Henkel Technologies

TECHNICAL INFORMATION
DORUS HARDENER R 397

Hardener for Dispersion Glues

CHARACTERISTICS

- Yellowish, transparent liquid
- Based on aliphatic polyisocyanate
- Well dispersable
- Bond joint turns into a thermoset

FIELDS OF APPLICATION

- Joints where increased water and heat resistance is required

TECHNICAL DATA

Colour:	transparent, yellow
Viscosity (Brookfield, 20 rpm):	approx. 2 000 mPa·s

INSTRUCTIONS FOR USE

DORUS R. 397 is stirred into the dispersion glue till a homogeneous mix is formed. Some foam that may be possibly created by mixing can be removed by slow stirring.
For gluing use only freshly prepared glue mix within the given potlife. The open times and setting times of the basic **DORUS** glues are not significantly changed when the hardener is added. The values as well as the processing instructions given in the datasheets of the basic glues are the same. Often the rubber of rollers can swell or even be dissolved under certain circumstances. Ask your supplier of rollers whether the rubber material used is resistant to aliphatic polyisocyanate.

GLUE / HARDENER MIXTURE

D2 Glue like DORUS MD 041 plus 3 % R. 397 hardener = durability class D3 according to EN 204

D2 Glue like DORUS MD 041 plus 6 % R. 397 hardener = durability class D4 according to EN 204

D3 Glue like DORUS MD 074 plus 5 % R. 397 hardener = durability class D4 according to EN 204

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GLUE / HARDENER MIXTURE Cont…

Dispersion glues for 3-D press technology like **DORUS FD 140** plus 5 % R. 397 hardener = increased water and heat resistance.

DELIVERY FORM

Bottles

STORAGE

Store in a cool, dry place in the unopened original container for up to 9 months.
After each use the container has to be tightly closed, since the product is moisture sensitive and is less effective when exposed to open air for longer time.

LABELLING

The safety datasheet should be respected!

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