

CROMOBOND XL

Two component frame adhesive

► Description

CROMOBOND XL is a fast drying, two component frame adhesive with excellent chemical resistance and adhesion to all commonly used screen frames.

► Application

1. Frame preparation

Before adhering the mesh with **CROMOBOND XL**, remove excessive adhesive residue from the frame with **PREGATEX DL**, grinding or sandblasting. Be careful not to roughen the frame surface too much, as this could impair the adhesion of the adhesive. Frames should be free from oil, grease, dirt, water and solvents before applying the adhesive. Slight residues of **CROMOBOND XL**, however, do not need to be removed. The surface should be even.

If the frame surface is slightly uneven or has deeper grooves from sandblasting or grinding a pre-coat of **CROMOBOND XL** with hardener can be used to even the surface.

2. Mixing the adhesive

Before use, mix 100 weight parts **CROMOBOND XL** with 20 weight parts of **HARTER XL**. For higher solvent resistance and for pre-coating of the frame, the ratio of hardener can be increased. However, when increasing the amount of hardener the adhesive becomes more brittle.

3. Applying the adhesive

Using pressure apply the adhesive with a short bristle brush or scraper-type applicator onto the bonding area of the mesh. Make sure that a sufficient amount of adhesive is worked through the mesh and obtains contact with the frame. Bubbles showing through the mesh indicate poor contact between mesh and frame.

4. Curing / Drying time

The adhesive dries in about 10-20 minutes depending on application thickness and room temperature.

After approximately 10-20 minutes the frame can be cut away from the stretching unit.

After 3-4 hours the adhesive is relatively resistant to solvents and water and over lacquering or degreasing is possible. The complete chemical resistance is achieved after 24 hours.

► Personal Protection / Safety

CROMOBOND XL and **HARTER XL** are highly flammable. Keep away from sources of ignition.

DO NOT SMOKE. Do not breathe fumes. Working areas must be well ventilated. Wear chemical-splash eye goggles and protective gloves. Use respiratory protection if exposure limits are exceeded. See Material Safety Data sheet for additional information.

► ENVIRONMENTAL PROTECTION

Do not empty into drains. Completely hardened and dried adhesive can be eliminated as non-hazardous solid waste. Consult your local authorities for local regulations.



► Physical Properties

Cleaning:	uncured: acetone
Cured:	PREGATEX DL
Color:	CROMOBOND XL: clear
Pot Life:	40 - 90 minutes in open containers
Shelf life:	1 year at 68°F, 20°C
Flash point:	CROMOBOND XL: -18°C, 0°F HARTER XL: -4°C, 25°F
TLV:	750 ppm Acetone 400 ppm Ethyl Acetate
HMIS rating:	health - 2 flammability - 4 reactivity - 1
Packaging:	900 grs set: CROMOBOND XL (750 grs) + HARTER XL (150 grs)

Information with regard to the safety: consult the safety leaf. **We have the right to modify the product and the technical leaf.** If you want more information and technical assistance, please put in touch with our technical department.

Our technical assistance to the client, by telephone or personally, is effected by tests in the practice and in our laboratory. Anyhow, we do not take any commitment, possible rights of protection to thirds included. This service does not exempt the user to examine our products as for its suitability for the procedures and wished purposes. Provided that the utilization, the application and treatments realized with our products are out of our control, the user assumes all the responsibility.