

PRODUCT INFORMATION

Insulating Glass-Sealant GD 677 with pasty B-component



Special sealing compound for the manufacturing of insulating glass units

- Excellent adhesion to clean surfaces such as glass, aluminium and galvanized or stainless steel
- Good adhesion to many kinds of plastics
- Low water vapour transmission rate

TECHNICAL DATA

Base	A-component: Polyurethane B-component: Isocyanate		
Colour – Mixing	Black		
Consistency	Paste		
Mixing ratio			
- accd. to volume	A-component : B-component = 10 : 1		
- accd. to weight	A-component : B-component = 10 : 0,64		
Density			
A-component	approx.	1.72 g/cm ³	
B-component	approx.	1.10 g/cm ³	+23 °C
Pot life	approx.	30 min	+23 °C
Peel resistance	>	3,5 N/mm ¹⁾	
Tear resistance	>	0,7 N/mm ²⁾	
Hardness Shore A	>	35	EN 1279.6, annex E and Kö-Norm 100039 at standard climate 23/50
Adhesion floatglass		0.36 ³⁾ N/mm ²	EN 1279.4, annex A
Water vapour transmission rate	<	4 g/m ² •d	EN 1279.4
Gas permeation (Ar)	<	0,05 g/m ² •h	EN 1279.4
Volatile elements	<	1 %	EN 1279.6, annex G
Fogging	Without visual fogging		EN 1279.6, annex C
¹⁾ Kö-Norm 100086, 24 h at standard climate 23/50, aluminium / glass ²⁾ Kö-Norm 100075, 7 d at standard climate 23/50, glass / glass ³⁾ average value			

PROCESSING

Preparation

The joint flanks or surfaces to be bonded must be dry, clean and free of dust or grease. As cleaning agent we recommend **Körasolv GL**, unless washing machines or other tested, residue-free agents are available.

Preparing the mixture

When using automatic mixers observe the correct setting of the dosing cylinder. The mixing ratio according to volume is 10 : 1.

The two-component mixture must be applied within the indicated pot-life. At a higher temperature the pot-life is shorter. Prepare only the amount that can be applied within this period of time.

Rule of thumb

30 min. pot-life at +20 °C material temperature
 15 min. pot-life at +30 °C material temperature
 8 min. pot-life at +40 °C material temperature

Mixing tolerance: ± 10 %

GD 677 WITH PASTY B-COMPONENT

Curing

GD 677 should not be applied below +10°C. The curing speed of GD 677 basically depends on the storage temperature of the units fabricated with this sealant.

At +10°C the curing times double or triple; at +30°C they are shortened by approx. 50 %. A tack-free surface is reached at approx. +23°C after about 5 hours.

CLEANING

For cleaning the surfaces to be bonded: **Körasolv GL**

For cleaning tools and removing fresh stains: **Körasolv GL**

SPECIAL NOTES

Storage

Store cool, dry and in tightly closed containers. The shelf-life is approx. 9 months.

SAFETY

Please notice the indications on our EC-safety-data-sheets and the safety-indications on the labels of each product for the treatment of our products.

Especially the directions of the Dangerous Substance Regulation have to be respected.

Keep the EC-safety-data-sheet of the product you treat ready to hand. It gives you valuable indications for the safe usage, disposal and in case of accidents.

PACKAGING UNITS

A-component:

200 l drum

B-component:

20 l hobbcock

200 l drum

For safety related data please refer to the safety data sheet!

Please note: All given data are based on careful examination in our laboratories and our past practical experience. These are non-binding indications. Given the high number of materials appearing on the market and the different methods of use which are beyond our influence and control, we naturally cannot accept any responsibility for the results of your work, also with regard to third party patent rights. We recommend that sufficiently thorough tests be carried out to ascertain whether the product described will meet the requirements of your particular case. Please also note our Terms of Sale, Delivery and Payment. This product information replaces all previous issues.



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