



Art.-No.:6.5625.0050

**5625**

## 2K PU-Plastic Glue 1,5 min.

### Characteristics

4CR 5625 is a fast curing, easy to use structural 2-part polyurethane adhesive which cures by a chemical reaction of the two components forming a durable polymer resistant to elevated temperature, moisture, fuel, many solvents and chemicals.

5625 is specially designed for small, quick, durable bonding and repair jobs. The use of this adhesive yields a fast turnaround due to early sanding and painting capability.

5625 shows good sag resistance properties, allowing vertical application and offers excellent gap filling properties. In combination with a reinforcing mesh broken or missing bumper tabs can be rebuilt.

### Application

5625 adhesive system has been designed for ease of dispensing with both hand-held manual and pneumatic applicator tools. To assure an on ratio dispense we recommend levelling the pistons by placing the opened cartridge in the dispenser and purge till material starts to flow from both cartridge chambers prior to attaching the mixer. After attaching the mixer tip (we recommend to only use the mixer tips included in the package; additional mixer tips can be ordered) and loading the cartridge into the dispense tool, pull the trigger at a constant and steady rate to force both prepolymer and curative through the mixer tip. It is recommended to discard the first 25 to 50 mm of dispensed material as it may be off-ratio. Sufficiently mixed on-ratio adhesive has a uniform black colour, is creamy, smooth and glossy.

The material in the mixer will become very difficult or impossible to dispense at about one-half of the open time. Either keep material flowing through the mixer during short periods of time adhesive is not needed or replace the mixer prior restarting dispense.

After having finished dispensing, leave the mixer in place till 5625 shall be used again. The remainder of the adhesive will have a shelf life of several weeks if stored properly. To start using 5625 again, remove the static mixer and dispose of properly. Carefully clean the cartridge nozzle, the products in the two chambers must be cleanly separated. If there is any black-tan mixing on either side dispense some product out of the openings with no mixer tip attached, until only single component product resides in each chamber. Finally attach a new mixer and start dispensing.

### Technical Data

Chemical base I	Reactive Isocyanate Prepolymer (black)
Chemical base II	Reactive Polyol Mixture (white)
Specific Gravity [g/cm <sup>3</sup> ]	~1,45
Appearance	Sag Resistant Paste
Working Time (23°C)	1,5 Min.
Sanding Time (23°C)	10 min.
Clamp Time (23°C)	5 min.
Shore D Hardness (EN ISO 868)	63
Tensile Strength (EN ISO 527)	23 MPa
Young's Modulus (EN ISO 527)	420 MPa
Elongation at Break (EN ISO 527)	55 %



Glass Transition Temperature	65°C (ISO 11357)
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### Storage and Transportation

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Unopened containers stored at a dry place indoors at 15 – 32°C.

Shelf life: 12 months in the originally sealed cartridge.