

ONEBOND PU RAPID 60

Description

ONEBOND PU RAPID 60 is a high modulus, low conductive, fast curing one-component polyurethane adhesive for vehicle glass direct glazing. It is also recommended for bonding glass-fiber composite panels in caravans, trucks, vans, etc.

Features and Benefits

- Gun grade: very easy to apply and tool. Application temperature: 5°C - 40°C.
- Drive Away Time (DAT) of 60 minutes with double airbag
- Solvent-free
- Thixotropic: non-sagging
- Excellent thermal stability
- Cannot be applied on damp surfaces.
- High modulus product that increases the torsional rigidity of vehicle

Physical properties⁽¹⁾

Composition:	Polyurethane
Colour:	Black
Viscosity	Non-sag thixotropic paste
Specific weight (g/ml):	1.2
Application temperature (°C)	From +5 to +40

1: These are typical values and should not be construed as specifications.

Typical curing properties⁽¹⁾⁽²⁾⁽³⁾

Curing Mechanism:	Moisture
Curing through volume [mm] (24h - 23°C and 50% RH):	3
Skin Time (min) (23°C and 50% RH):	20

1: These are typical values and should not be construed as specifications.

2: Curing conditions: +23°C and 50% Room Humidity

3: Curing can be accelerated at higher temperature and humidity

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Typical proprieties of the cured material⁽¹⁾

Hardness Shore A:	60
Tensile strength [N/mm ²]	14
Elongation at break [%]	700
Electrical volume resistivity [$\Omega \cdot \text{cm}$]	10^8
Temperature Resistance [°C]	From -40 to +100, with brief points up to +140

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Directions for use

Once it has been confirmed that the glass is free of cracks/defects proceed to clean the bonding surface with OneBond One Cleaner (**78072765571**) using a dry lint-free cloth/paper towel, wiping the surface in the same direction. The cloth(s) must be discarded after use.

Ensure that the glass/ceramic surface is completely dry prior to the application of OneBond PU Primer (**78072765569**). Shake the OneBond PU Primer 5 bottle for at least **1 minute** before opening it. This is key to obtain a uniform, smooth film build. If the sealed original bottle remains idle for more than **12 hours**, shake it again for **1 minute** before the product is opened and applied. Once the bottle is opened, the primer must be used within **24 hours** as it cures very fast (reacts with moisture). Tightly close the bottle when not in use. OneBond PU Primer (**78072765569**) must be applied on the glass/ceramic surface around the entire bonding area always moving the dauber/felt applicator in the same direction and applying pressure against the glass/ceramic frit. It is recommended to apply a layer of wet film approximately **1 mm thick**. The layer must be continuous. Drying time of OneBond PU Primer (**78072765569**) is **5 minutes** at 25°C and 50%RH. If there are uncovered areas on the glass or on the ceramic frit, apply another layer of primer on top. Never apply a third layer.

OneBond PU Rapid 60 is paste-like product designed to be applied at 15°C – 25°C. At this temperature, the viscosity is high enough to prevent the glass from moving during the first few minutes and after 30 minutes handling strength develops, as the chemicals react. The adhesive should be applied to the glass, either on top of the primer in a continuous triangular bead with no gaps or air pockets, overlapping both adhesive ends to prevent leakage. For perfect sealing, the triangular bead must be adjusted to the correct height and width. The bead width measurement should be continuous. The triangle height should be greater than the height of the car pinch weld. The adhesive bead must be applied with the dispensing gun positioned 90° to the glass surface, to ensure it is filled correctly.

When applying the windscreen to the vehicle body, it is critical to do so before the adhesive has 'skinned over'. OneBond PU Rapid 60 exhibits a skin-time of **20 minutes** at 25°C and 50%RH

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Storage

	Unit	
Recommended temperature	°C	5 – 25
Storage stability / Shelf life	Months	12

1: Stored in the original sealed containers at the recommended temperature in a dry place.

Packaging

Cartridge 310 ml – 12 pieces per box – **66254427472** – EN, FR, PT, IT

Soft-pack 400 ml – 12 pieces per box – **66254427474** – EN, FR, PT, IT

Soft-pack 600 ml – 20 pieces per box – **66254427476** – EN, FR, PT, IT

Safety, handling and disposal

Safety Data Sheets (SDS) are available from ONEBOND. SDS include information regarding the physical, health, and environmental health hazards, safety precautions, for products handling, storing and disposal. SDS are available in the language of the country or area of destination and may include locally applicable health and safety regulations. SDS are updated regularly and can be downloaded from www.onebondadhesives.com. ONEBOND encourages users to review the up to date SDS before handling or using any product.

Note

The data contained herein, obtained in Onebond laboratories, are given for information only; if specifics are required, please contact Onebond Technical Department. Onebond ensures abiding quality of supplied products according to its own specifics. Onebond cannot assume responsibility for the results obtained by others which methods are not under Onebond control. It is user's responsibility to determine suitability for user's purpose of any product mentioned herein. Onebond disclaims all warranties expressed or implied, including warranties of merchantability or fitness for a particular purpose, arising from sale or use of Onebond products. Onebond specifically disclaims any liability for consequential or incidental damages of any kind, including lost profits.