

PACTAN 6076 BfR PACTAN 6076 FDA

Flexible adhesive
for industrial use

AREA OF APPLICATION

For industrial adhesive applications in the household goods sector. This product is used in the area of bonding modular components and assemblies, particularly for flexibly bonding high temperature-stressed interior oven panels.

PRODUCT BENEFITS

Adhesive is environmentally friendly, high temperature-resistant, highly flexible and vibration-resistant. The product does not contain isocyanates, flame retardants, BPAs, PAHs, phthalates or fluorine, bromine and ozone-depleting compounds. It complies with the regulations of REACH, RoHS, WEEE as well as many other regulations. UL-listed under QMFZ2.340731.

Food-compatible in accordance with 1935/2004/EC and German Food and Feed Code (LFGB). Test certificate no.: H-250884-14-Bg.

MATERIAL PROPERTIES

PACTAN 6076 is a stable 1-component material. Cross-linking occurs through a chemical reaction with moisture from the environment. Once the cross-linking is completed, the product is odourless. In addition to being very resistant to ageing and weather, the material also has good chemical and thermal resistance.

	UNIT	VALUE
Specific gravity DIN 52479	g/ml	1.08
Working time	minutes	approx. 10
Consistency	–	paste-like
Processing temperature	°C	+5 to +40
Temperature stability		
• up to	°C	315
• tested 2,000 hrs	°C	250
Cross-linking system	–	acid
Stability	–	good
Tensile strength DIN 53504 S2	N/mm ²	approx. 1.5

PACTAN 6000 series can accelerate or intensify corrosion under unfavourable conditions.

PRE-TREATMENT

PACTAN 6076 adheres to a large number of material surfaces. However, the surfaces must always be clean, free from grease and dry. The removal of grease and other pollutants which might affect the bonding of the adhesive onto the respective substrate is essential.

Where cleaning is required use PACTAN Cleaner or an automatic degreasing system. Information and recommendations regarding any additional pre-treatment that may be required are provided once we are fully aware of the problems involved and after application technology tests in our laboratory. Suitable cleaning agents include PACTAN Cleaner or PACTAN Adhesive Cleaner. Adhesion without pre-treatment can be achieved on a large number of materials, such as glass, metal and most technical plastics. On some plastics with a low surface tension, such as polyethylene and polypropylene, adhesion is mostly insufficient. Pre-treatment is very strongly recommended.

ADHESION TABLE

SUBSTRATE	ADHESION	PRE-TREATMENT
Glass	good	none
V2A 1.4301	satisfactory	recommended
Eloxal	satisfactory	recommended
Aluminium	satisfactory	recommended
Copper	satisfactory	recommended
Brass	satisfactory	recommended
Hot-dip galvanised sheet metal	satisfactory	recommended
ABS	satisfactory	recommended
Polyamide 6.6	good	none
Polystyrene	satisfactory	recommended
Polycarbonate (unfilled)	satisfactory	recommended
PMMA (unfilled)	satisfactory	recommended
Polypropylene (unfilled)	satisfactory	recommended
Polyethylene (unfilled)	satisfactory	recommended

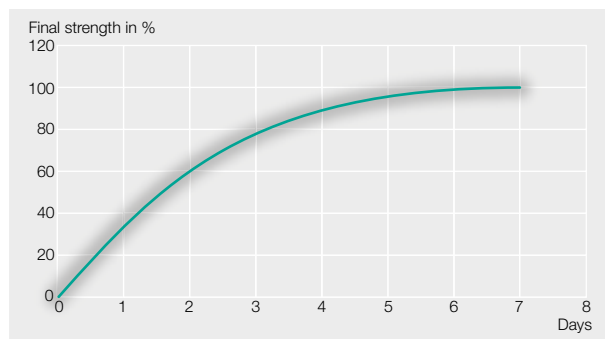
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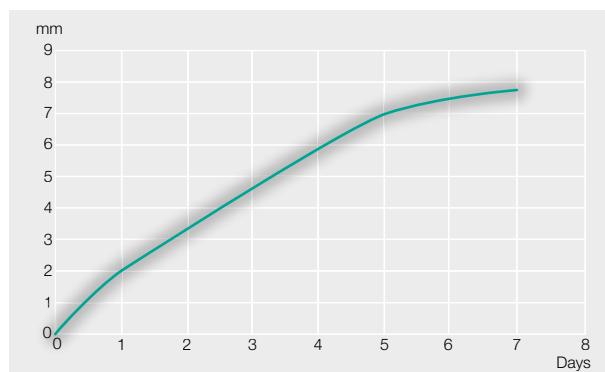
PROCESSING

Both manual guns and pneumatically driven dispensers are available for manual processing from cartridges or foil bags. A supplier certificate will be provided on request for processing from hobbocks or drums.

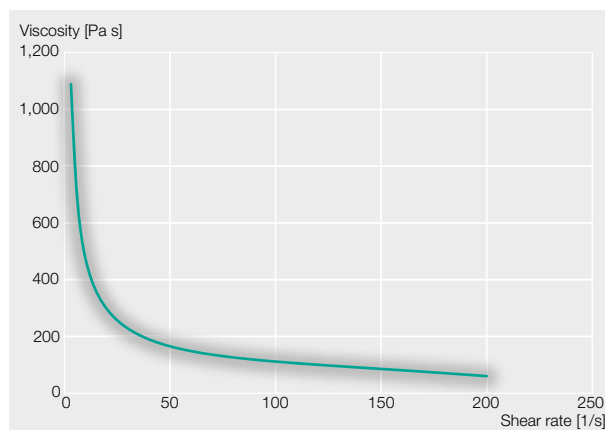
TENSILE STRENGTH



DEPTH OF CURING



FLOW CURVE 23°C



APPLICATION INSTRUCTIONS

Adhesives/sealants are applied to the prepared surfaces and then immediately attached to the work piece being bonded. PACTAN 6076 forms a flexible and temperature-stable bond through a reaction with the moisture from the environment. Any subsequent work, such as smoothing the surface or re-positioning, must be completed within the working time. PACTAN 6076 is tack free after around 60 minutes. Do not expose to any thermal or chemical stress until the reaction is concluded and the decomposition product has escaped.

WORKING TIME

In PACTAN 6076 the cross-linking process goes from the outside to the inside by diffusion of air humidity.

It is recommended not to exceed adhesive depths of 15 mm to ensure acceptable curing. Low moisture supply extends the curing process. The supply of moisture is affected by the structure and the environmental conditions.

Damage to the adhesive from downstream processes must be avoided. For this reason, the adhesive process must be designed so that the adhesive has sufficient structure and bond.

CLEANING

Clean tools immediately after the work is finished using PACTAN Cleaner. It is only possible to remove fully reacted material mechanically with a great deal of effort.

PACKAGING

This product is available in standard sizes for industrial applications. Further information is available from your contact person at tremco illbruck.

MINIMUM SHELF LIFE

Suitable for storage for up to 12 months in dry areas at +5°C to +25°C in unopened containers.

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SAFETY INSTRUCTIONS

The information in the technical data sheet, on the container label and in the safety data sheet must be adhered to in order to ensure safe handling of the product. Good ventilation must be ensured when processing large quantities in enclosed spaces, so as to avoid any excessively unpleasant odours.

INFORMATION ON HEALTH AND THE ENVIRONMENT

There is a safety data sheet available in the country-specific language for all questions related to the safety of our products.

SPECIFICATIONS

We can provide specifications and inspection certificates according to EN 10204 3.1 on request.

EXPLICIT RESTRICTIONS

Our products are not suitable for medical devices or for pharmaceutical applications and have not been tested for these uses. All applications must be tested and approved in advance.

LIMITATION OF LIABILITY

The information contained in this document is provided to the best of our knowledge on the basis of research carried out at tremco illbruck.

Because tremco illbruck does not have any influence over the type of use of the products and the conditions under which they are used, it is absolutely essential that tests are carried out before the products are used, even though you have this product information, in order to ensure that tremco illbruck's products are suitable for the customer's specific use with regard to performance, outcome and safety.

SERVICE

The tremco illbruck application technology department is at your disposal on +49 (0)2203 57550-600 at any time if required.

Subject to technical modifications.



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