

DINITROL 771

Characteristics:

DINITROL 771 is a MS polymer-based adhesive with high green strength and is suitable for making elastic constructive joints. Due to its high green strength, clamping times can often be reduced or the requirement of clamps eradicated completely. DINITROL 771 can also be used as a sealant, if similar materials (similar rigidity) are joined together or if mechanical fastening methods are used.

- Solvent, isocyanate and PVC-free
- Very good UV-resistance and ageing properties
- In general, good adhesion on several substrates without the use of a primer
- Permanently elastic in a temperature range from -40°C to $+120^{\circ}\text{C}$
- Neutral, odourless and fast curing
- Paint compatible with most industrial paint or lacquering systems, both alkyd resin and dispersion-based (due to the large scale of different types of industrial paints, a paint compatibility test is recommended)
- Paintable after skin forming (wet on wet); this will not influence the curing speed

Areas of Applications:

- Elastic bonding and sealing in e.g. bus, train, caravan, camper and truck construction
- Bonding of windows in e.g. buses and trains
- Bonding of corner profiles of aluminium or polyester on trailers
- Bonding of polyester parts on metal frames

Method of Use:

DINITROL 771 can easily be extruded with a hand or air pressure gun at temperatures between $+5^{\circ}\text{C}$ and 35°C . In sealing applications DINITROL 771 should be tooled or smoothened within 10 minutes (at $20^{\circ}\text{C}/50\%$ r.h.) with a spatula or putty knife, and occasionally moistened with a soap solution. Prevent the soap solution from penetrating between joint sides and sealant, given that this will create loss of adhesion.

In bonding applications the substrates must be assembled within 15 minutes (at $20^{\circ}\text{C}/50\%$ r.h.) after applying DINITROL 771. The higher the temperature, the shorter the open time will be! In general, an adhesive thickness of 2 mm is recommended if similar materials (similar rigidity) are bonded. The larger the difference in thermal expansion, the thicker the adhesive bead should be. For more details, please consult DINOL GmbH.

At a temperature of 20°C and a relative humidity of 50%, DINITROL 771 can be painted with most industrial paints just 10 minutes after application. Best paint adhesion is generally obtained if painted within 4 hours after applying DINITROL 771.

Cleaning tools or removing uncured DINITROL 771 residue can be done with a clean, colourless cloth soaked in acetone or MEK. It is recommended to carry out a trial first to ensure that such solutions do not attack the substrate.

Die in diesem Merkblatt gemachten Angaben sind das Ergebnis sorgfältiger Untersuchungen. Soweit sie sich auf die Anwendung beziehen, sind sie als Empfehlung zu betrachten, die dem Erfahrungsstand entsprechen. Wegen der Vielseitigkeit der Anwendungs- und Arbeitsweisen können wir jedoch eine Verbindlichkeit nicht übernehmen. Es wird daher ein vertragliches Rechtsverhältnis nicht begründet, und es entstehen aus eventuellen Kaufverträgen keine Nebenverpflichtungen.

All data and recommendations are the result of careful tests by our laboratories. They can only be considered as recommendations which correspond to the level of experience of today. The data are given in good faith. However, in view of the multiplicity of possible application and working methods we are not in a position to assume any responsibility or obligations deriving from the use of our products.

DINOL GmbH
 Pyrmonter Str. 76
 D-32676 Lügde
 Telephone:
 +49 (0) 52 81 / 9 82 98-0
 Fax:
 +49 (0) 52 81 / 9 82 98-60
 Email:
 service@dinol.com

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In general DINITROL 771 adheres well without a primer on clean, dry, dust and grease-free substrates of aluminium, stainless steel, galvanised steel, zinc, copper, brass, powder coated metal, most lacquered metal surfaces, glass, PVC, polyester (GRP), painted and lacquered wood, etc. No adhesion on untreated polyethylene, polypropylene and teflon. In cases in which significant thermal or physical loads, especially under wet conditions, require high adhesion please contact DINOL GmbH also as for all other substrates and additional information.

Storage Stability:

DINITROL 771 may be stored for 12 months in a closed (unopened) container or bag in a dry place at temperatures between + 5°C and +30°C (cartridges 18 months).

Safety precautions:

No specific safety precautions required. Consult safety data sheet.

Transport classification:

Not applicable.

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Technical data:

Basic material:	MS polymer
Curing method:	Moisture
Density:	Approx. 1.4 g/ml
Skin forming time (20°C/50% R.H.):	Approx. 12 min.
Open time (20°C/50% R.H.):	< 15 min.
Curing speed after 24 hrs (20°C/50%R.H.):	Approx. 4 mm
Shore A hardness (DIN 53505):	Approx. 55
Volume change (DIN 52451):	< 3%
Green strength (Physica Rheometer MC100): (max. load which can be applied per m ² uncured adhesive without sagging)	Approx. 700 Pa
Tensile stress (100%) (DIN 53504/ISO 37):	Approx. 1.7 MPa
Tensile stress at break (DIN 53504/ISO 37):	Approx. 2.8 MPa
Elongation at break (DIN 53504/ISO 37):	Approx. 210%
Shear stress (DIN 53283/ASTM D1002): (Alu-Alu; adh. thickness 2 mm, test speed 50 mm/min.)	Approx. 2.5 MPa
Tear propagation (DIN 53515/ISO 34): (Type C, test speed 500 mm/min.)	Approx. 14 N/mm
E-Modulus (10%) (DIN 53504/ISO 37):	Approx. 4.5 MPa
Solvent percentage:	0%
Isocyanate percentage:	0%
Temperature resistance:	- 40°C to +120°C
Temperature resistance (max. 20 minutes):	+180°C
Application temperature:	+5°C to +35°C
UV and weather resistance:	Excellent
Colours (standard):	White, black
Packaging:	290 ml cartridges, 600 ml bags, other packaging on request

Health and safety information can be obtained from the material safety data sheet and the product label.

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