

# BLACKGLUE 01

**BLACKGLUE 01** is a fast curing two-components polyurethane adhesive specially formulated for gluing, grouting, and repairing a large range of materials used by CPOs (metal, plastics, composites, plaster, wood, foams...). It is a strong structural adhesive resistant to elevated temperatures, moisture, most solvents, and chemicals and that can be quickly sanded.

Easy to use thanks to its specific rheology, this product has a perfect working time to fix any parts together while keeping a high productivity.

- Easy and very fast sanding (after 10 minutes)
- Thixotropic, does not drip, allowing vertical application
- No shrinkage
- Suitable for most plastics
- Good impact resistance

## Implementation of components

**BLACKGLUE 01** packaged in 50 ml cartridges requires the use of a 1:1 two component manual or pneumatic dispensing gun to extrude the system.

IMPLEMENTATION CONDITIONS	
Recommended operating temperature (°C)	10 to 30
Operating temperature (°C)	-40 to 80

The adhesive must be applied on a clean and dry surface free of grease, dust, etc. For the choice of a degreaser, consult our technical department.

Start extruding the glue without mixer to equalize the levels of the two components, fix the mixer and remove the first milliliters of the extruded cordon.

Apply the adhesive to one or all the parts to be assembled. Bring the two parts to be bonded together within the recommended working time. Hold the pressure for a few moments to allow the adhesive to set. Then release the pressure and allow the adhesive to cure.

After a few minutes, you can sand your bonding with 80-180 abrasive paper.

Then wait for the weight loading time before stressing the assembly.



## Characteristics of the polymerized product

Shore D Hardness, EN ISO 868  
@23 °C: 65

Tensile strength, EN ISO 527 @23 °C  
(MPa): 23

Elongation at break, EN ISO 527  
@23 °C (%): 55

Young's modulus, EN ISO 527 @23 °C  
(MPa) : 420

## Characteristics of the liquid product

### Aspect:

Part A: black / Part B: white  
Mix: deep black

### Density:

Approx. 1.25 for the two components

### Viscosity at 25 °C in Pa.s:

- Polyol: approx. 44.8
- Isocyanate: approx. 42.6

### Mixing ratio in volume:

1 : 1

**BLACKGLUE 01** can be cleaned whether with acetone (uncured adhesive) or our unlabelled Greencleaner formulation.

Hands and skin should be cleaned immediately with water and a suitable soap. Do not use solvents on your skin.

## Reactivity

**BLACKGLUE 01** polymerizes when the two components are mixed and cures at room temperature. Curing can be accelerated by heat (maximum 60°C) using an infrared lamp or oven. Heating the system increases the curing speed (+10°C will double it) but reduces the open time.

The volume mixing ratio 1:1 is perfectly respected thanks to the design of the two-component cartridge mixer.

The bonding remains adjustable during open time.

REACTIVITY	
Open time at 23 °C / 50% RH	90"
Sand time at 23 °C	3'
Weight loading at 23 °C	10'

## Packaging

**BLACKGLUE 01** system is available in 50 ml two-component cartridge, for use with appropriate static mixers (sold separately).

PACKAGING	REFERENCE	PRODUCT
3 units	EMBBC50 003	Static mixer for 50ml cartridge
36 units	EMBBC50 036	Static mixer for 50ml cartridge
144 units	EMBBC50 144	Static mixer for 50ml cartridge
1 unit	PISC50 001	Manual dispensing gun for 50ml

## Storage, handling and safety

**BLACKGLUE 01** has a shelf life of 12 months, stored in a dry place at a temperature of 15°C - 25°C, in its original unopened packaging.

It is essential that appropriate protective measures are strictly observed during handling:

- ventilated rooms
- wearing gloves and glasses
- waterproof clothing

For further information, please refer to the MSDS.

## Customs' code

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BLACKGLUE 01 PART A	39093100
BLACKGLUE 01 PART B	39072020

*Information contained in this document is supplied in good faith and based on our current knowledge. It is for indication and not formal constraint, in particular if this product is not used according to the applications expressed in this technical index card. A preliminary test will always be advised to be sure that the product corresponds to the customer's requirements.*

*The user of this product undertakes to respect the current legislation for the elimination of waste.*