

ADHESIVE PRODUCTION PROGRAM



PRODUCT CATALOG

FOR REPAIRING RUBBER AND PVC BOATS
AUTOMOTIVE INDUSTRY



**PREMIUM
QUALITY**



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ADHESIVES FOR REPAIRING

rubber and pvc boats

CR 1000, PU 1000:





PRODUCT NAME:

CR 1000

TECHNICAL DATA

CR 1000 is contact adhesive based on special polymers.

APPLICATION:

CR 1000 is used to repair and maintain rubber boats.

TECHNICAL DATA:

Appearance	transparent yellow solution
Viscosity (ISO 2431, Ø8, 20°C), s	55 ± 5
Specific gravity (ISO 2811, 20°C), g/cm ³	1.38
Total solids (ISO 3251), %	min. 16.5
Flash point (ISO 3679), °C	non-flammable
Application	by brush
Consumption, g/m ²	300 – 500
Package	tin cans: 1 kg, 6 kg
Storage conditions	in original packaging, in a dark place, at temperature from 5°C to 25°C.
Storage life	4 years

INSTRUCTION FOR USE:

Surfaces to which the adhesive is applied must be prepared in advance. Rubber is sanded only to the extent that it is matte and not shiny. Sanded rubber is cleaned and degreased with a cleaning agent **INTERSOL NF**. The adhesive is prepared just before bonding by adding another component **HARDENER HTF (50g)** in the amount of 5% in relation to the adhesive and mixed well. Thus prepared adhesive is usable for 4h. We recommend applying the adhesive in two coats. The drying time for the first coat is 30 minutes and 10 to 20 minutes for the second, at a temperature of 20°C to 30°C. The surfaces to be bonded are pressed with rollers to make contact between them.



PRODUCT NAME:

PU 1000

TECHNICAL DATA

PU 1000 is a two-component contact adhesive based on polyurethane resin.

APPLICATION:

PU 1000 is used for the repair and maintain of PVC boats.

TECHNICAL DATA:

Appearance	homogeneous colorless solution
Viscosity (ISO 2431, Ø8, 20°C), s	35 ± 5
Specific gravity (ISO 2811, 20°C), g/cm³	0.88
Total solids (ISO 3251), %	min. 16
Flash point (ISO 3679), °C	< 0
Application	by brush
Consumption, g/m²	200 – 250
Package	tin cans: 700 g, 4 kg
Storage conditions	in original packaging, in a dark place, at temperature from 5°C to 25°C.
Storage life	2 years

INSTRUCTION FOR USE:

The adhesive is applied to both surfaces to be bonded. Surfaces must be cleaned and degreased with a cleaning agent **INTERSOL NF**. The second component **HARDENER HTF (40g)** is added to the adhesive immediately before use in an amount of 5% relative to the adhesive and mixed well. Thus prepared adhesive is usable for 4h. We recommend applying the adhesive in two coats. The drying time for the first coat is 30 minutes and 10 to 20 minutes for the second, at a temperature of 20°C to 30°C. Surfaces to be bonded are joined by pre-activating with heat. If an infrared lamp is used as the heat source, 1 minute is required for activation. Activation must be completed within a time interval of 6h from the moment the second component is added.



ADHESIVES FOR

automotive industry

CR 2000, PU 3000, CR 3000:



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PRODUCT NAME:
CR 2000

TECHNICAL DATA

CR 2000 is a contact adhesive based on special polymers.

APPLICATION:

The adhesive **CR 2000** is intended for the automotive industry for bonding the floor, car roof, and fenders of a car. A sponge, microporous rubber, or some other material is bonded to a metal surface.

TECHNICAL DATA:

Appearance	black homogeneous solution
Viscosity (ISO 2431, Ø4, 20°C), s	90 ± 10
Specific gravity (ISO 2811, 20°C), g/cm ³	0.89
Total solids (ISO 3251), %	min. 16
Flash point (ISO 3679), °C	> 0
Application	by spraying
Consumption, g/m ²	200 – 250
Package	tin cans: 800 g, 5 kg
Storage conditions	in original packaging, in a dark place, at temperature from 5°C to 25°C.
Storage life	1 years

INSTRUCTION FOR USE:

The adhesive is applied on both surfaces to be bonded. Application is done by spraying. The drying time of the adhesive is 10 to 20 minutes. It is necessary to apply two coats on porous materials. **INTERSOL NF** is used as a cleaning agent for car roof before the application of adhesive. We recommend the application of two coats to both surfaces for bonding the car roof to the sponge. Drying time depends on temperature and it needs to be adjusted to working conditions. Forced drying with industrial fans can also be used in order to shorten drying time. After drying, surfaces to be bonded are joined using the pressure necessary for the surfaces to touch. The bonded joint is resistant to water, oils, and elevated temperatures. The joint can withstand temperatures up to 110°C.





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PRODUCT NAME:
CR 3000

TECHNICAL DATA

CR 3000 is a contact adhesive basis on special polymers.

APPLICATION:

The adhesive **CR 3000** is used for bonding leather or some other porous material in the automotive or footwear industry. We recommend it for bonding leather to the steering wheel and car gear shift lever.

TECHNICAL DATA:

Appearance	yellow homogeneous solution
Viscosity (ISO 2431, Ø8, 20°C), s	55 ± 5
Specific gravity (ISO 2811, 20°C), g/cm³	0.84
Total solids (ISO 3251), %	min. 22
Flash point (ISO 3679), °C	< 0
Application	by brush
Consumption, g/m²	200 – 300
Package	tin cans: 700 g, 4 kg
Storage conditions	in original packaging, in a dark place, at temperature from 5°C to 25°C.
Storage life	1 years

INSTRUCTION FOR USE:

Adhesive **CR 3000** is suitable for application by brush on one or both surfaces to be bonded. The adhesive has good initial strength and a long open time. Good initial strength allows bonding materials a short time after application, and long open time allows correction of bonded materials without additional application of adhesive. For joints exposed to high temperatures, we recommend the addition of 5% of **HARDENER HT (40g)**. Thus prepared adhesive is usable for 4 to 6 hours.





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PRODUCT NAME:
PU 3000

TECHNICAL DATA

PU 3000 is a two-component contact adhesive based on polyurethane resin.

APPLICATION:

PU 3000 is used to bond leather or other material to the instrument panel in a car.

TECHNICAL DATA:

Appearance	homogeneous colorless solution
Viscosity (ISO 2431, Ø4, 20°C), s	95 ± 5
Specific gravity (ISO 2811, 20°C), g/cm ³	0.88
Total solids (ISO 3251), %	min. 14
Flash point (ISO 3679), °C	< 0
Application	by spraying
Consumption, g/m ²	200 – 400
Package	tin cans: 700 g, 4 kg
Storage conditions	in original packaging, in a dark place, at temperature from 5°C to 25°C.
Storage life	2 years

INSTRUCTION FOR USE:

The adhesive is applied by spraying both surfaces to be bonded. The viscosity of the adhesive is adjusted for application by spraying. Before use, 5% of **HARD-ENER HTF (40g)** is added to the adhesive. Thus prepared adhesive is usable for 4 hours. We recommend bonding at a temperature of 20°C to 30°C. **INTERSOL NF** is used as a cleaning agent for the instrument panel before the application of the adhesive. Surfaces on which the adhesive is applied can be joined immediately after application or later by heat activation. We recommend the activation by temperature. The temperature of activation is 40°C to 80°C. We recommend the application of two coats. The drying time for every coat is 20 min. An industrial fan can be used for activation. The bonded joint is resistant to elevated temperatures.



ADHESIVES for general consumption

CR 4000:





PRODUCT NAME:
CR 4000

TECHNICAL CHARACTERISTICS

CR 4000 is a universal contact adhesive based on special polymers.

APPLICATION:

The adhesive **CR 4000** is intended for bonding the wood, the plastic, the synthetic materials, the rubber, the cork, the leather, the felt, the hard PVC and the metal. It is not intended for bonding the soft PVC, the polyethylene, polypropylene and the silicone rubber.

TEHNIČKI PODACI:

Appearance	dark yellow homogeneous solution
Viscosity (ISO 2431, Ø4, 20°C), s	40 ± 5
Specific gravity (ISO 2811, 20°C), g/cm ³	0.79
Total solids (ISO 3251), %	min. 23
Flash point (ISO 3679), °C	> 0
Application	by brush
Consumption, g/m ²	250 – 400
Package	tin cans: 200 g, 700 g, 4 kg
Storage conditions	in original packaging, in a dark place, at temperature from 5°C to 25°C.
Storage life	2 years

INSTRUCTION FOR USE:

The adhesive is applied to both surfaces to be bonded. Application is done by brush. Drying time for the adhesive is 5 to 15 minutes. It is necessary to apply two coats on porous materials. The drying time depends on the temperature and it is necessary to adapt it to the working conditions. After drying, the parts are joined using the pressure required to touch the surfaces to be bonded. The adhesive is elastic and resistant to water,oil and elevated temperatures. It can withstand temperatures up to 110°C.





AUXILIARIES **and** **hardeners**

INTERSOL NF, HARDENER
HTF:





PRODUCT NAME:
INTERSOL NF

TECHNICAL DATA

INTERSOL NF is an organic product made on the basis of non-flammable solvents.

APPLICATION:

INTERSOL NF is used for cleaning rubber, textile and metal surfaces after sanding, before using adhesives **BSC 2000**, **BSC 2002**, **BSC 3000**, **BSC 4000**, **BSC 5000**, **BSC 6000** and **PRIMER SC**, as well as for cleaning and washing car instrument panel and car roof before application the adhesives **CR 2000** and **PU 3000**. It is also used as a cleaning agent before application the adhesives **PU 1000**, **CR 1000** and **PU 2000** for bonding pvc or rubber. It can also be used for washing brushes used for the application.

TECHNICAL DATA:

Appearance	pale-yellow liquid
Specific gravity (ISO 2811, 20°C), g/cm³	1,4
Flash point (ISO 3679), °C	non-flammable
Package	tin cans: 1kg, 6kg
Storage conditions	in original packaging, at temperatures up to 25°C.
Storage life	4 years

INSTRUCTION FOR USE:

Cleaning rubber, metal, and textile surfaces after sanding is done by using a suitable textile material soaked in **INTERSOL NF**. Brushes are washed every time immediately after applying the adhesive has been finished.





PRODUCT NAME:
HARDENER HTF

TECHNICAL DATA

HARDENER HTF is a solution of polyisocyanates. It is used as a crosslinking agent for adhesives.

APPLICATION:

HARDENER HTF is used to improve the temperature resistance and the speed of chemical reaction.

TECHNICAL DATA:

Apperance	light brown transparent liquid
Specific gravity (ISO 2811, 20°C), g/cm³	1
Flash point (ISO 3679),°C	-4°C
Boiling point	77°C
Package	glass bottles: 40g, 50g
Storage conditions	in original well-closed packaging, in a dry and dark place, at temperature from 5°C to 25°C.
Storage life	4 years

INSTRUCTION FOR USE:

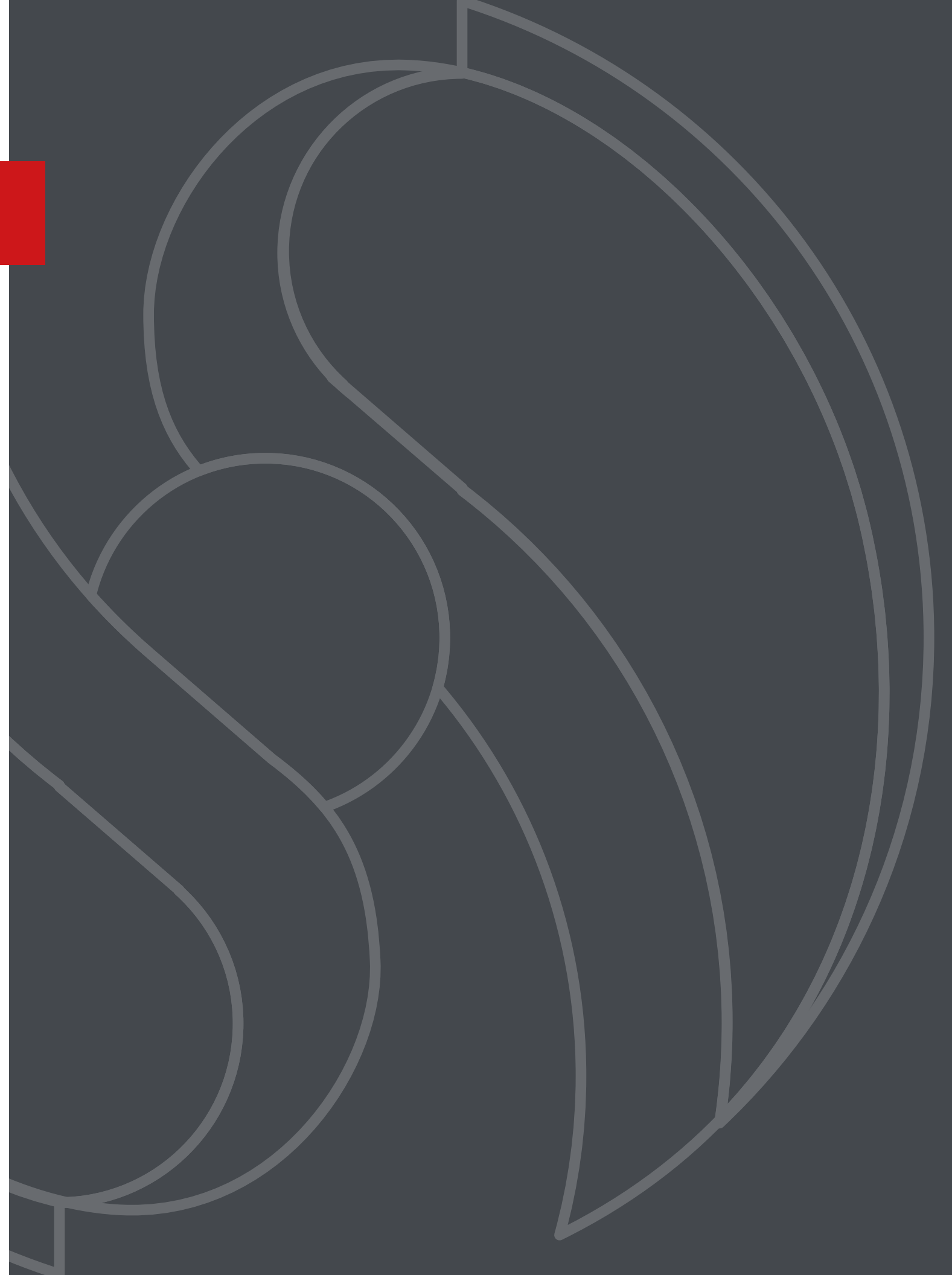
HARDENER HTF is added in the amount of 5%. After adding **HARDENER HTF**, it is necessary to homogenize the adhesive:

- by mixing with a glass stick in a container with adhesive or
- by shaking the sealed container with adhesive.

After adding **HARDENER HTF**, the adhesive is good to use for 4 hours.



Napomene/Notes:





interStik
adhesive solution



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