

PRODUCT INFORMATION

GD 677

with liquid B-component



KÖMMERLING CHEMISCHE FABRIK GMBH

Secondary sealant for the manufacturing of insulating glass units

- Excellent adhesion to clean surfaces such as glass, aluminium and galvanized or stainless steel
- Good adhesion to many plastics
- Low water vapour transmission rate

TECHNICAL DATA

Base	A-component: Polybutadiene polyol B-component: Isocyanate		
Mixed colour	Black		
Consistency	Paste		
Mixing ratio A-comp. : B-comp.			
- by volume	10 : 1		
- by weight	10 : 0,63		
Density			
- A-component	approx.	1.72 g/cm ³	+23 °C
- B-component	approx.	1.09 g/cm ³	+23 °C
Pot life	>	20 min	+23 °C
Peel resistance	>	3.5 N/mm	Kö test method 100086
Tensile strength	>	0.7 N/mm ²	EN 1279-4
Hardness Shore A	≥	35	EN 1279.6, annex E and Kö-Norm 100039 at standard climate 23/50
Adhesion floatglass		0.36 N/mm ²	EN 1279.4, annex A
Water vapour transmission rate	<	4 g/m ² •d	EN 1279.4
Gas permeation (Ar)	<	0.05 g/m ² •h	EN 1279.4
Volatile content	<	1 %	EN 1279.6, annex G
Fogging	Without visual fogging		EN 1279.6, annex C

PROCESSING

Preparation

The joint faced or surfaces to be bonded must be dry, clean and free from dust and grease.

For cleaning we recommend **Körasolv GL**, unless washing machines or other tested, residue-free agents are available.

Preparing the mixture

When using an automatic mixer ensure the mix ratio is correct. The mix ratio by volume is 10:1.

The mixed product must be applied within the indicated pot-life. At a higher temperature the pot-life is shorter. Prepare only the amount that can be applied within this period of time.

Rule of thumb:

30 min. pot-life at +20 °C material temperature
15 min. pot-life at +30 °C material temperature
8 min. pot-life at +40 °C material temperature

Maximum acceptable mixing tolerance ± 10 %.

GD 677 WITH LIQUID B-COMPONENT

Curing

GD 677 should not be applied where the ambient temperature is below +10 °C.

The curing speed of **GD 677** depends on the storage temperature of the units produced with this sealant.

At +10 °C the curing times double or triple; at +30 °C they are reduced by approx. 50 %. A tack-free surface is reached at approx. +23 °C after about 5 hours.

CLEANING

For cleaning the surfaces to be bonded: **Körasolv GL**

For cleaning tools and removing fresh stains: **Körasolv GL**

SPECIAL NOTES

Storage

Store in unopened containers in cool conditions. The shelf-life is approx. 9 months.

(Please note: B-component is sensitive to humidity!)

SAFETY

Please notice the indications on our EC-safety-data-sheets and the safety-indications on the labels of each product for the treatment of our products.

Especially the directions of the Dangerous Substance Regulation have to be respected.

Keep the EC-safety-data-sheet of the product you treat ready to hand. It gives you valuable indications for the safe usage, disposal and in case of accidents.

PACKAGING UNITS

A-component:
200 l drum

B-component:
20 l hobcock
200 l drum

For safety related data please refer to the safety data sheet!

Please note: All given data are based on careful examination in our laboratories and our past practical experience. These are non-binding indications. Given the high number of materials appearing on the market and the different methods of use which are beyond our influence and control, we naturally cannot accept any responsibility for the results of your work, also with regard to third party patent rights. We recommend that sufficiently thorough tests be carried out to ascertain whether the product described will meet the requirements of your particular case. Please also note our Terms of Sale, Delivery and Payment. This product information replaces all previous issues.



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