

Technical Data Sheet
DiPUR 503

 Issue date: 2012.03.14
 Revision date: 2018.03.05

Two-component solventless polyurethane adhesive.
1. Purpose

DiPUR 503 is designed for manual gluing of foamed polystyrene, XPS, PUR foam, mineral and glass wool, board with metal plates, facings made of plastics, building paper, concrete slabs, wood and other materials. The adhesive can be also used for moulders manufacture and gapes filling. Ready for use adhesive is strongly hydrophobic and can be applied even in hard conditions.

2. Physical and chemical properties

	DiPUR 503 A (polyol component)	DiPUR 503 B (isocyanate component)
Form	white suspension	brown liquid
Viscosity at 25°C [mPas]	15000 ± 2500	200 ± 50
Density at 25°C [g/cm ³]	1,60 ± 0,05	1,23 ± 0,02

3. Technological properties*

Component mixing ratio recommended:

	by weight	by volume
DiPUR 503 A	100	100
DiPUR 503 B	20 ±1	26 ± 1,5

The adhesive use with different mixing ratio can cause the reaction time changes or the joint flexibility and mechanical strength changes.

Reaction times of 83,3g DiPUR 503 A and 16,7g DiPUR 503 B mixture measured in a cup at temp. 19 – 21°C and 50 % of air relative humidity:

Pot life: 30- 40 min

Open time: max. 2 h

Press time: 5 – 6 h

Joint density: 1450 –1550 kg/m³

Joint hardness: 50- 60 °Sh D

It is necessary to mix both components of the adhesive, in accordance with given ratio. The adhesive mixed volume should be applied on joined elements during no more, than 30 – 40 minutes after the components mixing. Elements with the adhesive spread should be pressed to each other not later, than 2 h after the components mixing and kept under press until the joint will set. The adhesive consumption should be about 200 g/m², and about 300 g/m² in the case of absorptive materials.

The time for full strength of the joint reach is 24 h.

4. Processing conditions

DiPUR 503 A component should be thoroughly mixed before use; after prolonged store it is especially important.

Processing temperature range: 10-80°C

The product should be stored in tightly closed containers at temperature of 10 – 35°C.

Expiration date for use: 12 months

5. Application safety

DiPUR 503 A is not classified as hazardous substance. DiPUR 503 B is harmful substance. It is necessary to be familiarized with the product Safety Data Sheet before use. Standard protective clothing should be wear during the adhesive application. Fresh contaminations should be washed out with Pursan ACT solvent. Cured adhesive can be removed mechanically.

***Notes**

Data presented in this information have been obtained in model conditions. The results obtained when operating in other conditions can be slightly different from published.

Every time the user is obliged to check the product and auxiliary agents usefulness for his intentional use.

The user is obligated to have a valid technical data sheet and safety data sheet of the product, which is provided by the manufacturer during the sale and every time on the customer's request

Prior to processing the user must carefully read aforementioned documentation and follow the rules of procedure for product use.