

FOTECHEM 2320 HV + 2325

2-Component Screen Adhesive

1. PROPERTIES

FOTECHEM 2320 HV is a fast curing, polyester based, 2-component screen adhesive that is mixed with the isocyanate hardener **FOTECHEM 2325**. This screen adhesive can be applied to all commercially available screen fabrics (polyester, polyamide-nylon, stainless steel and metal-polyester) and especially to high precision and high-tension fabrics that are bonded to flat surfaces.

The ready-mixed red transparent adhesive exhibits excellent dispersion and flow-out properties despite a high solid content of 20% by weight (+/- 1% by weight) and a viscosity of 18000 m PAS. It is usable for all mesh counts and can be mixed with adhesive thinner and cleaner **FOTECHEM 2327 T** at a mixture ratio of 10% by weight to meet specific fine mesh requirements.

The properly cured **FOTECHEM 2320 HV** screen adhesive is extremely resistant to solvents, water, oil, chemicals and heat which is extremely important when the finished frames are used in automatic screen washing equipment.

The unparalleled elasticity of **FOTECHEM 2320 HV** screen adhesive eliminates brittleness even if exposed numerous times to organic solvents and UV-light. These outstanding performance characteristics also allow using this product as a permanent block-out that will neither flake-off nor will it create sharp and thus damaging coating edges on the screen.

The fast curing time of this frame adhesive does not require a longer dwell time for frames in stretching devices than the ordinarily needed 15 - 20 minutes. The actual tension release time of the screen stretching system depends on the fabric tension, thickness of the applied frame adhesive, ambient temperature, relative humidity and room air circulation.

The working pot life of the 2-component adhesive **FOTECHEM 2320 HV** is approx. 1 hour.

2. APPLICATION - DIRECTION

FOTECHEM 2320 HV screen adhesive must be intensively mixed with the special hardener **FOTECHEM 2325**. The following **mixing ratio** should be closely adhered to:

5 parts by weight of FOTECHEM 2320 HV Adhesive to 1 part by weight of FOTECHEM 2325 Hardener.

Achieve the desired level of adhesive curing and bonding strength primarily by the homogeneous mixing of the two components.

When the screen adhesive is catalysed with the red hardener, the colour will become wine red. This color change differentiates the applied frame adhesive from the color of most frame surfaces and screen fabrics.

The mixing of the screen adhesive should occur at a normal ambient temperature of 20 – 25°C (68 – 77°F) and at a relative humidity of not exceeding 60% moisture content.

The adhesive has been applied with a stiff bristle brush, plastic spatula or scraper blade and should be evenly spread with slight pressure.

Metal frames must be thoroughly cleaned from corrosion, grease, and old adhesive particles. Preferred cleaning method is grinding or sand blasting. The treated frame surface must be completely cleaned from any debris or other obstructing particles. Stubborn traces of grease, silicon or oil can be easily removed with a solvent-based degreasing agent. Slightly soiled frame surfaces can be cleaned with the highly volatile adhesive thinner and cleaner **FOTECHEM 2327 T**.

Surfaces of new aluminum frames are usually sand blasted. For increased bonding characteristics in certain applications, the surface texture of new frames can be chemically improved with the alkaline cleaning paste **FOTECHEM 2080**.

Applying the 2-components screen adhesive **FOTECHEM 2320 HV** onto new frame surface will result in a strong adhesive-on-adhesive bond.

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SPT SALES +
MARKETING GMBH

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2-Component Screen Adhesive

Initial resistance against water and less aggressive solvents is achieved within 1 – 2 hours. The final performance criteria especially when processing in automatic screen washing equipment, will only be reached after min. 12 hour reaction time (overnight), better yet after 24 hours.

FOTECHEM 2320 HV is highly solvent resistant but when more aggressive solvents are being used, it may become necessary to insulate the frame adhesive with a suitable frame adhesive protection lacquer.

3. PACKAGING

Shipping and sales units:

- **FOTECHEM 2320 HV**
2-component screen adhesive
4,5 kg or 900 g tin cans
(6 cans adhesive and 6 cans hardener in cardboard box)
- **FOTECHEM 2325**
hardener for 2-component screen adhesive
900 g or 180 g tin cans
(6 cans adhesive and 6 cans hardener in cardboard box)

4. STORAGE

The shelf life of unopened hardener cans is approx. 9 months. Opened containers must always be closed airtight. Store **FOTECHEM 2320 HV** adhesive and **FOTECHEM 2325** hardener at ambient temperature and never expose these products to temperature of more than 40°C (104°F) or to direct sun light. If exposed to cold temperature or frost, the frame adhesive can gel. The original consistency can be restored by warming up to ambient temperature and briskly stirring the content of the can.

FOTECHEM 2320 HV and **FOTECHEM 2325** are highly flammable. The cans should never be exposed to fire or other ignition sources. There should not be direct light in the storage and mixing area where smoking is strictly prohibited, and sufficient air ventilation is necessary.

Additional safety, application, and pollution data can be obtained from the respective SDS according to guidelines 1907/2006/EC.