

DanBond P09

Fast-Curing Polyurethane Adhesive

DanBond P09 structural adhesive is high-strength, fast-curing, highly viscous, and can be sanded and painted over after approx. 30 minutes. It is weather resistant, resistant to chemicals and temperature resistant from -55°C to +125°C (-67 to +257°F) and has a very short pot life of around 240 seconds.

P09 can be used to bond numerous materials such as composite materials, plastics, polyurethane, epoxides, polyester, metals, wood and ceramics to themselves and among each other with high tensile, shear and peel strength.

DanBond P09 can be used in plastic technology, machine construction, model and mould making, metal construction, ship and boat building, carriage and vehicle construction, trade show and exhibition construction and in many other applications.

FEATURES:

- High-strength
- Fast-curing
- Highly viscous

Technical Data

Composition	Polyurethane
Colour	Black
Mixing ratio by weight (Resin / Hardener)	1:1
Density of the mixture	1,30 - 1,35 g/cm ³
Pot life at +20°C (+68°F)	4 min
Handling strength (35% strength) after	10 min
Capable of bearing mechanical loads (50% strength) after	30 min
Final strength (100%) after	12 h
Adhesive gap bridging	0,1 - 4,0 mm
Medium shear strength according to DIN EN 1465 at	
Aluminium	14 N/mm ²
Tensile strength ISO 527 max.	20 N/mm ²
Steel bright	23 N/mm ²
Stainless Steel	18 N/mm ²
Medium e-module +20°C (+68°F)	450 - 550 N/mm ²
Shore hardness D DIN EN ISO 868	68
Tensile Extension ISO 527 max	31 %
Thermoforming resistance	+65 °C
Temperature resistance	-55 to +125 °C

Surface pre-treatment

The prerequisite for perfect adhesion are clean and dry surfaces.

The highest strength values can be achieved through additional pretreatment of the surfaces, such as roughening using blasting or abrasive agents. Several plastics, in particular polyamide, Teflon®, polyolefin etc. can only be bonded after special surface treatment, for example using fluoridation, low-pressure plasma, corona, flame impingement etc.

Processing

DanBond P09 can be processed directly from the double cartridges with the help of the included static mixer. Reject the first 5 cm of the dosed bead. Apply adhesive to only one of the surfaces to be bonded. The pot life given is for a material quantity of 10 ml at room temperature. If larger quantities are used, the curing time will be faster. Similarly, higher ambient temperatures shorten the cure times (as a rule of thumb, every +10°C increase above room temperature will halve working and curing time).

Temperatures below +16°C will extend working and curing times considerably, while below about +5°C, no reaction will take place at all.

Storage

The shelf life is 18 months when stored unopened at a normal climate (+23°C and 50 % rel. humidity).

HANDLING PRECAUTIONS

Please refer to the relevant SDS (Safety Data Sheet) regarding the safe handling of this material.

Note: *All materials, whether innocuous or not, should be handled in accordance with the principles of good industrial hygiene.*

Further technical support or information may be obtained from

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