

Hybrid polymer adhesive for constructional, slightly elastic adhesive work, injectable, non-foaming, paintable

Application

Wisacoll HPK 675 is an injectable, solvent-free, paintable, elastic, seam- and joint-filling hybrid polymer adhesive of the latest generation with a high Shore A hardness of 75 and above-average tensile and tensile-shear strengths. It is used, among others, in vehicle construction, e.g. for vehicle attachments, as injectable anti-drone or corrosion-protective coating (e.g. underfloor protection). It is also used in industry and the construction area, e.g. in metal construction, wood-aluminium window construction for gluing/sealing the aluminium corner connectors, gluing natural stones or wood-metal adhesions.

Wisacoll HPK 675 can be point welded, does not act corrosively and does not foam when curing. The adhesive is stable and has a very good processing viscosity. This makes it easy to press from the cartridge even at low temperatures and easy to spread with brush or spatula. It can even be shaped and structured.

Wikoplast-HPK 675 has good adhesive properties on most undergrounds used in vehicle construction and at construction sites, such as treated metals, aluminium, masonry, natural stone, wood materials, many plastics, etc. For more details, see items *Limitations* and *Undergrounds*.

Basis

Wisacoll HPK 675 is a high-quality adhesive based on silan-modified polymers (SMP) of the next generation. The adhesive does not require marking, is silicone free, softener-free, solvent free (VOC-free), tin-free, nearly odourless and contains no isocyanates.

Linking takes place chemically neutrally in air humidity.

Limitations

Wisacoll HPK 675 is NOT suitable for expansion joints, joints under load, PE, PP, Teflon, bituminous and wax-containing undergrounds. Adhesion on glass under direct influence of UV radiation on the adhesive area is only warranted conditionally in the long term. Better materials are available for glass and mirrors.

Processing

The adhesive areas must be capable of bearing load, dry, dust- and grease-free. Grinding or roughening can improve adhesion on difficult undergrounds. Pre-apply Wi-Primer V-06 on strongly absorbent and porous undergrounds. Clean non-absorbent undergrounds with Wisatyp TL 16 or Wisaclean R 216. For treated and non-absorbent surfaces, perform an adhesive test first.

Apply adhesive on one side and join and fasten parts before skin forms. For area adhesions of non-absorbent materials, we recommend applying an adhesive bead from the top down or sprinkling the adhesive with the finest water droplets to ensure quick and complete curing of the adhesive. In the latter case, we recommend moving the pieces against each other so that the water is perfectly distributed in the adhesive.



Density	Approx. 1.60 g/cm ³	
Consistence	Pasteous, thixotropic (only just stable)	
Skin formation	Approx. 9 min under regular conditions (+23 °C, 60% rel. humidity)	
Loss	Less than 3 volume-%.	
Curing time	Approx. 2-3 mm on the first day (decreasing in the following period)	
Pressing time	Approx. 40 min in wood-wood adhesions under regular conditions (strongly dependent on temperature, application volume, material, moisture, layer thickness and absorbcency of the underground)	
Suitability for painting on	Can be painted on wet with many paints and special primers Can be ground and painted over with most paints and primers after linking Due to the many paint, primer and varnish types, own tests must be performed. Too-early painting on may cause blister formation or delay curing of the paint or adhesive.	
Shore A hardness	Approx. 75 (viscous-elastic)	
Temperature resilience	-30 °C to +80 °C (short-term up to +120°C), all values after completed linking	
Elongation at break	Approx. 75%	
Tensile resistance	Approx. 5.3 N/cm ²	
Tensile-shear resistance	Approx. 4.0 N/mm ² (0.1 mm adhesive joint) Approx. 3.6 N/mm ² (1 mm adhesive joint) Approx. 3.4 N/mm ² (3 mm adhesive joint)	
Improvement	With the same material	
Undergrounds	Aluminium, steel, zinc-plated steel, non-ferrous metals, concrete, compact masonry, natural stones like marble, granite, sandstone, ceramics, enamel, PVC-hard, polyester, epoxy, polystyrene (EPS/XPS), many thermal and duroplastic plastics (except for PE and PP), various paint systems (own tests required), wood, wood materials and many other materials.	
Cleaning and Pre-treatment	For non-absorbent undergrounds, cleaning/degreasing with Wisatyp TL 16 or Wisaclean R 216 is usually sufficient. We recommend priming strongly porous and absorbent undergrounds with Wi-Primer V-06. We recommend Wi-Primer V-07 for natural stones. Clean hands with water and soap.	
Processing temperature	From +5 °C to +40 °C.	
Item/colour	HPK 675.02 white	HPK 675.06 black
Processing tools	Commercial cartridge gun or compressed air spray application gun (item: TG 851.SPR).	
Shelf life	12 months from production (see printed-on best-before date) in original packaging and when stored dry between +15 and +25 °C.	
Delivery form	Boxes with 12 cartridges à 290 ml.	

Observe: All information is based on careful examinations in the labs and our previous practical experience. They are non-committal notes. Due to the many materials that are marketed and the different processing methods, which we cannot influence, we can, of course, not assume any warranty, including under patent-law, for the result of your work. We recommend performing sufficient own tests to find out if the product meets the respective requirements. Apart from this, we refer to our sales, delivery and payment conditions.