

AT-60, highly adherent

hybrids

Technical Data Sheet

AT-60, highly adherent is a single component, high resistant adhesive with hybrid polymer base of high module, fast curing, with exceptional physical/mechanical and adhesive properties that remain for long term. It does not shrink and is free of solvents.

Technical Information

PROPERTIES	VALUE	TEST METHOD
Chemical basis	Polyurethane hybrid	
Aspect	Pasty (high module)	
Skin over time	10-30 minutes (77 °F, 50% HR)	DBTM 16
Curing ratio	2.5-3 mm/24 hours (77 °F and 50% HR)	
Density	1.55 ± 3 g/ml	ISO 1183-1
Application temperature	41 °F to 104 °F	
Service Temperature	-40 °F to 212 °F	
Tensile Strength	Aprox. 359 lbf/in ²	DIN 53504 S ₂
Shore A Hardness	55	DIN 53505 ₃
Movement Capability	±25%	ASTM-C-719

Information obtained from laboratory tests.

Uses

AT-60, highly adherent has been mainly developed for:

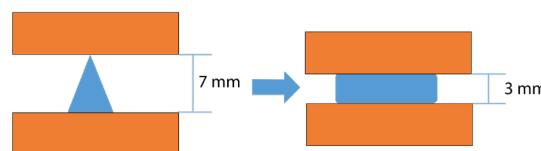
- Paste in sheets in the transport industry.
- Paste of interior and exterior lateral in bus manufacturing.
- Internal and external lamination in ambulance manufacture.
- Repair of body work and fixation of elements in automotive industry.

Advantages

- Fast adherence to contact surfaces (great initial force).
- Reduces or eliminate the use of fasteners during curing.
- Low odor.
- Excellent adhesive resistance.
- Does not release any type of acid.
- Non-corrosive.
- Does not shrink.
- Reduces or eliminates works associated with the use of adhesive tapes.
- Reduces or eliminates the use of mechanical fastening.
- Eliminates punctual stress distributing along the adhesive cord.
- Excellent adhesion to a variety of metallic substrates and plastics without activator or primer.
- Fast film formation and curing, which helps in continuous manufacturing processes.

Application

The surfaces to be adhered shall be firm, dry, clean free of dust, grease, oil, and water. The surfaces shall be cleaned with two cleaning clothes technique, consisting in passing a (lint free) cleaning clothe impregnated with isopropyl alcohol, and removing immediately all the impurities with a clean and dry cleaning clothe (it is not recommended that the alcohol dries by itself). Introduce the sausage of **AT-60** in a caulk gun special for this type of product. Cut the upper part of the sausage at the staple, then place the pipette previously cut straight and with an opening in V" (minimum it shall have 7 mm on the base and 7 mm height), in the metallic thread of the caulk gun and close. Apply vertical cords on one of the substrates placing the caulk gun at 90° and with the triangular cavity of the pipette in "V" looking to the front, so when displacing the product, forms a triangle. Then press to achieve its maximum adhesion taking care of leaving at least a thickness of 2 to 3 mm (see attached drawing).



Recommendations

- Some substrates may need grinding or manual/mechanic medium trimming to get a firm surface (all the loose particles shall be eliminated before applying the adhesive).
- Apply the adhesive cords vertically on the material to paste.
- Leave at least a separation of 10 cm between each cord to prevent that at the moment of press the pieces they join.
- For systems where the paste only includes the contact in the perimeter of the pieces, is recommended not to apply a closed adhesive circuit, but leave at least a separation of 2 to 3 cm to allow air circulation that helps to the curing of the product.
- Prevent film formation before placing the element to fix.
- Only apply the necessary quantity of adhesive.
- Once pasted the surfaces it is not recommended to detach them. If an adjustment is needed this shall be done with the elements attached and in the first 5 to 10 minutes.
- Use proper safety equipment, like gloves, safety glasses or the specified by your company.
- Perform tests under actual application conditions to guarantee its proper operation.

Maintenance

- No maintenance required.
- If the adhesive is damaged, replace the damaged section, cleaning the surface with chemical or mechanical means before applying the new adhesive (following again the cleaning steps).

Precautions

- The sealant shall not be applied in completely close area, (due it is required relative humidity for vulcanization).
- Do not leave it exposed to weather or use as sealant, due its main function is work as an adhesive, so it shall be confined.
- Keep out of the reach of children.
- It is recommended to always perform adhesion tests on some painted materials in the industries where they will be used to ensure the proper operation.

Limitations

- Do not use to paste Teflon or bituminous surfaces.
- In applications where is required the compliance with FDA or USDA.
- For pasting windshield or lateral windows that does not have mechanical fastening.
- In applications where the adhesive is exposed to UV.

Presentation

Packaging and Colors



- White
- Black

Coverage

A sausage yields approximately 22.77 m, in triangular section of 7 x 7 mm, considering a 7% waste.

Shelf Life

15 months in cold and dry warehouse in its original packaging at temperatures of 21 °C (70 °F) and 50% relative humidity.

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.

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

Camino a San José 1, Fracc. San Pablo Tecnológico, C.P. 76150, Querétaro, Qro. México

* Trademarks registered by Productos Pennsylvania S.A. de C.V.
Date of production: May 2023

the caulking expert

