

# REPASCHOL 181 GPV

Transparent, 650 g + 50 g hardener

## DESCRIPTION

*Repaschol 181 GPV* is a 2-component glue for cold bonding PVC and PU

## APPLICATION

- **Surface preparation:**  
The surfaces must be clean, dry, free of greases and oils.
- **PVC / PU:**  
Slightly roughen surface with a grinding disc (or similar) until all gloss is gone. Clean off grinding dust.
- **Metal:**  
Roughen surfaces by sandblasting or grinding. Clean with *LUCON Cleaner* and let dry completely. To increase the adhesion treat the metal surface with *Lutze steel primer 140*.
- **Application:**  
Mix *Repaschol 181 GPV* with 5% hardener thoroughly.  
  
For plastic-plastic bonds two layers, for cotton-fabric bond three layers of glue are needed.  
  
Minimum drying time between the layers 20 – 30 minutes (back-of-the-hand test).  
  
Press or powerfully knock (using a hammer) both surfaces onto each other, within the contact bonding time of 30 minutes.  
  
Activate dried layer by carefully heating up to approx. 80 °C with a heat gun before joining. This increases the strength and heat resistance properties in demanding applications up to ~ 120 °C.

## CHARACTERISTICS

Thinner / Cleaner	LUCON Cleaner	Evaporation time	20 – 30 min
Hardener	Hardener 500 FE	Pot time	Max. 2 hours
Shelf life	12 months	Storage conditions	Not below 10 °C
Consumption	400 – 500 g/m <sup>2</sup> per coat		Keep container tightly closed

The values determined in the laboratory can be used as an orientation and may deviate in practice. The suitability for Repaschol 181 GPV should be tested in a trial application.

## HANDLING

This adhesive thickens up when it is colder than 0 °C, but can be made usable again when heated to room temperature! In extreme weather conditions, such as cold and rain, protective measures must be taken, such as an additional roof, heated air supply, etc. to provide the necessary processing conditions.

The ideal application conditions are 15 – 25 °C and 30 – 65 % relative humidity. The hardener will crystallize in cold temperatures. In this state it cannot be used. Slightly warming it up will reverse the crystallization.