



AEROK®

TECHNICAL DATA SHEET

PYROK 9142

Pyrok 9142 is a two component water borne adhesive developed for bonding applications in aerospace and mass transit interiors. Formulated to have good fire, smoke and toxicity performance. The product is heat reactive and is suited for large surface areas such as train/bus floors or curved three dimensional profiles.

Pyrok 9142 will bond leather, fabric, PVC, polyurethane, rubber etc. to aluminium, wood, GRP, Nomex type honeycomb, faced plywood etc.
Once fully cross linked Pyrok 9142 has a good temperature and moisture resistance.

PROPERTIES

Composition	Polyurethane resin in water dispersion
Cure	Evaporation and cross linking with activator 420
Solvent	Solvent free
Colour	Transparent when dry
Mix Ratio	3-5% of activator by weight
Pot Life	8 hours
Reactive Time	8 hours
Solids Content	50%
Viscosity	mPas 1300 - 2500

METHOD OF USE

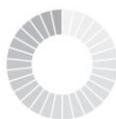
Add the activator to the adhesive (3-5% by weight) stirring carefully. Best results are achieved by using a powered mixer on low speed to avoid foaming and air absorption.

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PUROK™



FORGEWAY

APPLICATION

Apply an even coating of adhesive on to both surfaces to be bonded using a spray system (nozzle size 2.0-2.5mm). Apply approximately 50 gsm (wet). Conduct own testing for optimum coat weight as substrates vary. The adhesive can also be applied by brush or roller. The adhesive will turn transparent when dry. The drying time depends on the ambient temperature and humidity. With porous substrates the time will be 30-35 minutes. Drying time can be reduced with heat.

ASSEMBLY

Before assembly both surfaces should be completely dry. Heat both surfaces up to 60°C - 70°C / 140°F - 158°F and then assemble under pressure. Substrates can be laid on top of each other and heat applied through. Maximum bond strength achieved after 48 hours.

STORAGE

6 months in the original container
Store between +15°C and +25°C / +59°F and +77°F

CLEANING EQUIPMENT

Spray equipment should be flushed after each use (or daily) using soapy water. Air cap and exterior parts to spray gun and pressure pot using soapy water and Scotchbrite type scouring pad.

The variability of materials, substrates and conditions of use is such that no warranty of their functionality for a specific application can be deducted from this information, written recommendation or any other type of suggestion offered. Each user has the responsibility to complete adequate evaluations on the efficacy of the materials offered by Forgeway, of its products, services, recommendations and suggestions for the specific application need, and must accomplish sufficient testing to ascertain that the final product will be safe and sound for the final intent of the end-user.