

DINITROL PVC PA 283 02

Heat-curing PVC epoxy adhesive and sealant

DINITROL PVC PA 283 02 is a solvent-free, 1-component, cold-applied and heat-curing adhesive and sealant based on PVC epoxy. It serves as a seam sealant between sheet-metal butt joints and overlap joints (internal and external seams) on vehicle bodies, steel structures, machine components and add-on parts, for example.

The product is used before powder coating and cures with the lacquer in the oven.



» No need to pregel the product before powder coating

» Ideal for applications before powder coating

» Solvent-free

» Fast further processing

» OEM approval



Equipment

DINITROL MASTER TOOL
310 ml Cartridge & 600 ml Foilwrap
Art. No. 1736500

DINITROL MASTER TOOL
310 ml Cartridge & 400 ml Foilwrap
Art. No. 1736600

INDUSTRIAL NITRILE GLOVES XL 10-P
Art. No. 1734100

DINITROL PVC PA 283 02

Art. No.	Size	Package	Color
16402	600 ml	Foil wrap	Grey
12324	25 kg	Pail	Grey

DINITROL PVC PA 283 02

Technical Details

Product description

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Features

- No need to pregel the product before powder coating
- Ideal for applications before powder coating
- Solvent-free

- Fast further processing
- OEM approval

Instructions for use

The workpieces to be sealed are usually pretreated in a cleaning/degreasing system before powder coating. This means that no further cleaning or mechanical treatment of the workpieces is required before sealing with DINITROL PVC PA 283 02. The nozzle tip should be cut to size depending on the intended application. Apply with a suitable compressed-air or battery gun (if used from hobbocks, please contact DINOL).

When applying the product, excess material (e.g. in the edge area) should be avoided as far as possible.

The adhesive bead should be applied in one stroke to avoid air pockets when applying. Do not use chemical

smoothing agents for smoothing, only smooth with a disposable glove, spatula or brush and sufficient pressure. Sealing must be carried out as the last work step before powder coating, as the sealant does not achieve washout resistance without the addition of heat.

In order to ensure optimum adhesion, the coating with powder coatings should take place as soon as possible after the sealant has been applied (max. 16 hours open time at 23 °C and 50% RH). Preliminary tests are required!

The sealant changes to a force-elastic, mechanically resilient state from an oven temperature of approx. 160 °C. The bonding and sealing of oiled substrates (common corrosion-protection and deep-drawing oils, approx. 3 g/m²) is possible due to the oil absorption during heat curing.

Technical Data

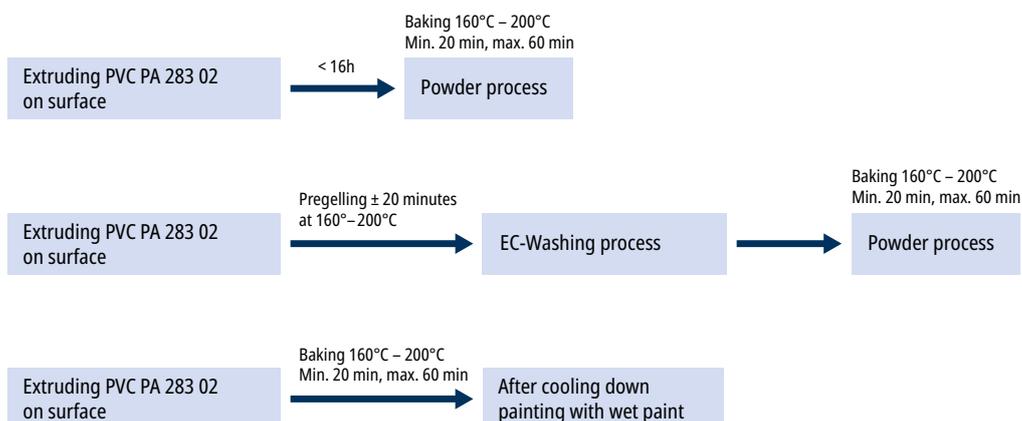
Colour	Grey, RAL 7004	
Consistency	homogenous paste	
Density	1.50 – 1.56 g/ml	
Shore A hardness	Tile: 25 x 80 x 6 mm / 30' 185°C	53 – 55 Shore A
Non-sag properties	Substrates: Zn/Ni – electro-galvanized steel	
	Rope ø 12 mm	0 mm
	10'70°C + 20'150°C + 30'170°C	0 mm
Rheology (flow)	Parameters:	
	Temperature	20°C
	Diameter	2,6 mm
	Pressure	1,4 bar
Result	30 – 50 seconds/ 20 g	
Shear strength	Substrates: Zn/Ni – electro-galvanized steel	
	25'150°C	2,0 MPa, cohesive break
	25'150°C + 30'180°C	2,1 MPa, cohesive break
	60'200°C	2,2 MPa, cohesive break
Available in	600 ml Foil wrap / 25 kg Pail	

Storage

DINITROL PVC PA 283 02 must be stored in a closed container, in a dry and ventilated area at temperatures between 10 °C and 30 °C. The shelf life is 12 months for the foil wraps and 6 months for the pails. Do not expose to direct sunlight. Avoid contact with water. For additional information, please consult DINOL.

For all relevant safety advices please read the material safety data sheet or the packaging label.

Hazards identification
2.1. Classification of the substance or mixture
 GB CLP Regulation
 Skin Irrit. 2; H315; Eye Dam. 1; H318; Skin Sens. 1; H317; Aquatic Chronic 2; H411



All data and recommendations are the result of careful tests by our laboratory. They only can be considered as recommendation which corresponds to the level of experience of today. The data are given in good faith. However, in view of the multiplicity of possible application and working methods we are not in a position to assume any responsibility or obligations deriving from the misuse of our products. Therefore, a contractual legal relationship is not justified, and there are no secondary obligations arising from any purchase contracts.