

GEPI 315

VOC-free class A+ Water based polychloroprene adhesive

Technical features

	<u>Data</u>	<u>Tolerance</u>	<u>Method</u>
Viscosity at 20°C	1300 mPa.s	± 15%	ICF N° 07

Purpose

GEPI 315 is one-component polychloroprene adhesive in aqueous dispersion to be used by brush or spray suitable for different types of assembly. It is mainly used in the construction industry in heating and refrigeration systems. It is particularly suitable for the insulation of rubber pipes and sheets glued to themselves or to sheet metal and can be considered a sustainable replacement of the traditional solvent based adhesives for such type of applications. The main features are: high thermal resistance and rapid initial setting.

GEPI 315 obtained the A+ certification for indoor air quality which is the highest rating available and indicates that the adhesive release very low levels of VOCs into the atmosphere during the manufacturing process and application.

GEPI 315 meets the VOC-free class A+ requirements of the French Ministry of Ecology, Sustainable Development, Transport and Housing.

Instruction for use

1. Shake the package carefully and mix the adhesive.
2. Make sure that the surfaces to be bonded are clean and free from dust and grease.
3. Apply a uniform layer of adhesive on both surfaces to be bonded and wait 15 – 20 minutes. The evaporation of water can be reduced to a few minutes using of dehumidification devices.
4. Join the parts to be glued and pressed for 5 – 10 seconds manually, subjecting the surfaces to an effective and uniform pressing.

The bond is permanently stabilized after 72 hours.

Note

Viscosity: The viscosity value is determined with Brookfield RVT viscosimeter RV3 spindle and speed 20 rpm.

Stocking: **GEPI 315** in its original packaging and carefully closed, kept at a temperature between 15 and 25 °C keeps its features for 6 months without particular changes. **CAUTION!** If **GEPI 315** is kept at temperatures below 0 °C it can irreversibly freeze.

Cleaning: To clean surfaces dirty with **GEPI 315** it's enough to use a water-soaked cloth if the material is still moist, or DILUENTE R for dry surfaces.

Packaging

10 kg net weight cans.
1 kg net weight bottles.

Technical Characteristics

Viscosity at 20 °C: 1300 mPas
Solid content: 51%

Adhesive Bonding Application Tests

OPEN TIME (after complete drying)	RESULTS	COMMENTS	Sample look after 24 h	Thermal resistance at 80°C for 60'	Thermal resistance at 90°C for 60'	Thermal resistance at 100°C for 60'
0 minutes	PASS	Good bonding	Closed samples	OK	The sample begins to breake	The sample is broken
7 minutes	PASS	Good bonding	Closed samples	OK	OK	OK
15 minutes	PASS	Good bonding	Closed samples	OK	OK	OK

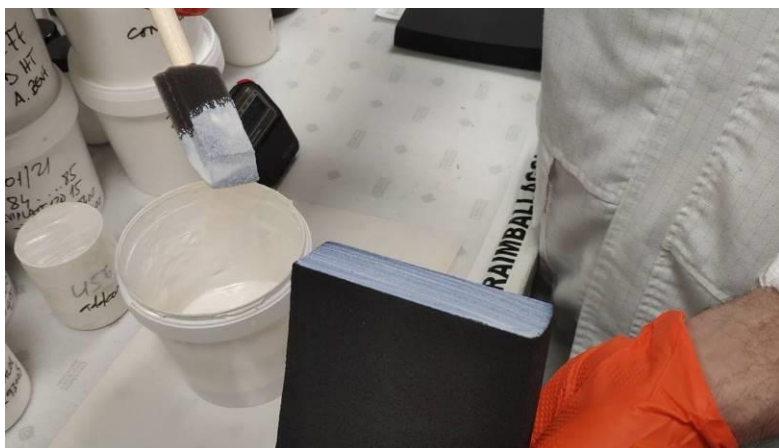
The adhesive has good spreadability, good adhesion and excellent thermal resistance. Bonding are made with classical insulation materials.

Operating procedures

- 1 - Spread by brush or spray adhesive GEPI 315 and wait the completely evaporation of water (10-12 minutes at room temperature between 22-25 °C). **(pic. 1)**
IMPORTANT NOTE: drying time depends on the room temperature, if your room temperature is below 20 °C the drying time will be increased.
- 2 - When the sample in completely dried is possible start to bond. **(pic. 2)**
The sample must be closed very well. **(pic. 3)**
Open time after drying is 15 minutes maximum.
- 3 - The three sample, closed in different time, remaining at room temperature for at least 24h before the thermal resistance. **(pic. 4)**
- 4 - The thermal resistance test start at 80 °C for 60 minutes. **(pic. 5)**
- 5 - Then the temperature increased to 90 °C for other 60 minutes. **(pic. 6)**
Lastly the test finishing with 60 minutes at 100 °C. **(pic. 7)**



Pictures



PICTURE 1

*Spread by brush adhesive
GEPI 315*



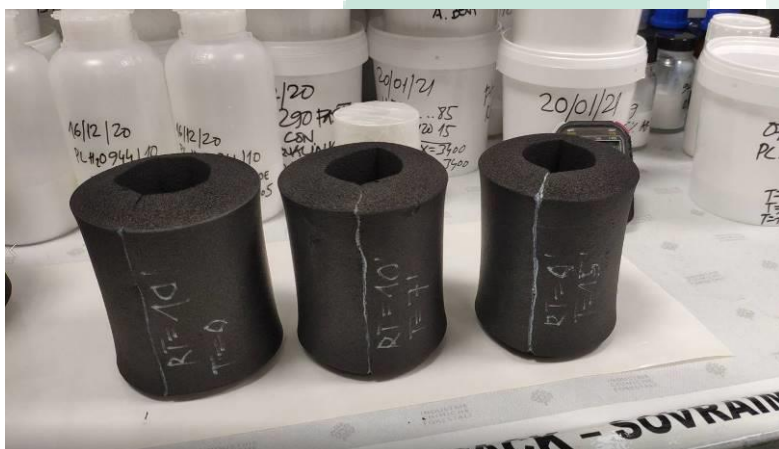
PICTURE 2

*When the sample is completely
dried is possible to start to bond*



PICTURE 3

The sample must be closed very well



PICTURE 4

Remaining at room temperature for at least 24h



PICTURE 5

Sample after 60' at 80 °C



PICTURE 6

Sample after 60' at 90 °C



PICTURE 7

Sample after 60' at 100 °C

ICF Laboratory