

DESCRIPTION

HM-VK™ is an ultra high-strength, handmix 100% pure polyurea elastomeric adhesive with extended pot life.

FEATURES

- 100% solids, no solvents, and zero VOCs.
- Pot mixed.
- Compliant with FDA/USDA for incidental food contact.

RECOMMENDED USES

- High strength polyurea adhesive.

COLORS

HM-VK™ is available in SPI standard Neutral (honey) color.
Note: In continuous full-light exposure, HM-VK™ will yellow over a period of time.

PACKAGING

HM-VK™ is sold in 1 quart, 1 gallon, 5 gallon, and 55 gallon kits.

CURING SCHEDULE

Gel	26 ± 2 min
Tack Free	30 ± 2 min
Post Cure**	12 hour
Recoat	12 hours

Above curing schedule is based on 125 g @ 77°F (25°C). Variables that will change the speed of reaction and length of pot life:

- **Weight of product used**
- **Starting temperature of test product**
- **Air temperature**
- **Substrate temperature**

**Complete polymerization to achieve final strength can take up to several days, depending on a variety of conditions or substrate type.

DRY PROPERTIES*

Hand Mix	
Tensile Strength ASTM D 638	± 6,671 psi (46 mpa) avg
Elongation ASTM D638	± 506%
Hardness (Shore A) ASTM D2240	95 ± 5
Hardness (Shore D) ASTM D2240-81	44 ± 5
Modulus 300% ASTM D412	1395 psi (9.7 mpa)
Service Temperature	-30° - +250°F (-34° - +121°C)

*All cured film properties are approximate since processing parameter, ad-mixture types, and quantities change physical properties of the cured elastomer.

All samples for above tests were force cured 48 hours or aged for more than three weeks. It is recommended that the user perform their own independent testing.

WET PROPERTIES

Solids by Volume	100%
Solids by Weight	100%
Volatile Organic Compounds	0 lbs./gal (0 g/l)
Theoretical Coverage DFT	100 sq. ft. @ 16 mils/gal
Weight per gallon (approx.)	8.8 lbs. (4.0 kg)
Number of coats	1 or more
Mix Ratio (by volume)	1 "A" : 4 "B"
Viscosity (cPs) @77°F (25°C)	A: 40 ± 20 mPa.s B: 3000 ± 500 mPa.s
Shelf Life Unopened Containers @ 60 - 90°F (15 - 32°C)	6 Months

Minimum material/container temperature for application is 75°F (24°C).

GENERAL APPLICATION INSTRUCTIONS

Apply HM-VK™ to only clean, dry, sound surfaces free of loose particles or other foreign matter.

HM-VK™ “A” containers are clearly marked indicating what size “B” container is required for the 4:1 ratio mix by weight.

HM-VK™ should remain sealed while not in use as exposure to the atmosphere will reduce physical properties of end product.

After introducing the “A” side to the “B” side the mixture should be folded in with a stir stick and in an even manner, scraping the sides and bottom of container as you mix. DO NOT whip or mix with an electric mixer. Once mixed drizzle onto prepared substrate in an overlapping figure 8 pattern to allow for even distribution to spread with a notched type trowel or preferred tool. Note: porous substrates will likely create “out gas” bubbles. Heating the substrate may help mitigate this.

Read and observe all precautions, instructions, and limitations that are included with all containers of HM-VK™.

LIMITATIONS

HM-VK™ is for professional use only.

HM-VK™ must be stored at temperatures between 70° - 90°F (21° - 32°C). Storing this product at temperatures below 70°F (21°C) will cause the polymer to become very viscous.

HM-VK™ is best processed at 80°F (27°C) ± 5.

Processing HM-VK™ below 75°F will cause the polymer to become very viscous and negatively impact the ability to get a good mix.

Processing HM-VK™ at temperatures above 80°F (27°C) will speed up the reaction and shorten pot life. Pot life is approximately 24 - 28 minutes at 77°F (25°C).

Avoid moisture contamination in containers. Containers should not be resealed if contamination is suspected, CO₂ created pressure can develop. Do not attempt to use contaminated material.

Note: The material supplied is a two component system (Component “A”/Component “B”) which is used to formulate this product. The quality and characteristics of the finished polymer is determined by the mixture and application of the two components.

If you own a machine that is not listed above please contact your SPI representative for information and instructions.

GENERAL SAFETY, TOXICITY, & HEALTH

Safety Data Sheets are available for this coating material. Any individual who may come in contact with these products should read and understand the S.D.S. **CHEMTREC EMERGENCY NUMBER 1-800-424-9300**

WARNING: Contact with skin or inhalation of vapors may cause an allergic reaction. Avoid eye contact with the liquid or spray mist. Hypersensitive persons should wear protective clothes, gloves and use protective cream on face, hands and exposed areas.

CLEAN UP: Use DPM or NMP.

EYE PROTECTION: Safety eye wear complying with an approved standard should be used when a risk assessment indicates this is necessary to avoid exposure to liquid splashes, mists, or dusts. If contact is possible, the following protection should be worn, unless the assessment indicates a higher degree of protection: chemical splash goggles and/or face shield.

SKIN PROTECTION: Personal protective equipment for the body should be selected based on the task being performed; the risks involved, and should be approved by an industrial hygiene specialist before handling this product. Chemical resistant gloves complying with applicable health and safety standards shall be worn when handling this product. Cover as much of the exposed skin area as possible with appropriate clothing. Refer to safety data sheet (SDS).

RESPIRATORY PROTECTION: Harmful if inhaled and may cause allergy or asthma symptoms. Ensure adequate ventilation. If the respirator is the sole means of protection, use a full-face supplied respirator. Use respirators and components tested and approved under appropriate government standards such as OSHA 29CFR 1910.134, NIOSH (US), or CEN (EU). Consider the application and environmental concentrations when deciding if additional protective measures are necessary.

INGESTION: Do not take internally. It is believed that ingestion of polymeric isocyanates would not be fatal to humans, but may cause inflammation of mouth and stomach tissue.



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