

# RELEST® Plus Adhesion Promoter

Art.-Nr. I367-0080

### Properties:

Type of binder	Polyurethane
Mixing ratio	According to weight: 2 : 1 According to volume: 2 : 1
Hardener	RELEST® Hardener PUR 159
Viscosity 4 mm (ready for use)	Approx. 14 s
Density ISO 2811-1 (ready for use)	Approx. 0.98 g/cm <sup>3</sup>
Solid content (mixture)	Weight: approx. 35% Volume: approx. 26%
Workable life	Approx. 45 minutes
Gloss level	Gloss
VOC content (ready for spraying)	Approx. 648 g/l
Spreading rate (mixture)	At a recommended dry film thickness of 10 µm on even surfaces in delivery form without application loss theoretical: approx. 38 g/m <sup>2</sup> corresponds to: approx. 26 m <sup>2</sup> /kg  Non-binding reference value since surfaces and their consumption rates vary. Carry out a test application according to DIN 53220 to assess the exact spreading rate.

The technical data refer to +20°C and 65% relative air humidity.

### Characteristics and resistance:

RELEST® Plus Adhesion Promoter is a two-component PU material designed as adhesion promoter for PVC, aluminum cast, CDC, PMMA and GRP based on EP or UP; in case of doubt adhesion tests should be implemented.

The adhesion promoter is especially suited for use in combination with wear protection coatings for rotor blades (RELEST® Wind Leading Edge Protection).

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### Substrate preparation:

#### General:

The surface preparation is decisive for the durability of all coating systems. Substrates must be clean, dry, solid, free of dust, parting agents and other soiling. The surfaces must be sanded with fine abrasive paper (e.g. 180 grit size) before use.

### Application:

Empty the contents of the hardener container completely into the corresponding base component container. Ensure that the hardener container is completely empty. If smaller quantities are required, it is also possible to remove partial quantities only. Mix both components thoroughly by means of a low-speed stirrer. Smaller quantities should be thoroughly stirred in by hand. Apply the product with foam rollers (e.g. SUPERFLOC rollers). Make sure that as little air/foam as possible is generated during the mixing and application process. All loose particles should be removed from new foam rollers by means of adhesive tape before use. The material must be applied swiftly and evenly without adding thinner.

<b>Application conditions:</b>	+15 °C min. to +35 °C max. air and object temperature at 85 % rel. humidity max. The lower the ambient and the object temperature or the air circulation, the longer the drying time.		
<b>Overcoating times:</b>	Climate Overcoating time	Overcoating time min.	max.
	18°C / 20% rel. humidity	approx. 20 min	6 h
	23°C / 65% rel. humidity	approx. 20 min	6 h
	35°C / 85% rel. humidity	approx. 15 min	2 h

### Storage/Transport conditions:

The material is storable for approx. 12 months in firmly closed original containers.  
Seal open containers airtight and use up soon.  
Protect from frost, heat and humidity.

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#### Standard coating system:

The respective coating system can be individually adapted to the local manufacturing processes and the desired quality standard.

Please contact the responsible field staff!

#### Safety measures:

The information and safety advice on the containers as well as the respective accident prevention regulations of the responsible trade associations are to be observed at all times when working with this product.

For further information, please see the Safety Data Sheets.