

## Technical Data Sheet

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- Properties:** AKEPUR® 250 HIGH TACK is a creamy-soft, solvent-free 2-component adhesive based on PUR.
- The product is characterized by the following properties:
- high initial adhesion
  - very fast functional hardness
  - easy dosing and mixing by means of cartridge system
  - does not foam
  - good resistance to solvents
  - low shrinkage
  - can be painted
  - high bonding strength on metal, ABS, PVC, GRP, ceramic, natural and artificial stone
  - emission class A+ (confirmed by an external testing institute)
- Application Area:** AKEPUR® 250 HIGH TACK is mainly used for bonding of kitchen worktops, especially for substructures. For vertical and horizontal bondings in non-visible areas, also for corner connections in door and window areas. Steps made of ceramic can also be bonded with AKEPUR® 250 HIGH TACK.
- Instructions for Use:**
1. The surface must be clean, free of dust, completely dry and roughened.
  2. Remove the clasp from the cartridge and put the cartridge in the gun; work the grip until material emerges from both openings; then eventually screw up the mixing nozzle. Do not use the first 10 cm pressed out of the mixing nozzle.
  3. If used without mixing nozzle both components have to be thoroughly mixed.
  4. The mixture remains workable for approx. 3 - 4 minutes (20°C), after 20 - 25 minutes (20°C) the bonded parts may be moved, after 1 hour (20°C) they are resilient.
  5. The hardening process is accelerated by heat and delayed by cold. In summer we recommend cooling the product before processing in order to extend the processing time.
  6. Tools can be cleaned with AKEMI® Nitro-Dilution.
- Special Notes:**
- For professional use only.
  - Attention: component B contains diisocyanates. May cause an allergic reaction. As from August 24, 2023, adequate training is required before industrial or commercial use.
  - Exterior bondings affected by frost and moisture are not permanently resistant.
  - If damp or wet surfaces are bonded, the adhesive does not adhere well.
  - If absorbent materials, e.g. travertine, are to be bonded, special attention must be paid to dryness, otherwise the adhesive will not show good adhesion.
  - The maximum permissible air pressure when using the pneumatic gun recommended by AKEMI is 6 bar.
  - The optimal mechanical and chemical properties can only be attained by adhering to the exact mixing proportions and complete mixing; a surplus of component A or B has the effect of a plasticizer and may slowly result in discolouring in the contact area.
  - An adhesive which is already thickened or just gelling should not be used anymore.

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- Do not use the product at temperatures below 10°C because it will not sufficiently harden.
- The hardened adhesive tends to yellowing if it is permanently exposed to light and temperature.
- The hardened product can no longer be removed by solvents. Removal is only possible mechanically or by higher temperatures (> 200°C).
- For proper waste disposal the container must be completely emptied.
- Recycling in accordance with the guidelines of EU Decision 97/129 EC on the Packaging Directive 94/62/EC.

**Technical Data:**

Colours: white, black  
Density comp. A+B: approx. 1.54 g/cm<sup>3</sup>

Pot life at various temperatures:

10°C: 4 - 5 minutes  
20°C: 3 - 4 minutes  
30°C: 2 - 3 minutes

Hardening process (20°C, layer of 2 mm) Shore D hardness:

<u>0.5 hrs</u>	<u>1 hrs</u>	<u>2 hrs</u>	<u>24 hrs</u>	<u>7 d</u>
59	71	73	78	79

Tensile strength (DIN EN ISO 527): 20 - 22 N/mm<sup>2</sup>  
Bending strength (EN ISO 178): 40 - 44 N/mm<sup>2</sup>

**Storage:**

If stored in dry and cool condition (5-25°C/41-77°F) in its closed original container at least 12 months from production.

**Health & Safety:**

Read Safety Data Sheet before handling or using this product.

**Important Notice:**

The above information is based on the latest stage of development and application technology. Due to a multiplicity of different influencing factors, this information – as well as other oral or written technical advises – must be considered as non-binding hints. The user is obliged in each particular case to conduct performance tests, including but not limited to trials of the product, in an inconspicuous area or fabrication of a sample piece.