



TECHNICAL DATA

MITOPUR R2

Polyurethane solvent based contact adhesive

DESCRIPTION

MITOPUR R2 is polyurethane solvent based contact adhesive. It can be used as a one or as a two component adhesive. Joints are translucent, strong, elastic, water and temperature resistant from -20°C till +90°C. Better temperature resistance from -40°C till +120°C is reached by adding of hardener (Mitopur B7).

FIELDS OF APPLICATION

Adhesive is used for gluing of all types of PVC - hard PVC (pipes), soft PVC (artificial leather) and PVC foil. It is also used for gluing of natural leather, textile, hard and soft polyurethane foam, some types of rubber, synthetic resins etc. It is not suitable for gluing of polyethylene, polypropylene, Teflon, silicon rubber and polystyrene.

MITOPUR R2 is used in production and repairing of abrasive tapes and transport lines. It is also used for shoemaking, for repairing of textile or rubber tilts and in case where translucent, elastic, strong, water and temperature resistant joint is required. One component adhesive can be also used as a thermo activated coating. Gluing test is recommended before gluing.

CHARACTERISTICS

Chemical base	Mitopur R2: polyurethane prepolymer in solvent Mitopur B7: isocyanate
Mixing ratio:	Mitopur R2 (A): Mitopur B7 (B) = 8 to 10 :1 <ul style="list-style-type: none">• 20kg Mitopur R2+8x250g or 2x1,15kg Mitopur B7• 6x1kg Mitopur R2+3x250g Mitopur B7
Pot life for 100g adhesive (int. method 4/02)	minimum 5 hours (Mitopur R2:Mitopur B7=10:1)
Colour	Mitopur R2: yellowish, transparent Mitopur B7: brown
Viscosity (ISO 2555-Brookfield RVT Spindle 4 / 20 rpm, at 23°C)	Mitopur R2: 3000 – 7000 mPa s
Solid content ISO 3251	Mitopur R2: 21 - 23%

APPLICATION

Substrates to be bonded should be clean, dry, oil and dust free. Less demand joints can be glued using only Mitopur R2. Better water and temperature resistance can be reached by using of mixture of both components in mixing ratio by weight 80-100 parts of Mitopur R2 (component A) and 10 parts of Mitopur B7 (component B). Thinner MITOSOL 3905/E can be used for diluting adhesive Mitopur R2 if necessary. The pot life of the mixture in well closed tin is till 8 hours. Adhesive should be applied on both sides by brush, roller or notched trowel in thin layer in quantity 100 – 200 g/m² depend on roughness and porosity of gluing materials. Very porous materials should be coated twice within 5 to 10 minutes.

Application methods:

1. Cold gluing:

Apply the adhesive on both materials, dry it for 3 to 5 minutes. Stick the materials together and press them manually or by pressure from 3 to 5 bars by 1 minute.

If applied adhesive is completely dry, only hot gluing method for sticking is recommended.

2. Hot gluing:

a) Apply the adhesive on both materials, dry it for 10 to 30 minutes. Heat the materials for the half minute with warm air or IR lamp at the temperature from 80 to 90°C and immediately press them for 1 minute by pressure from 3 to 5 bars.

b) Apply the adhesive on both materials, dry it for 10 to 30 minutes. Stick the materials together and press them manually with hot iron or by pressure from 3 to 5 bars by 1 minute in 80 to 90°C warm press.

Before gluing under hot method check if materials are temperature resistant.

By using hot gluing method, stronger joint is achieved.

Attention:

Adhesive is flammable. Keep away from source of ignition. Local ventilation is recommended.
Before use testing of glued material is recommended.

PACKING

Mitopur R2 (component A) in metal tin:	20 kg, 1 kg and 220g
Mitopur B7 (component B) in metal tin:	25kg, 4,6kg, 1,15kg and 0,25kg

STORAGE

In well closed containers at the temperatures from 5°C to 25°C. Component B is very sensitive to moisture. The shelf life of the correctly stored component A is minimum 1 year. The shelf life of the component B is minimum 6 months.

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