



**CHARACTERISTICS**

- Hybrid polymer based adhesive sealant
- High initial bonding strength ('high tack')
- High final strength
- Bonds also with slightly moist supports
- Does not cause any corrosion in metal joints
- Suitable for use with natural stone
- Paintable with most water and solvent based paints
- Solvent, isocyanate and phthalate free
- Permanently elastic
- U.V. and weather-resistant
- Good resistance to finger picking (you get a seal which is harder to pick by hand)

**APPLICATIONS**

- For interior and exterior use.
- Gluing of panels and elements in the interior and ceiling construction: wall cladding elements and ceiling panels (interior), isolation panels (mineral wool, wood-wool cement & plastic foams, PUR, PIR, PS)
- Wooden & plastic laths, ornaments, frames, doorsteps, window sills, skirting boards, roofing elements...
- Gluing and fitting of safety glass in the banking industry and fitting of cable ducts, mitres in aluminium windows, mirrors etc.
- Can be used for bonding materials in the automotive.
- Secure environments (i.e. prisons, hospitals...) where the sealant is hard so it can't be picked out by hand (not for external glazing applications!).
- Bonds without primer on almost all materials used in the construction industry, such as aluminium, galvanized and stainless steel, zinc, copper, natural stone, concrete, brick, HPL panels, treated wood, gypsum, glass, various synthetic materials, etc.

**TECHNICAL CHARACTERISTICS**

Basic ingredient	Hybrid polymer
Curing system	By means of humidity
Number of components	1
Skin formation time (23°C and 50% R.V.)	17 minutes
Vulcanisation rate (23°C and 50% R.V.)	2,5 - 3 mm after 24 hours
Density : ISO 1183	1,56 g/ml
Processing temperature	+5°C - +40°C
Shelf life, in original packing in dry conditions between +5°C - +25°C	12 months
Shore A hardness: ISO 868	60
Joint movement capacity: ISO 11600	20%
Modulus at 100% elongation: ISO 8339	1,60 N/mm <sup>2</sup>
Elongation at break: ISO 8339	110%
Modulus at break: ISO 8339	1,7 N/mm <sup>2</sup>
Solvent & isocyanate content	0%
Dry matter content	ca. 100%
Temperature resistance	-40°C - +90°C
Extremely good moisture resistance and not sensitive to frost	

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## PACKING AND COLOURS

25 cartridges of 290 ml/box - 48 boxes/pallet

White, black, grey (Ral 7004), dark brown (Ral 8016), beige (Ral 1001)

20 sausages of 600 ml/box - 45 boxes/pallet

White, black

Other colours are available on request (75 cartridges or multiples).

## METHOD OF USE

### Preparation

The support must be fixed and rigid enough. The support may be slightly damp. The materials to be joined must be clean and free from dust and grease. If necessary, degrease using **Parasilico Cleaner**, MEK, alcohol, or ethanol.

### Primers

For strongly absorbent supports it is recommended to use **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.

### Application

- Good ventilation is important during application and vulcanisation of the product.
- Apply **Parabond 600** with the supplied nozzle in strips or dots to the base or on the element to be bonded. The strips must be applied in vertical rows. Apply the strips parallel to each other, to allow the humidity to reach the adhesive between the strips.
- Bring together the parts to be joined as quickly as possible, at least within 10 minutes (this depends on the temperature and relative humidity level). The parts can at this stage still be adjusted
- Finally, push down one over the other well or tap with a rubber hammer.
- It is advised to have a gap of 3.2 mm between the parts to be bonded spacer blocks or pieces of foam tape may be used), to allow the adhesive to smooth out any distortions (especially important in exterior use or under humid conditions).
- The internal strength of **Parabond 600** immediately after application is such that bonding is possible without clamping or temporary support.

### Tooling

If desired, smooth finishing can be done using **DL 100** or **rubber stripper**.

### Cleaning

Any adhesive 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 adhesive must be removed mechanically.

### Painting

Paintable with most water and solvent based paints. Can be painted wet on wet. After 48 hours, the surface must be cleaned first before it can be painted. Pre-testing is necessary. Alkyd paints might require an extended drying time.

## SAFETY

Please consult the safety data sheet online: [www.dl-chem.com](http://www.dl-chem.com).

## LIMITATIONS

- Permanent exposure to high relative humidity may cause fungal growth.
- Not suitable for joints with a width or depth < 5 mm.
- No adhesion on PE, PP, PA, PTFE (Teflon®) and bituminous substrates.
- On bituminous surfaces: use **Paraphalt** for this purpose.
- On polycarbonate and polyacrylate: use **Parasilico PL** for this purpose.
- Not compatible with the edge seals of insulating glazing. Avoid direct contact.
- Tests show that **Parabond 600** is compatible with most PVB films of security glass. However, due to the large number of PVB films on the market and because the composition of it can be changed by the producer without mentioning, this statement does not guarantee compatibility on all PVB films.
- Not suitable for bonding masonry to facade supports.

## TECHNICAL APPROVALS

IKI-report for the use in hospitals as glue and adhesive for wall panels.

Leeds certificate for low VOC (tested by Eurofins)

EC1<sup>PLUS</sup>



\* Information sur le niveau d'émission de substances volatiles dans l'air intérieur, présentant un risque de toxicité par inhalation, sur une échelle de classe allant de A+ (très faibles émissions) à C (fortes émissions).

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