bonding
- Rapid increase of internal strength
- Excellent bonding on most building materials
- Bonds with moist supports
- Solvent and isocyanide free
- Extremely strong
- Permanently elastic
- Does not cause any corrosion in metal joints
- For interior and exterior use
- UV and weather-resistant
- Suitable for use with natural stone
- Mould resistant
- Paintable with most water and solvent based paints. Is paintable wet on wet. After 48 hours, the surface must be cleaned first before it can be painted. Pre-testing is necessary. Alkyd paints require an extended drying time.

Processing:

Support: The support must be fixed and rigid enough. The support does not have to be completely dry (damp).

Pre-treatment: The materials to be glued must be clean, dust and grease free. If necessary, degrease using Top Cleaner, MEK, alcohol, or ethanol. For strongly absorbent supports, we recommend the use of DL-2001 Primer. It is advisable to do bonding tests. It is the user's responsibility to check whether the product is suitable for his application. Our technical department could be consulted, if necessary.

Application: Apply Parabond 600 with the supplied nozzle in strips or dots to the support or on the element to be bonded. The strips must be applied in vertical rows. The material can at this stage still be adjusted, just push it down well. For information regarding the mutual distances between the glue strips, refer to "adhesive quantities". DL Chemicals advises a gap of 3,2 mm between the parts to be bonded, to allow the glue to smooth out any distortions (especially important in exterior use or under humid conditions). To achieve this space, spacer blocks or pieces of foam tape with a thickness of 3,2 mm may be used. If the adhesive layer does not have to take up any, or only have to take up a slight mutual distortion between the construction parts, a thinner adhesive layer (at least 1,5 mm) will suffice (for example in interior applications).

Open time: Apply the part to be glued as quickly as possible, at the latest within 10 minutes (this depends on the temperature and relative humidity level). The material can at this stage still be adjusted, but then it should be pushed down well or tapped with a rubber hammer.

Cleaning: Any glue that may protrude along the edges can be removed using a stopping knife. Adhesive residue that has not yet dried, can be removed using Parasilico Cleaner, dried glue must be removed mechanically. If desired, smooth down using DL 100 or rubber stripper.

Drying time and strength:

Parabond 600 combines the benefits of a tape with that of a reactive adhesive system:

- During assembly, Parabond 600 has a high bonding capacity and a high internal strength. Thus it is possible to work without temporary supportive constructions or the glued construction parts can be moved directly or be processed further.

After drying under the influence of humidity, Parabond 600 vulcanizes into a permanently elastic and extremely strong adhesive connection.

Initially:

The internal strength of Parabond600 immediately after application is such that bonding is possible without clamping or temporary support:

Internal strength (immediately) > 0.0015 N/mm²

Strength per m² adhesive surface > 1500 N (> 150 kg)

After one hour, the strength has increased threefold:

Internal strength (after 60 minutes) > 0.0045 N/mm²

Strength per m² adhesive surface > 4500 N (> 450 kg)

After drying:

Parabond 600 dries into a durable elastic and extremely strong adhesive connection under the influence of humidity. The maximum tensile stress is > 1,5 N/mm², the shearing force amounts to 2-4 N/mm² depending on the glue construction. Refer to the Technical characteristics for additional information concerning the strength qualities.

Adhesive quantities, for the initial adhesion:

Parabond 600 is applied in the form of glue strips or dots. By applying the element to be glued, the glue distributes between the element and the support. The eventual surface of the adhesive layer determines the strength of the connection, both initially as well as after drying.

The relationship between the dimensions of the glue strip and the final adhesive surface is determined by the surface structure of the parts to be glued and obviously of the final thickness of the adhesive. Triangular glue strip of 9 mm wide and 9 mm high (app. 40 mm² in diameter) provides a glue width of 13 mm at a thickness of 3 mm on smooth materials. On uneven supports, the glue width at a minimum thickness of 3 mm will correspond with app. 10 mm. At a glue thickness of 1.5 mm, the widths are resp. 26 and app. 20 mm. Apply the strips parallel to each other, to allow the humidity to reach the glue between the strips. Assuming a standard triangular strip of 9 mm wide and 9 mm high and – after pressing together – glue thicknesses of 1.5 and 3 mm, the relationship as stated below can be established between strip distance and weight of the parts to be glued. Level glue surfaces were assumed. It is advised to carry out tests beforehand. With the gluing of bigger wall or ceiling elements, possible additional gravitational forces should be considered (e.g. because of bends in the panels).

Strength immediately after application:

Thickness of the adhesive 1.5 mm (on smooth support - width after applying pressure ca. 26 mm)

Strip-distance, immediately after 60 minutes per m²

10 cm	(adhesive surface 26% of the support)	370 N	37,0 kg	1110 N	111 kg
20 cm	(adhesive surface 13% of the support)	185 N	18.5 kg	555 N	55.5 kg
30 cm	(adhesive surface 9% of the support)	130 N	13.0 kg	390 N	39 kg
40 cm	(adhesive surface 6.5% of the support)	95 N	9.5 kg	285 N	28.5 kg

Thickness of the adhesive 3 mm (on smooth support - width after applying pressure ca. 13 mm)

Strip-distance, immediately after 60 minutes per m²

5 cm	(adhesive surface 26% of the support)	370 N	37.0 kg	1110 N	111 kg
10 cm	(adhesive surface 13% of the support)	185 N	18.5 kg.	555 N	55.5 kg.
20 cm	(adhesive surface 6.5% of the support)	95 N	9.5 kg.	285 N	28.5 kg.
30 cm	(adhesive surface 4.5% of the support)	67 N	6.7 kg	201 N	20.1 kg
40 cm	(adhesive surface 3% of the support)	45 N	4.5 kg	135 N	13.5 kg

When determining the number of strips, make sure that

- The internal cohesive forces of the parts to be glued are not exceeded (e.g. ceiling tiles based on mineral wool. With such materials, it is advisable to apply glue to the biggest possible surface.)
- Distribute the adhesive strips regularly over the surface to be glued.

Technical characteristics:

- Basic ingredient: MS-Polymer
- Drying system: By means of humidity
- Drying speed: 2,5 to 3 mm/24 hour at 23°C and 50% R.V.
- Number of components: 1
- Skin formation: 10 to 15 minutes at 23°C and 50% R.V.
- Density: ca. 1,56 ml.
- Shore A : 55 (+/- 5) (ISO-868)
- Maximum allowed distortion: 25%
- Module at 100% stretch: 1,300 N/mm² (ISO-8339-40)
- Module with breaking: 1,500 N/mm² (ISO-8339-40)
- % stretch with breakage: 230% (ISO-8339-40)
- Solvent quality: 0%
- Isocyanate quality: 0%
- Dry matter quality: ca. 100%
- Processing temperature of +5°C to +40°C, do not process below +5°C.
- Temperature stability -40°C to +90°C
- Moisture resistance: Extremely good
- Frost stability: not sensitive to frost



All advice, recommendations, figures and safety directives are based on careful research, as well as the current state of our experience and are free of charge. Although the documentation was compiled with the greatest care, we do not accept responsibility for incorrect information, mistakes, or printing errors. Since the design, condition of the support and the circumstances fall outside our assessment, no liability can be accepted based on this documentation for work done. We therefore advise you to do your own practical tests on site. Our general sales conditions apply.

Packaging & Colour:

25 cartridges of 290 ml per box: white – black – grey (Ral 7004) – dark brown (Ral 8016) – beige (Ral 1001)
20 bags of 600 ml per box: white
Other colours on request.

Certificates:

KOMO-certificate nr. 20764/06 with product certificate: Parabond 600 for mounting wall sheeting without nails or screws.
IKI-report for the use in hospitals as glue and adhesive for wall panels.

Storage and stability:

Keep cool and in the sealed packaging.
Shelf life of opened packaging is limited.
12 months in the sealed packaging at 23°C.

Safety:

Please consult the safety information, which is available upon request.

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