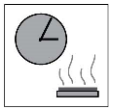
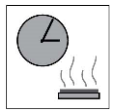
Prep M /Prep CS

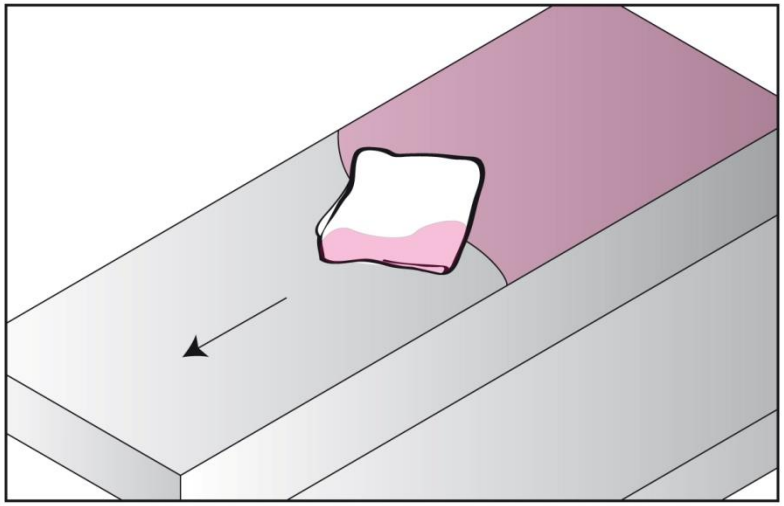

Wipe on in one direction to avoid spreading the contamination of the surface



5 to 20 minutes open time / evaporation time needed

Use of a colourless and fluff free cloth

If the surface of the to be bonded materials are heavy contaminated , cleaning of surface with Simson Cleaner I will be strongly recommended (see recommendation Simson Cleaner I)



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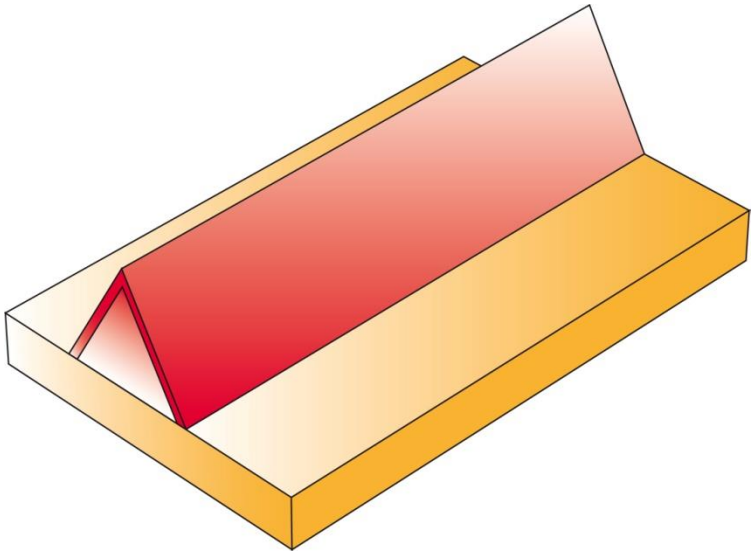
Skin formation



Skin formation time is the time between applying the bead and the elastic skin formation on top of the adhesive or sealant

Skin formation can be brittle. So the open time of an adhesive or sealant can be slightly longer than the skin forming time

check possible attack of the substrate by Liquid 1.

Technical data

Basic material	Silyl Modified Polymer (SMP)	
Curing method	moisture	
Specific gravity	ca. 1.5 g/ml	
Skin forming time	ca. 15 min.	(20°C/50% R.H.)
Open time	< 15 min.	(20°C/50% R.H.)
Curing speed after 24 hrs	ca. 3 mm	(20°C/50% R.H.)
Shore A hardness	ca. 60	(DIN 53505)
Volume change	< 3%	(DIN 52451)
Tensile stress (100%)	ca. 2.3 MPa	(DIN 53504/ISO 37)
Tensile stress at break	ca. 2.9 MPa	(DIN 53504/ISO 37)
Elongation at break	ca. 250%	(DIN 53504/ISO 37)

To have a high and durable bonding application the two materials needs to be pressed together within the skin formation time. This info can be find on the TDS belonging to the product.

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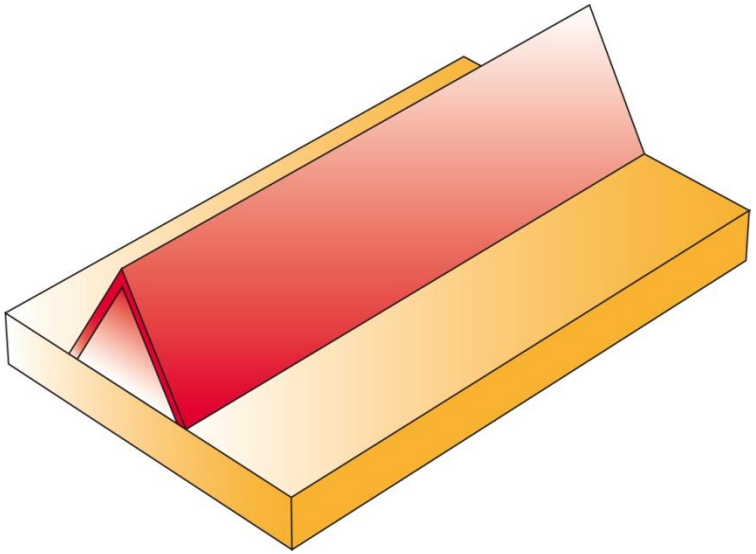
Open time



The open time of an adhesive or sealant is the maximum time in with the bonding or sealing application has to be carried out

check possible attack of the substrate by Liquid 1.

Technical data

Basic material	Silyl Modified Polymer (SMP)	
Curing method	moisture	
Specific gravity	ca. 1.5 g/ml	
Skin forming time	ca. 15 min.	(20°C/50% R.H.)
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Bostik
smart adhesives

SIMSON ISR 70-03 sskf

SILYL MODIFIED POLYMER

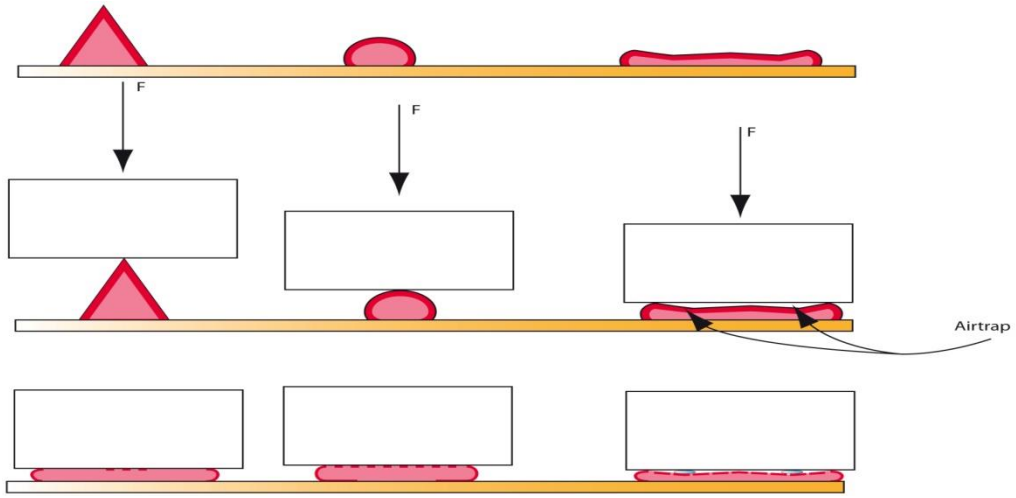
High quality and durable sealing of bonding application:

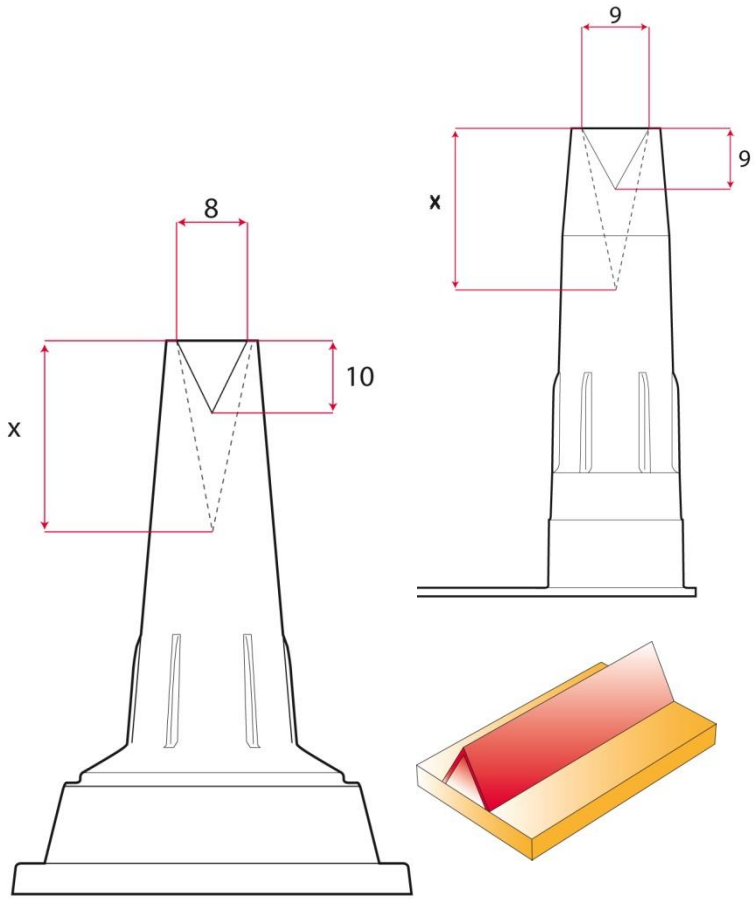
To have a high and durable bonding application the two materials need to be pressed together within the open time of the adhesive. A high and durable sealing needs to be finished before skin formation starts. You can find this information on the TDS of the product in use

Back to general information

Why a triangle bead

- To create the best wetting on both materials surfaces
- To have no air in closers in the adhesive bead
- To avoid high pressure needed during the bonding application
- To create the longest open time
- To avoid skin forming in the adhesion zone of the bond line





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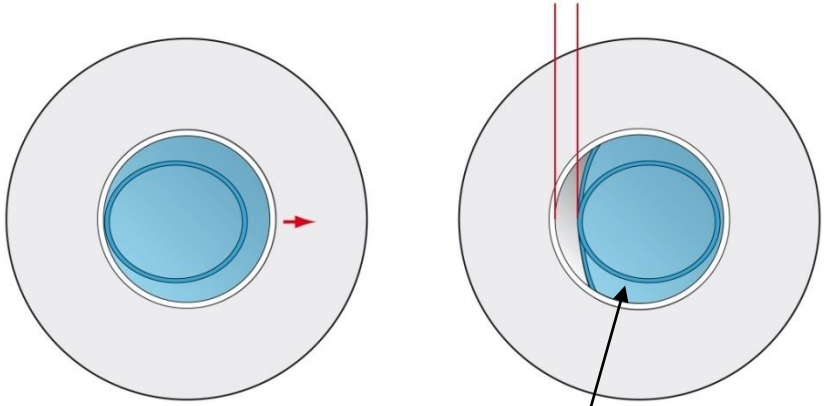
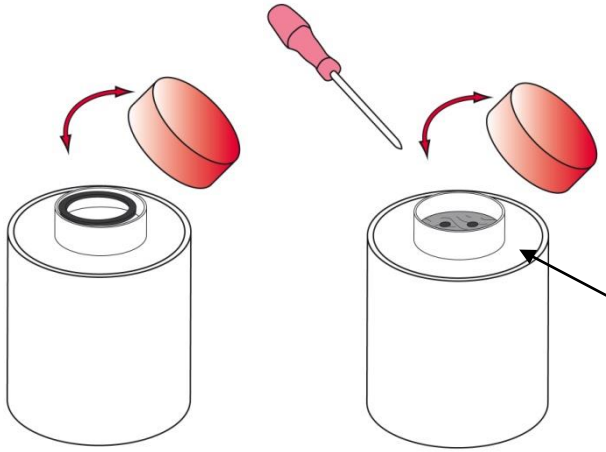
- To avoid fast ageing and contamination of the Simson Prep products
- To avoid evaporation and downgrading of the quality of Simson Prep products
- To improve the environmental conditions in the production line
- To improve the air quality as much as possible
- To reduce the cost per application
- And many more issue to mention

We advise you to take off the cap and perforate the foil with a piercer, as shown in the drawings.



open the plastic closer or stopper only for a few millimetres



Two different packaging's are sold today

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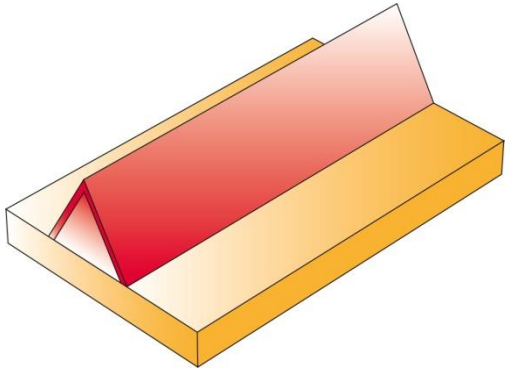
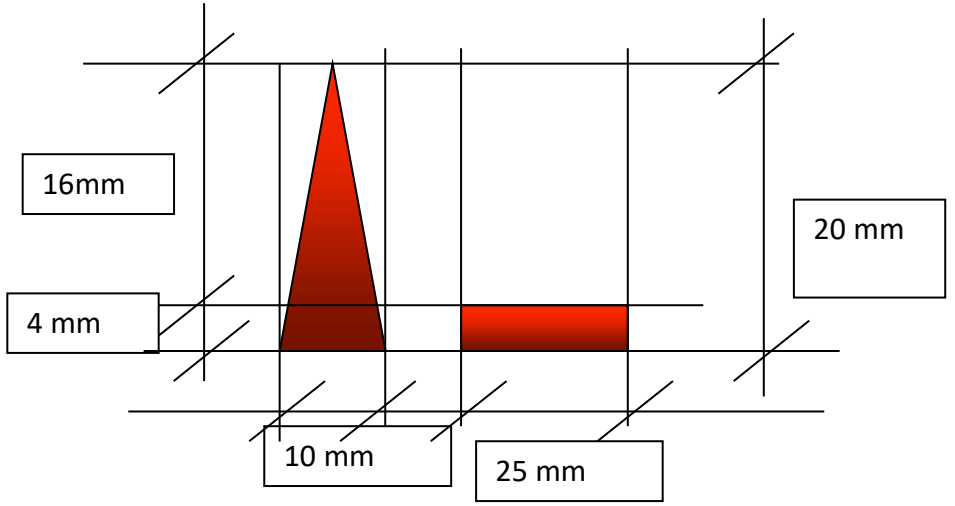
Recommended triangle bead sizes





To have a high-quality and durable bonding application, Bostik advises to create a triangle bead that is 5 times as high as the thickness of the final adhesive layer
The width of the of the triangle needs to be around 50% of the final width of the bond

For example: we need an adhesive layer of 25 mm wide and 4 mm high
Bostik advises a triangle bead of 20 mm high and 10 mm wide

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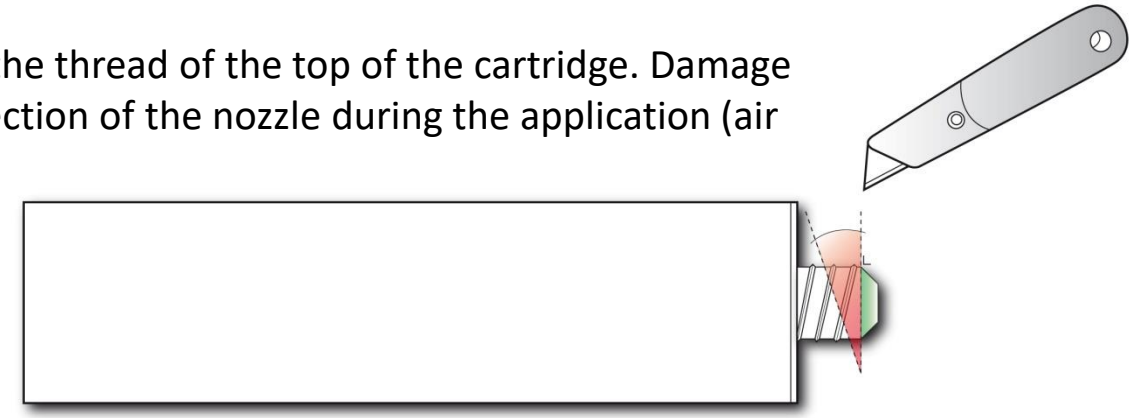
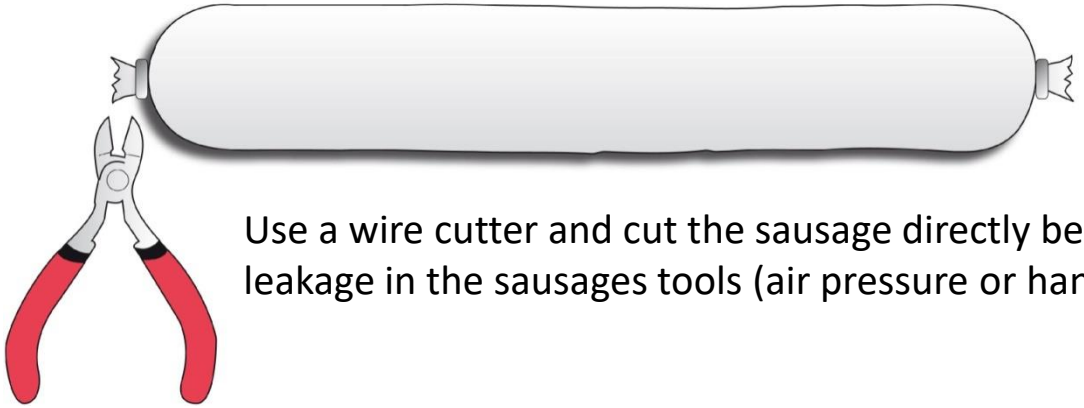
Use a sharp cutting knife and don't damage the thread of the top of the cartridge. Damage can cause leakage or can create a bad connection of the nozzle during the application (air pressure or hand pressure)





Use a wire cutter and cut the sausage directly behind the clip damaging of the foil can create leakage in the sausages tools (air pressure or hand pressure)

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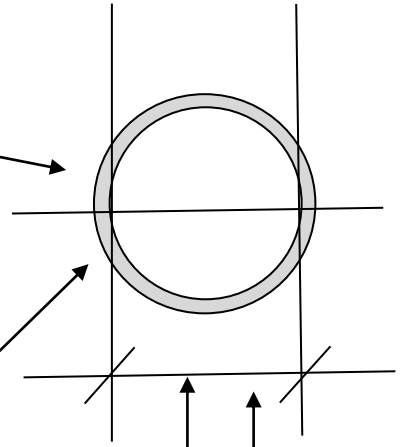
Min and max diameter of pneumatic and hand pressed adhesive guns



50.20 mm < ---- > 51,10 mm

1.976 inch <-----> 2,0118 inch

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Calculation usage SMP products in cartridges and sausages

usage of adhesives 290 ml	width of the bead [mm]			version : 10-02-2004		
thickness of bead [mm]	5	10	15	20	25	30
2	29,00	14,50	9,67	7,25	5,80	4,83
3	19,33	9,67	6,44	4,83	3,87	3,22
4	14,50	7,25	4,83	3,63	2,90	2,42
5	11,60	5,80	3,87	2,90	2,32	1,93
6	9,67	4,83	3,22	2,42	1,93	1,61
7	8,29	4,14	2,76	2,07	1,66	1,38
8	7,25	3,63	2,42	1,81	1,45	1,21
9	6,44	3,22	2,15	1,61	1,29	1,07
10	5,80	2,90	1,93	1,45	1,16	0,97
Meter of Applications per cartridges 290 ml						

usage of adhesives 600 ml	width of the bead [mm]			version: 10-02-2004		
thickness of bead [mm]	5	10	15	20	25	30
2	60,00	30,00	20,00	15,00	12,00	10,00
3	40,00	20,00	13,33	10,00	8,00	6,67
4	30,00	15,00	10,00	7,50	6,00	5,00
5	24,00	12,00	8,00	6,00	4,80	4,00
6	20,00	10,00	6,67	5,00	4,00	3,33
7	17,14	8,57	5,71	4,29	3,43	2,86
8	15,00	7,50	5,00	3,75	3,00	2,50
9	13,33	6,67	4,44	3,33	2,67	2,22
10	12,00	6,00	4,00	3,00	2,40	2,00
Meter of Applications per sausages of 600 ml						

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Bead sizes calculated out of triangle beads

Bead applied out of different sizes of traingles					
pressed sizes after bonding application					
Height 6 mm and width 5 mm	1 mm x 15 mm	2 mm x 7,5 mm	3 mm x 5 mm		
Height 8 mm and width 8 mm	1 mm x 32 mm	2 mm x 16 mm	3 mm x 10 mm	4 mm x 8 mm	
Height 9 mm and width 9 mm	1 mm x 40,5 mm	2mm x 20 mm	3 mm x 13,5 mm	4 mm x 10 mm	
Height 10 mm and width 12 mm	1mm x 60 mm	2 mm x 30 mm	3 mm x 20 mm	4 mm x 14 mm	5 mm x 12 mm
Height 8 mm and width 12 mm	1 mm x 48 mm	2 mm x 24 mm	3 mm x 16 mm	4 mm x 12 mm	
Height 10 mm and width 15 mm	1 mm x 75 mm	2 mm x 37,5 mm	3 mm x 25 mm	4 mm x 19 mm	5 mm x 15 mm
most common traingles and beads in industrial and marine applications					

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