



<b>TECHNICAL CHARACTERISTICS</b>	
Tensile strength alu/alu	After 2 weeks: 15 kg/cm <sup>2</sup> After 2 weeks + 20 min 180°C: 20 kg/cm <sup>2</sup>
Solvent & isocyanate content	0%
Dry matter content	ca. 100%
Temperature resistance	-40°C - +90°C
Extremely good moisture resistance and not sensitive to frost	

<b>PACKING AND COLOURS</b>	
<b>25 cartridges of 290 ml/box - 48 boxes/pallet</b>	
White, black, grey (Ral 7004), dark brown (Ral 8016), beige (Ral 1001)	
<b>20 sausages of 600 ml/box - 45 boxes/pallet</b>	
White, black	

Other colours are available on request (75 cartridges or multiples).

## METHOD OF USE

### Preparation

The support must be fixed and rigid enough. The support may be slightly damp. The materials to be joined must be clean and free from dust and grease. If necessary, degrease using **Parasilico Cleaner**, MEK, alcohol, or ethanol.

### Primers

For strongly absorbent supports it is recommended to use **DL 2001 Primer**. It is advisable to do bonding tests. It is the user's responsibility to check whether the product is suitable for his application. Our technical department could be consulted.

### Application

- Apply **Parabond 600** with the supplied nozzle in strips or dots to the base or on the element to be bonded. The strips must be applied in vertical rows. Apply the strips parallel to each other, to allow the humidity to reach the adhesive between the strips.
- Bring together the parts to be joined as quickly as possible, at least within 10 minutes (this depends on the temperature and relative humidity level). The parts can at this stage still be adjusted
- Finally, push down one over the other well or tap with a rubber hammer.
- It is advised to have a gap of 3.2 mm between the parts to be bonded spacer blocks or pieces of foam tape may be used), to allow the adhesive to smooth out any distortions (especially important in exterior use or under humid conditions).
- The internal strength of **Parabond 600** immediately after application is such that bonding is possible without clamping or temporary support.

### Tooling

If desired, smooth finishing can be done using **DL 100** or **rubber stripper**.

### Cleaning

Any adhesive that may protrude along the edges can be removed using a stopping knife. Adhesive residue that has not yet dried, can be removed using **Parasilico Cleaner**. Dried adhesive must be removed mechanically.

### Painting

Paintable with most water and solvent based paints. Can be painted wet on wet. After 48 hours, the surface must be cleaned first before it can be painted. Pre-testing is necessary. Alkyd paints require an extended drying time.

## SAFETY

Please refer to safety data sheet which is available on request.

## LIMITATIONS

- Joints that are exposed to constant submersion under water and rooms with permanent high relative humidity
- Joints with a width or depth < 5 mm
- Gluing PE, PP, PA and Teflon®.
- On bituminous surfaces : use our **Paraphalt** for this purpose
- On polycarbonate and polyacrylate: Use our **Parasilico PL** for this purpose

This technical data sheet replaces all previous editions. The data on this sheet have been compiled according to the last laboratory report. Technical characteristics can be changed or adapted. We are not responsible for any incomplete information. Before use, one needs to ensure that the product is suitable for his application. Therefore, tests are necessary. Our general conditions apply.

## TECHNICAL APPROVALS

IKI-report for the use in hospitals as glue and adhesive for wall panels.  
Leeds certificate for low VOC (tested by Eurofins)



\* Information sur le niveau d'émission de substances volatiles dans l'air intérieur, présentant un risque de toxicité par inhalation, sur une échelle de classe allant de A+ (très faibles émissions) à C (fortes émissions).

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