

GPI-300 ADHESIVE

Description

GPI-300 is a two-component, solvent based, polyester urethane adhesive. It provides excellent adhesion in the bonding encapsulation of PVC to automotive glass.

Typical Properties (Not a Specification)

	<u>Part A</u>	<u>Part B</u>	<u>PartA&B</u>
Color	Bright Blue	Dark Reddish Brown	Green
Specific Gravity	0.96	1.13	0.98
Viscosity (#4 Ford cup)	12	28	15
Solids Content (%)	19	67	24
Mix Ratio (by wt.)	10 parts	1 part	A:B = 10:1
Pot Life (hrs @ 25C)	-	-	24

Application Instructions and Use Guidelines

Due to the settling nature of solid material in Part A, it is necessary to vigorously shake this component to re-suspend solid material prior to use.

A visual safeguard has been incorporated to ensure that the two components are mixed properly together prior to use. GPI-300 Part-A is bright blue in color, and Part-B is a dark reddish yellow color; upon mixing the two components together at their proper ratio of 10:1 by weight, the product turns to a green color to verify catalyzation.

Once the two components are mixed together, continuous stirring is necessary to avoid settling of solid material. If only a small quantity of material is mixed together for use (one quart or less) periodic shaking of the mixture prior to application of the adhesives is sufficient.

The glass substrate edges should be free from dust, dirt, grease, oil, release agents, or any other foreign matter. Apply the mixed GPI-300 adhesive to the edges of the glass to be encapsulated. Ensure that the complete area that will be covered by PVC receives adhesive.

The use of a hand-held, plastic squeeze bottle with a synthetic application pad attached to the opening works well. The use of daubers or cheesecloth will also perform the application adequately.

The GPI-300 adhesive should be applied at a wet film thickness of approximately 5 mils.



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The information contained herein is, to the best of our knowledge and belief, accurate. However, since the conditions of handling and of use are beyond our control, we make no guarantee of results and assume no liability for damages incurred by following these suggestions. Nothing contained herein is to be construed as recommendation for use in violation of any patents or of applicable laws or regulations.

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Adhesive Activation/Cure Cycle

Upon completion of the application of the adhesive to the glass, allow the wet adhesive to air dry for approximately 15 minutes. After the 15-minute air-dry cycle, subject the glass to a pre-heat cycle. Generally, the pre-heating is for approximately 1-3 minutes @ 200-300F. The conditions of the pre-heating depend on the size of the glass, cross-section of PVC, PVC injection temperature, mold temperature, and time in mold.

After pre-heating, place the glass in the mold and inject the PVC under your normal conditions.

Upon removal of the glass from the mold, handle with care during trimming operations, since full adhesion properties will be achieved upon the glass cooling.

Shelf Life

Twelve (12) months after date of manufacture, when stored at room temperature in original, unopened container.

Storage and Handling

Flammable liquid, keep away from heat, sparks, and open flame. Store in a cool, dry, well-ventilated area. Product is moisture sensitive.

See Safety Section for Safe handling instructions.

Safety Precautions

GPI-300 is for industrial use only.

Always use protective goggles, gloves, respiratory equipment, and appropriate work clothing when handling. Avoid eye and skin contact. Wash thoroughly after handling. Do not breathe vapors. Use with adequate ventilation. Refer to the Material Safety Data Sheets for more information.

Availability

GPI-300 is available in pre-measured, pre-proportioned 5-gallon kits. The product is shipped from our Versailles, Kentucky plant.



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