



VARIOGLUE Technical Information

VARIOGLUE 0012 A 2-Component Screen Adhesive

Page 1 of 2

Product Characteristics

VARIOGLUE 0012 A is a very fast curing, polyester based, 2-component screen adhesive that is mixed with the isocyanate hardener **VARIOGLUE 0012 H**. This screen adhesive can be applied to all commercially available screen fabrics (polyester, polyamide-nylon, stainless steel, metal-polyester) and especially to high-precision and high-tension fabrics that are bonded to flat surfaces.

Advantages

The ready-mixed red transparent adhesive exhibits excellent dispersion and flow-out properties despite a high solid content of 20% by weight (+/- 1% by weight) and a viscosity of 1000 m PAS. It is usable for all mesh counts and can be mixed with adhesive thinner and cleaner **VARIOGLUE 0112 T** at a mixture ratio of 10% by weight to meet specific fine mesh requirements.

The properly cured **VARIOGLUE 0012 A** screen adhesive is extremely resistant to solvents, water, oil, chemicals and heat which is extremely important when the finished frames are used in automatic screen washing equipment.

The unparalleled elasticity of **VARIOGLUE 0012 A** screen adhesive eliminates brittleness even if exposed numerous times to organic solvents and UV-light. These outstanding performance characteristics also allow to use this product as a permanent block-out which will neither flake-off nor will it create sharp and thus damaging coating edges on the screen.

The fast curing time of this frame adhesive does not require a longer dwell time for frames in stretching devices than the ordinarily needed 10 - 15 minutes. The actual tension release time of the screen stretching system depends on the fabric tension, thickness of the applied frame adhesive, ambient temperature, relative humidity and room air circulation.

The working pot life of the 2-component adhesive **VARIOGLUE 0012 A** is approx. 45 - 60 minutes.

Application - Direction

VARIOGLUE 0012 A screen adhesive must be intensively mixed with the special hardener **VARIOGLUE 0012 H**. The following mixing ratio should be closely adhered to:

5 parts by weight of **VARIOGLUE 0012 A** Adhesive to
1 part by weight of **VARIOGLUE 0012 H** Hardener.

The desired level of adhesive curing and bonding strength will primarily be achieved by the homogeneous mixing of the two components.

When the screen adhesive is catalyzed with the hardener, the colour will become wine red. This



color change differentiates the applied frame adhesive from the colour of most frame surfaces and screen fabrics.

The mixing of the screen adhesive should occur at a normal ambient temperature of 20 – 25°C (68 – 77°F) and at a relative humidity of not exceeding 60% moisture content.

The adhesive has been applied with a stiff bristle brush, plastic spatula or scraper blade and should be evenly spread with slight pressure.

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Page 2 of 2

Metal frames must be thoroughly cleaned from corrosion, grease, and old adhesive particles. Preferred cleaning method is grinding or sand blasting. The treated frame surface must be completely cleaned from any debris or other obstructing particles. Stubborn traces of grease, silicon or oil can be easily removed with the degreasing agent **REMCOPUS S 7606**. Slightly soiled frame surfaces can be cleaned with the highly volatile adhesive thinner and cleaner **VARIOGLUE 0112 T**.

Surfaces of new aluminum frames are usually sand blasted. For increased bonding characteristics in certain applications, the surface texture of new frames can be chemically improved with the alkaline cleaning paste **VARIOHAZE 8068**.

Applying the 2-components screen adhesive **VARIOGLUE 0012 A** onto new frame surface will result in a strong adhesive-on-adhesive bond.

Initial resistance against water and less aggressive solvents is achieved within 1 – 2 hours. The final performance criteria especially when processing in automatic screen washing equipment, will only be reached after min. 12 hour reaction time (over night), better yet after 24 hours.

VARIOGLUE 0012 A is highly solvent resistant but when more aggressive solvents are being used, it may become necessary to insulate the frame adhesive with a suitable frame adhesive protection lacquer.

Ideal screen adhesive protection coatings are the humidity curable, 1-component protection lacquer **VARIOFLEX 0058 L** or the 2-component protection lacquer **VARIOFLEX 0082 L**.

Packaging – Storage

Shipping and sales units:

VARIOGLUE 0012 A 2-component screen adhesive
4,5 kg or 900 g tin cans
(6 cans adhesive and 6 cans hardener in cardboard box)



VARIOGLUE 0012 H hardener for 2–component screen adhesive
900 g or 180 g tin cans
(6 cans adhesive and 6 cans hardener in cardboard box)

The shelf life of unopened hardener cans is approx. 9 months. Opened containers must always be closed air-tight. Store **VARIOGLUE 0012 A** adhesive and **VARIOGLUE 0012 H** hardener at ambient temperature and never expose these products to temperature of more than 40°C (104°F) or to direct sun light. If exposed to cold temperature or frost, the frame adhesive can gel. The original consistency can be restored by warming up to ambient temperature and briskly stirring the content of the can.

VARIOGLUE 0012 A and **VARIOGLUE 0012 H** are highly flammable. The cans should never be exposed to fire or other ignition sources. There should not be direct light in the storage and mixing area where smoking is strictly prohibited, and sufficient air ventilation is necessary.

Additional safety, application, and pollution data can be obtained from the respective MSDS according to guidelines 1907/2006/EC.

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