

**Bohle America, Inc.**

Phone (+1) 704 247 8400
Fax (+1) 704 247 8420
Email info@bohle-america.com
Internet www.bohle-america.com

Xtragrip™: Technical Data Sheet

Base	Silyl-terminated polymer
Sag	No sag in vertical displ. @120°F ASTM C 639
Curing system	Moisture Cure
Tack-free time	90 min. ASTM C 679 (maximum 72 hrs.)
Cure time	24-72 hrs, 1/4" diameter bead @ 75°F & 50% relative humidity
Hardness – Shore A	50 +/- 5 ASTM C 661
Skin Formation (*)	(75°F/50% RH) 5 min.
Temperature resistance	-40°F to +194°F
Tensile Yield	435 psi ASTM D 412
Elongation	500% ASTM D 412
Total joint movement	+/- 20 % ASTM C 719
Stain and color change	Passes ASTM C 510 (no visible stain)
Artificial weathering	No Cracking ASTM C 793 (2,000 hrs Xenonarc)
Shelf life	12 months Stored between 33°F & 80°F

(*) these values may vary depending on environmental factors such as temperature, moisture, and type of substrates

Product

Xtragrip™ Fast Cure is an adhesive/sealant with high initial tack

Characteristics

Excellent adhesion on porous and non-porous substrates immediate high grab strength on nearly all surfaces high performance mechanical properties flexible elastic rubber - movement accommodation up to +/- 20% high green strength, quick build-up of end strength, high sheer strength after full cure no bubble formation within sealant even in high temperature and humidity applications very easy to tool and finish color stable and UV resistant ecological advantages - free of isocyanates, solvents, halogens and acids minimal health and safety considerations can be painted with all water based paints and many other systems (to be tested) good extrudability even at low temperatures excellent weather resistance in all climates primerless adhesion on many different substrates (except where water pressure may occur) almost odorless.

Applications

Can be used for mirror installations as a 1 step product sealing and bonding in building and construction industry and metal working industry sanitary and kitchen areas - resists mold growth, structural elastic bonding, structural bonding applications in the automotive industry (cars, coaches, caravans, marine, trains), elastic bonding of panels, profiles, and other pieces on the most common substrates.

Packaging

10.1 fl. oz. cartridge

Shelf life

12 months in unopened packaging in a cool and dry storage

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Adhesion

Xtragrip™ has an excellent adhesion to almost all substrates. Xtragrip™ has been tested on the following metal surfaces: steel, AlMgSi1, brass, electrolytic galvanized steel, AlCuMg1, flame galvanized steel, AlMg3 and steel ST1403. Plastics that were tested include: polystyrene, polycarbonate (Makrolon®), PVC, polyamide, fiberglass reinforced epoxy, and polyester (GRP).

While producing plastics very often releasing agents, processing aids and other protective agents (like protection foil) are used. These should be removed prior to bonding. For optimum adhesion, the use of Surface Activator is recommended. NOTICE: bonding plastics like polycarbonate (ie Makrolon® or Lexan®) in stress loaded applications can give rise to stress cracking and crazing in these substrates. The use of Xtragrip™ is not recommended in these applications.

There is no adhesion on PE, PP, PTFE (Teflon®) and PMMA (ie Plexi® glass).

Substrates

Type: all usual building surfaces, most metals, polyesters, and many plastics. Not suitable for PE, PP, PTFE (Teflon®), ABS or PMMA (ie Plexi® glass). Surface Preparation: clean, dry, free of dust and grease it is expected that the product will adhere and perform in uncontaminated joints with most common construction substrates, without the use of a primer porous surfaces in water loaded applications should be primed with Primer 150 surface activator may be used to pretreat non-porous surfaces we always recommend preliminary compatibility tests previous to application

Resistance to chemical agents

Good resistance to water, aliphatic solvents, mineral oils, grease, diluted inorganic acids, and alkalis. Poor resistance to aromatic solvents, concentrated acids, chlorinated hydrocarbons.

Remarks

Pre-testing for adhesion is intended to eliminate potential problems. This testing will aid in determining the proper surface preparation method. May be painted, however, due to the large number of paints and varnishes available we strongly suggest a compatibility test before application. The drying time of alkyd resin based paints may increase. Can be applied to a wide variety of substrates. Due to the fact that specific substrates such as plastics, like polycarbonate, etc. may differ from manufacturer to manufacturer, we recommend preliminary compatibility tests. Porous surfaces in water loaded applications should be primed with Primer 150. Lower temperatures and humidity will extend curing time.

In order to avoid possible problems due to condensation, the mirror manufacturers recommend sufficient ventilation at the back of the mirror. As a guideline, an opening of 1/8" should be left between the surface and the mirror. This can be assured by the use of double-sided mirror tape. We recommend this minimal ventilation opening of 1/8" to ensure correct curing of the adhesive/sealant. Full surface bonding is at own risk of the applicator. For larger mirrors always use the adhesive in combination with a very good and qualitative double-sided adhesive mirror tape.

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Bonding Layer

We recommend a bonding layer of at least $\frac{3}{4}$ " (bead size of $\frac{3}{8}$ ") to achieve a bond with maximum elastic properties.

Application Method

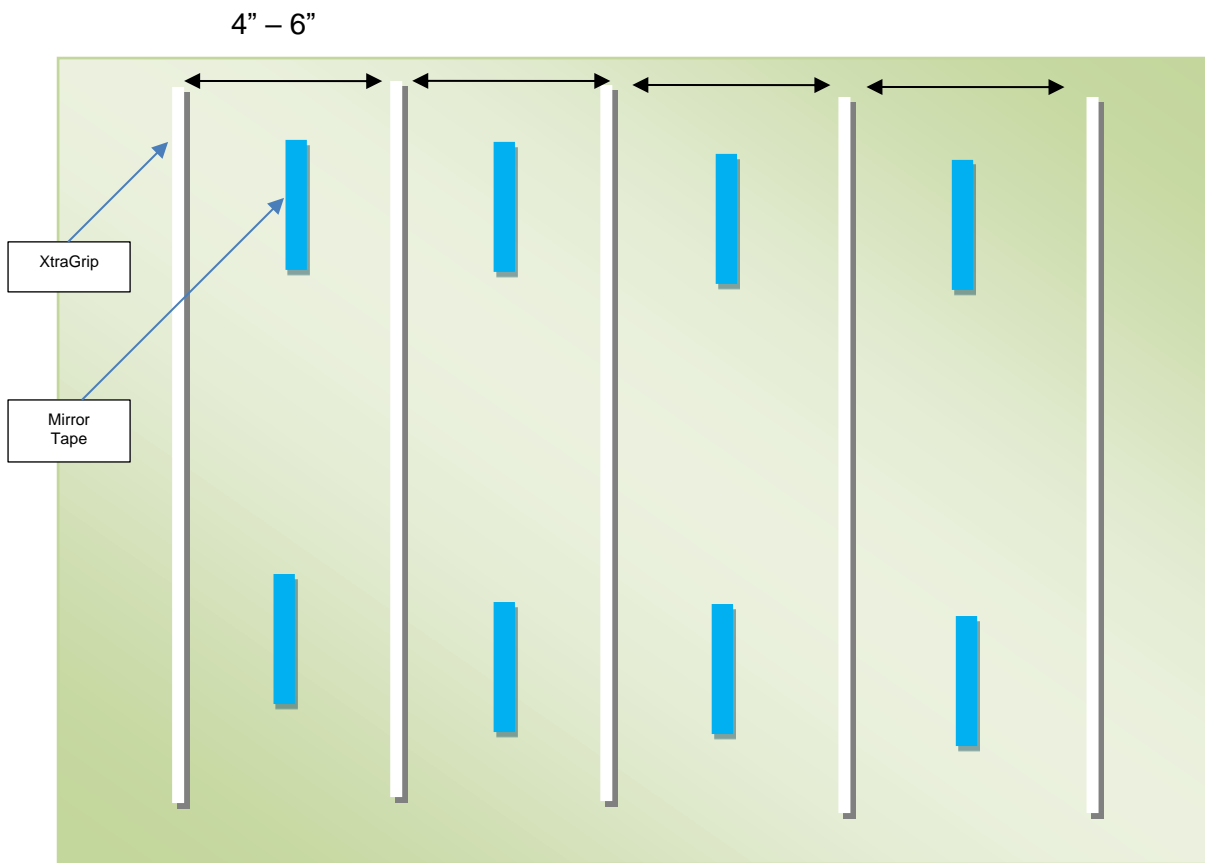
Application Method: Manual or pneumatic caulking gun

Application temperature: 34°F to +90°F

Cleaning: with IPA immediately after use and before curing.

Depending on the weight of the mirror, an adhesive bead shall be applied every 4"-6", applied in a vertical line with compatible MirrorTape -1/8" thick mirror tape applied for curing support (see image).

If needed, repair with Xtragrip

**Meets**

ASTM C 920, Type S, Grade NS, Class 25, Use T, NT, M, A, G and O, Federal Specification TT-S-00230C, Type II, Class A



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Health and Safety Recommendation

KEEP OUT OF REACH OF CHILDREN. Avoid skin and eye contact. On Contact, uncured sealant could cause irritation to skin and eyes. In case of eye contact, flush eyes with warm water for 15 minutes, call a physician. For skin contact, remove sealant with a paper towel. If swallowed, do not induce vomiting, call a physician. Xtragrip™ is manufactured for professional use only. Refer to Material Safety Data Sheet (MSDS) for further information.

Environmental Clauses

LEED regulation: Xtragrip™ conforms to the requirements of LEED. Low-Emitting Materials: Adhesives and Sealants. SCAQMD rule 1168. Complies with USGBC LEED® 2009 Credit 4.1: Low-Emitting Materials – Adhesives & Sealants concerning the VOC-content. Xtragrip™ has VOC of 15g/L (< 3% VOC)

Limited Warranty

Xtragrip™ warrants product to be of good quality and will replace or, at our election, refund the purchase price of any products proved to be defective. Satisfactory results depend not only upon quality products but also upon many factors beyond our control.

Therefore, except for such replacement or refund, XTRAGRIP™ MAKES NO WARRANTY OR GUARANTEE, EXPRESS OR IMPLIED, INCLUDING WARRANTIES OF FITNESS FOR A PARTICULAR PURPOSE OR MERCHANTABILITY, RESPECTING ITS PRODUCTS, and Xtragrip™ shall have no other liability with respect thereto. Any claim regarding product defect must be received in writing one (1) year from the date of shipment. No claim will be considered without such written notice or after the specified time interval. User shall determine the suitability of the products for the intended use and assume all risks and liability in connection therewith.