

ADHESIVE PRODUCTION PROGRAM



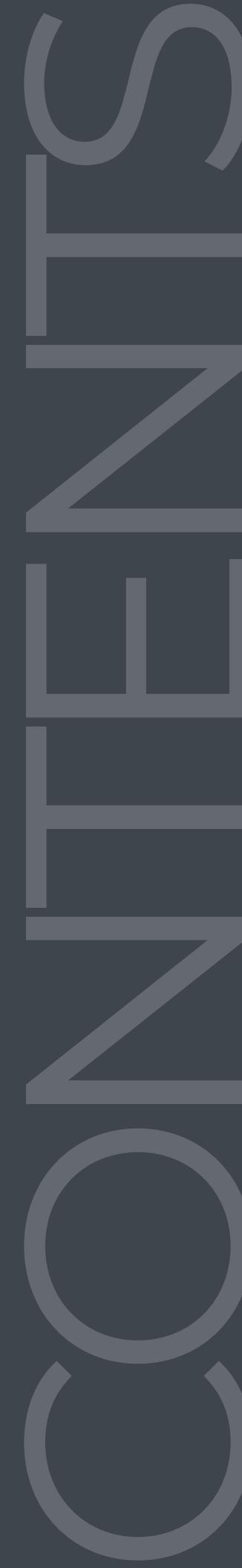
PRODUCT CATALOG

FOR REPAIRING RUBBER AND PVC BOATS
AUTOMOTIVE INDUSTRY



interStik
adhesive solution

PREMIUM
QUALITY



**PREMIUM
QUALITY**

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ADHESIVES FOR REPAIRING
**rubber and
pvc boats**

CR 1000, PU 1000:



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PRODUCT NAME: **CR 1000**

TECHNICAL DATA

CR 1000 is a contact adhesive based on special polymers.

APPLICATION:

CR 1000 is used to repair and maintain rubber boats.

TECHNICAL DATA:

Appearance	transparent yellow solution
Viscosity (ISO 2431, Ø8, 20°C), s	55 ± 5
Specific gravity (ISO 2811, 20°C), g/cm ³	1.38
Total solids (ISO 3251), %	min. 16.5
Flash point (ISO 3679), °C	non-flammable
Application	by brush
Consumption, g/m ²	ranging from 300 – 500
Package	tin cans: 1000 g; 6 kg
Storage conditions	in the original packaging in a dark place at a temperature ranging from 5°C to 25°C.
Storage life	4 years

INSTRUCTION FOR USE:

Surfaces to which the adhesive is applied must be prepared in advance. Rubber is sanded only to the extent that it is matte and not shiny. Sanded rubber is cleaned and degreased with a cleaning agent **INTERSOL NF**. The adhesive is prepared just before bonding by adding another component **HARDENER HTF (50g)** in the amount of 5% relative to the adhesive and mixed well. Thus prepared adhesive is usable for 4h. We recommend applying the adhesive in two coats. Drying time for the first coat is 30 minutes and 10-20 minutes for the second, at temperature of 20°C-30°C. The surfaces to be bonded are pressed with rollers to make contact between them.



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PRODUCT NAME: **PU 1000**

TECHNICAL DATA

PU 1000 is a two-component contact adhesive based on polyurethane resin.

APPLICATION:

PU 1000 is used for the repair and maintenance of PVC boats.

TECHNICAL DATA:

Appearance	homogeneous colorless solution
Viscosity (ISO 2431, Ø8, 20°C), s	35 ± 5
Specific gravity (ISO 2811, 20°C), g/cm ³	0.88
Total solids (ISO 3251), %	min. 16
Flash point (ISO 3679), °C	< 0
Application	by brush
Consumption, g/m ²	ranging from 200 – 250
Package	tin cans: 700 g; 4.0 kg
Storage conditions	in the original packaging in a dark place at a temperature ranging from 5°C to 25°C.
Storage life	2 years

INSTRUCTION FOR USE:

The adhesive is applied to both surfaces to be bonded. Surfaces must be cleaned and degreased with a cleaning agent **INTERSOL NF**. Second component **HARDENER HTF (40g)** is added to the adhesive immediately before use in an amount of 5% relative to the adhesive and mixed well. Thus prepared adhesive is usable for 4h. We recommend applying the adhesive in two coats. Drying time for the first coat is 30 minutes and 10-20 minutes for the second, at temperature of 20°C-30°C. Surfaces to be bonded are joined by pre-activating with heat. If an infrared lamp is used as the heat source, 1 minute is required for activation. Activation must be completed within a time interval of 6h from the time the second component is added.



ADHESIVES FOR
automotive
industry

CR 2000, PU 3000, CR 3000
Intersol NF, Hardener HTF:



PREMIUM
QUALITY



PRODUCT NAME: **CR 2000**

TECHNICAL DATA

CR 2000 is a contact adhesive made on the basis of special polymers.

APPLICATION:

The adhesive **CR 2000** is intended for the automotive industry for bonding the floor, roof linings, and fenders of a car. A sponge, microporous rubber, or some other material is bonded to a metal surface.

TECHNICAL DATA:

Appearance	black homogeneous solution
Viscosity (ISO 2431, Ø4, 20°C), s	90 ± 10
Specific gravity (ISO 2811, 20°C), g/cm ³	0.89
Total solids (ISO 3251), %	min. 16
Flash point (ISO 3679), °C	< 0
Application	by spraying
Consumption, g/m ²	ranging from 200 – 250
Package	tin cans: 800 g; 5.0 kg
Storage conditions	in the original packaging in a dark place at a temperature ranging from 5°C to 25°C.
Storage life	1 years

INSTRUCTION FOR USE:

The adhesive is applied on both surfaces to be bonded. Application is done by spraying. Drying time of the adhesive is 10-20 minutes. It is necessary to apply two coats on porous materials. It is used **INTERSOL NF** as a cleaning agent for car roof before application of adhesive. We recommend the application of two coats to both surfaces for bonding car roof to sponge. Drying time depends on temperature and it needs to be adjusted to working conditions. Forced drying with industrial fans can also be used in order to shorten drying time. After drying, surfaces to be bonded are joined using pressure necessary for the surfaces to touch. Bonded joint is resistant to water, oils and elevated temperatures. The joint can withstand temperatures up to 110°C.



PREMIUM
QUALITY



PRODUCT NAME: **CR 3000**

TECHNICAL DATA

CR 3000 is contact adhesive made on basis of special polymers.

APPLICATION:

The adhesive **CR 3000** is used for bonding leather or some other porous material in the automotive or footwear industry. We recommend it for bonding leather to the steering wheel and car gearbox.

TECHNICAL DATA:

Appearance	yellow homogeneous solution
Viscosity (ISO 2431, Ø8, 20°C), s	55 ± 5
Specific gravity (ISO 2811, 20°C), g/cm ³	0.84
Total solids (ISO 3251), %	min. 22
Flash point (ISO 3679), °C	< 0
Application	by brush
Consumption, g/m ²	ranging from 200 – 300
Package	tin cans: 700 g; 4.0 kg
Storage conditions	in the original packaging in a dark place at a temperature ranging from 5°C to 25°C.
Storage life	1 years

INSTRUCTION FOR USE:

Adhesive **CR 3000** is suitable for application by brush on one or both surfaces to be bonded. The adhesive has good initial strength and a long open time. Good initial strength allows bonding materials after a short time after application, and long open time allows correction of bonded materials without additional application of adhesive. For joints exposed to high temperatures, we recommend the addition of 5% of **HARDENER HT (40g)**. Thus prepared adhesive is usable for 4-6 hours.



PREMIUM
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PRODUCT NAME: **PU 3000**

TECHNICAL DATA

PU 3000 is a contact adhesive made on the basis of polyurethane resin.

APPLICATION:

PU 3000 is used to bond leather or other material to the instrument panel in a car.

TECHNICAL DATA:

Appearance	transparent colorless solution
Viscosity (ISO 2431, Ø4, 20°C), s	95 ± 5
Specific gravity (ISO 2811, 20°C), g/cm ³	0.88
Total solids (ISO 3251), %	min. 14
Flash point (ISO 3679), °C	< 0
Application	by spraying
Consumption, g/m ²	ranging from 200 – 400
Package	tin cans: 700 g; 4.0 kg
Storage conditions	in the original packaging in a dark place at a temperature ranging from 5°C to 25°C.
Storage life	1 year

INSTRUCTION FOR USE:

The adhesive is applied by spraying on both surfaces to be bonded. The viscosity of the adhesive is adjusted for application by spraying. Before use, 5% of **HARDENER HTF (40g)** is added to the adhesive. Thus prepared adhesive is usable for 4 hours. We recommend bonding at a temperature of 20°C-30°C. It is used **INTERSOL NF** as a cleaning agent for instrument panel before application of adhesive. Surfaces on which the adhesive is applied can be joined immediately after application or later by heat activation. An industrial fan can be used for activation. The bonded joint is resistant to elevated temperatures.



PREMIUM
QUALITY



PRODUCT NAME: **INTERSOL NF**

TECHNICAL DATA

INTERSOL NF is a product made on the basis of organic, non-flammable solvents.

APPLICATION:

INTERSOL NF is used for cleaning rubber, textile and metal surfaces after sanding, as well as for cleaning and washing car instrument panel and car roof before application the adhesives **CR 2000** and **PU 3000**. It is also used as a cleaning agent before application the adhesives **PU 1000**, **CR 1000** and **PU 2000** for bonding pvc or rubber. It can also be used for thinning adhesives **BSC 2000**, **BSC 2002**, **BSC 3000** and **BSC 4000**, as well as for washing brushes used for the application.

TECHNICAL DATA:

Appearance	pale-yellow liquid
Specific gravity (ASTM D 1298, 20°C), g/cm ³	1,4
Package	tin cans: 6.0 kg; 1000 g
Storage conditions	in original well-enclosed packaging at temperatures up to 25°C. The product is non-flammable.
Storage life	4 years

INSTRUCTION FOR USE:

Cleaning rubber, metal and textile surfaces after sanding is done by using a suitable textile material soaked in **INTERSOL NF**. Brushes are washed every time immediately after applying the adhesive is finished. If it is necessary to dilute the adhesive for easier application, we recommend that it be a maximum 5-10% with subsequent mixing up to homogenization of the adhesive and **INTERSOL NF**.



PREMIUM
QUALITY



PRODUCT NAME: **Hardener HTF**

TECHNICAL DATA

Hardener HTF is a solution of polyisocyanates. It is used as a crosslinking agent for adhesives.

APPLICATION:

Hardener HTF is used to improve the temperature resistance and the speed of chemical reaction.

TECHNICAL DATA:

Apperance	light brown transparent liquid
Specific gravity (ASTM D 1297, 20°C), g/cm ³	1.0
Flash point (ISO 3679), °C	-4°C
Boiling point	77°C
Package	glass bottles: 40 g and 50 g; in original well-enclosed packaging in a dry and dark place at a temperature from 5°C to 25°C.
Storage life	4 years

INSTRUCTION FOR USE:

Hardener HTF is added in the amount of 5%. After adding **Hardener HTF**, it is necessary to homogenize the adhesive:

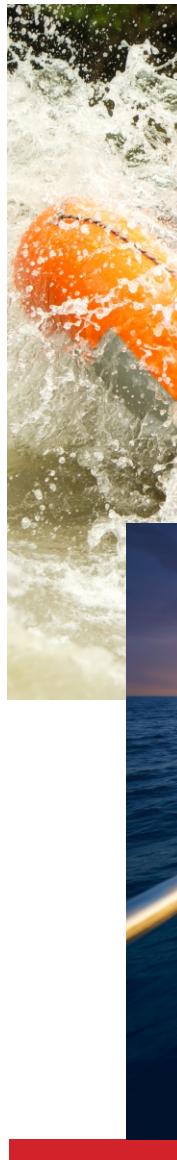
- by mixing with a glass stick in a container with adhesive or
- by shaking the sealed container with adhesive.

After adding **Hardener HTF**, the adhesive is good to use for 4 hours.





interStik
adhesive solution



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