

# AT-60, high fixation

## technical data sheet · industry

**AT-60** is a high resistance, high modulus, fast curing hybrid polyurethane adhesive, which maintains its exceptional physic/mechanic and adhesive properties for a long term. It does not shrink and possesses no solvents.

### Product Data

PROPERTIES	VALUE	TEST METHOD
<i>Basis</i>	Hybrid polyurethan	
<i>Appearance</i>	Paste (High module)	
<i>Skin over time</i>	10-30 minutes (25°C, 50% RH)	ASTM-C-679-87
<i>Full cure</i>	2.5-3 mm/day (25°C, 50% RH)	ASTM-D-1640
<i>Density</i>	1.55±3 g/ml	ASTM-D-1475-98
<i>VOC</i>	36 g/L	
<i>Application temperature</i>	5°C to 40°C	
<i>Service temperature</i>	-40°C to 100°C	
<i>Elongation</i>	>350 %	ASTM-D-412-98a
<i>Tensile strength</i>	25.3 kgf/cm <sup>2</sup>	ASTM-D-412-98a
<i>Hardness, Shore A</i>	60	ASTM-C-661-98
<i>Movement capability</i>	±25%	ASTM-C-719

Information obtained from laboratory tests.

### Uses

- Stick galvanized sheets in transportation industry.
- Stick interior and exterior lateral bodywork during bus manufacturing.
- Interior and exterior ambulance lamination.
- Bodywork repairing and sticking elements through automobile manufacturing.
- Substitution or reduction of mechanic fixing points when assembling.

### Advantages

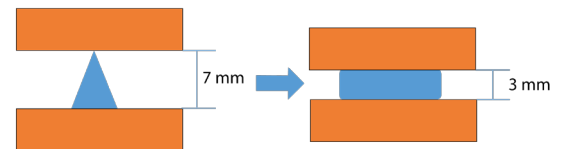
- Fast adhesion when contact with surfaces (great initial strength).
- Reduces or avoids using stiffeners while it cures.
- Low odor.
- Excellent adhesive resistance.
- It does not release any kind of acid.
- Non-corrosive.
- It does not shrink.
- It reduces or spares the use of adhesive tapes.
- It substitutes or reduces the use of mechanic fixing points.
- It dissipates tension along the adhesive bead, eliminating stress points.
- Excellent adhesion to lots of metals and plastics without using primer.
- Fast skin over time generating and curing, ideal for continuous manufacturing processes.

### Application

Make sure that surfaces about to seal are dry, clean, and free from dust, saltpeter, oil, or old sealant. Some substrates could require being cut or grinded in order to achieve a steady surface. Clean using a no lint rag wet with a free from oil solvent such as isopropyl alcohol, right after cleaning wipe the surface using a second dry rag (it is not recommended to leave the solvent dry by itself). Do not use thinner or turpentine for they may contain oil.

All loose particles must be removed before applying the adhesive.

Place **AT-60** in the caulking gun, cut the upper part of the sausage as close as possible to the clip, then place the "V" nozzle and close the caulking gun. Push the gun's trigger pumping the product towards the surface you want to stick. Make sure that the adhesive preserves its triangular form so when the surfaces are pushed together it keeps a 2 or 3 mm height.



# AT-60, high fixation

## technical data sheet • industry

### Recommendations

**Productos Pennsylvania S.A. de C.V.** recommends testing under real application conditions to ensure the product's correct performance.

- Apply the adhesive cords vertically on the surface you want to stick. Leave at least a 10cm gap between each cord to avoid them from touching when the materials are pressed together. When the pasting system implies only perimeter contact, it is recommended not to apply a closed trail of adhesive, leaving instead a 2 or 3 cm gap to allow air flowing and help the product to cure. After applying, place the material on the surface and press slightly to achieve its maximum adhesion. Place the element on the surface before the adhesive forms skin. Apply only the necessary amount of adhesive. Once stuck together do not separate the surfaces. If you need to make an adjustment, do it during the first 5 to 10 minutes and always keeping the surfaces together.
- Use the adequate safety equipment such as gloves, safety glasses or any other required by your company.

### Maintenance

It does not require any maintenance, however if the adhesive suffers any damage, clean the surface before applying and replace the damaged section with new adhesive.

### Precautions

- Adhesive must not be applied in closed areas for it needs atmospheric moisture to vulcanize.
- Do not expose to outdoors nor use it as sealant, its main function is to adhere for it must be kept within surfaces.
- Do not leave in children's reach.
- It is recommended to test adhesion when used with painted materials to ensure its correct performance.

### Limitations

- Do not use to adhere nonstick or bituminous surfaces.
- Applications that require FDA or USDA.
- To adhere windshields or lateral glasses that are not mechanically held.
- Applications where the adhesive is exposed to UV radiation.

### Presentation

### Packaging and Colors



- Black
- White

### Coverage

One sausage lasts 11.38 m, in triangular section of 7 x 7 mm, considering a 7% waste.

### Shelf life

12 months kept in a fresh and dry storage, in its original packaging at a 21°C (70°F) temperature and 50% of atmospheric moisture.

### Technical Support

**Productos Pennsylvania's** Technical Support is at your service, assisting you with:  
Guidance in how to apply this or any of our products.  
Blueprint reviews.  
Joint dimension calculus.  
Compatibility and adhesion testing of our sealants with different materials.

### NOTE:

**Productos Pennsylvania S.A de C.V.** provides technical assistance when required. Please contact our Technical Department regarding use and application of this product. It is the user's responsibility to test the product and its uses before application.

Soporte técnico: 01 800 90 210 00  
soporte.tecnico@pennsylvania.com.mx  
pennsylvania.com.mx

**Productos Pennsylvania, S.A. de C.V.**

Camino a San José 1, Fracc. Parques Industriales, C.P. 76169,  
Querétaro, Qro. México

© are Trademarks registered by Productos Pennsylvania S.A. de C.V.  
Date of production: August 2017

el experto en sellado 