

Product data sheet

HOLD ON® - P 10 - 20 is an adhesive which cures under ambient humidity. Recommended for full surface bonding coverings, panels, timber battens, cork, ...

Technical datas

Chemical base	one-component polyurethane
Colour	White / Black
Viscosity	High-viscosity
Density	1,3 g/cm ³
Processing temperature	+ 5 °C to + 35°C
Skin formation	45 min
Curing	3 mm / 24 h
Volume loss	7 %
Hardness Shore A	≈ 50
Elongation at tear	640 %
Tensile strength	2,6 N/mm ²
Tear propagation strength	12 N/mm
Temperature resistance	- 40 °C to + 90 °C

Application fields

HOLD ON® - P 10 - 20 is particularly recommended for full surface bonding of deck covering in teak, cork and synthetic. It can be used in sailing, building construction, industry and automotive market.

HOLD ON® - P 10 - 20 can be used on many substrates, such as lacquered or treated metals, aluminium, steel, and any type of plastic.

HOLD ON® - P 10 - 20 has a good resistance to humidity, bad weather and temperature between -40°C to +90°C (up to 120 °C on a short time).

Application advices

Surfaces must be clean, dry, free from dust and any trace of grease.

In order to avoid condensation phenomena, it is better to work with a temperature above 15 °C.

To maximise bond performance of non-porous substrates such as aluminium, stainless steel, glass-fibre reinforced plastics, wood, ABS or PVC, we recommend to apply an uniform coat of **HOLD ON® - T 10 - 50** before.

Due to the wide diversity of surfaces, it's strongly recommended to test the compatibility.

HOLD ON® - P 10 - 20 can be painted after skin formation. Adhesion and compatibility need to be validated with test under production conditions. Please note that the paint is less elastic than **HOLD ON® - P 10 - 20**, then, cracks may appear in the joint area.

Avoid direct contact with every substances containing isocyanates, especially solvents, paint thinner and cleaning compounds until **HOLD ON® - P 10 - 20** has attained full polymerization.

HOLD ON® - P 10 - 20 can be applied in bead and by spatula. The mastic quantity to apply depends on maximum deformation expected, dimensions of the joints and the flatness of materials to be assembled. It is advised not to exceed 30 minutes for smoothing the bead (limit of mastic skin formation). As a reminder, the polymerization rates depends on temperature, humidity level and the thickness of **HOLD ON® - P 10 - 20** applied. Assembly should be kept under light pressure in some applications during the setting time.

Storage

In its original and unopened packaging and at a temperature not exceeding + 25 °C, the shelf life of **HOLD ON® - S 20 - 60** is **12 months**.

Safety / Environment

When applying **HOLD ON® - P 10 - 20**, avoid direct contact with the uncured material, safety gloves are recommended.

The safety data sheet is available on request. Product is conforme to Directive 2011/65/EU RoHS2 and regulation REACH. Product without CFC.

Packaging

Sausage of 600 ml, box of 12 units.

Please note

All the data given are as accurate as possible in view to our current knowledge. However, they are given only as an indication. These informations cannot imply a guarantee on our part.