



Den Braven

Technical Data Sheet

Hercuseal Clear Bond 325

High quality crystal clear hybrid adhesive



Product Description

Hercuseal Clear Bond 325 is a high quality professional adhesive. Based on hybrid technology it cures under influence of humidity to form a durable elastic rubber.

Benefits

- Universal crystal clear adhesive for interior use
- Free of isocyanates, solvents and silicones
- No shrinkage, bubble free
- Adheres perfectly without primer to most surfaces
- Neutral curing, almost odourless
- Non corrosive towards metals
- High mechanical resistance strength and E-modulus
- Absorbs acoustic and mechanical vibrations

Applications

Hercuseal Clear Bond 325 was specifically developed as a universal construction adhesive for interior use. Suitable for applications in areas where food is being processed and/or stored.

Directions Of Use

Apply adhesive in a 'ventilating' way in vertical stripes with 10-20 cm distance between stripes. Do not apply the adhesive in dots! Use 3 mm thick double sided tape to support adhesion during the first 24

hours, and to make sure that the thickness of the adhesive is correct. For further questions please contact our technical service.

Additional information

100 % modulus	DIN 53504 S2	1,15 N/mm ²
Application rate	@ Ø2,5 mm/6,3 bar	150-300 g/min
Application temperature		+5°C to +40°C
Base		Hybrid
Curing time	@ +23°C/50% RH	2-3 mm/24 hours
Density	ISO 1183-1	1,06 g/ml
Elongation at break	DIN 53504 S2	450%
Flow	ISO 7390	< 2 mm
Frost resistance during transportation		Up to -15°C
Shorea hardness	DIN 53505	45
Skin formation	DBTM 16	10 minutes @ +23°C/50% RH
Temperature resistance		-40°C to +90°C
Tensile strength	DIN 53504 S2	3,20 N/mm ²

These are typical values

Limitations

- Not suitable for PE, PP, PC, PMMA, PTFE, soft plastics, neoprene and bituminous substrates
- Not suitable for continuous exposure to water
- With prolonged exposure to UV radiation, products can discolour and become less UV stable
- Not suitable for movement and glazing joints
- Not suitable for natural stone and mirrors

Surface Preparations and Finishing

Application temperature +5°C to +40°C (applies to environment and substrates). All substrates must be solid, clean and free of grease and dust. Clean substrates with Cleaner. Hercuseal Clear Bond 325 adheres perfectly without the use of primer to most non porous



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substrates. Porous substrates to be pre-treated with Primer. Always test adhesion prior to application.

Paintability

Hercuseal Clear Bond 325 is perfectly paintable with water based and most 2 component paints. Synthetic paints can dry slower. We recommend testing compatibility with paint prior to application. If Zwaluw Clearfix is to be painted over (not necessary), we recommend slightly sanding the sealant and the junction surfaces prior to use with Scotch-Brite. For the best results, we recommend painting within a few days after application.

Cleaning

Uncured material and tools can be cleaned by using Cleaner. Cured material can only be mechanically removed. Hands can be cleaned with Wipes.

Colour(s)

- Transparent

Packaging



- Cartridge


For product specifications, please refer to the Product Detail Page

Shelf Life

In unopened original packaging between +5°C and +25°C, shelf life till 18 months after production date, stored in a dry place.

Certifications

	ISEGA
	LEED
	A+ French VOC Regulation

	EN 15651-1: F-INT
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Health & Safety

Product Safety Data Sheet must be read and understood before use. These are available on request and via our websites

Warranty & Guarantee

Bostik warrants that its product complies, within its shelf life, to its specification.

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