



## Industrial glue

### Introduction

The HOSCH-KLEBER company in Germany develop and product high capacity industrial glues since 1997. The most successful product is the HOSCH-KLEBER industrial glue and granulate take a place worthily among the different German industries suppliers, owing to the extending usability. The BMW automobile factory and the SCHUBERT crash helmet factory are also end users as other numerous little- and medium-sized companies too. The manufacturer company is 100% German-owned. The base of the HOSCH-KLEBER users long term satisfactions are the all-time workmanlike utilization. The HOSCH Ca 2000 industrial superglue primarily used as auxiliaries for the product diverse industries. Thanks to widespread availability it have owned a lot of successes in the various fields of repair. The HOSCH-KLEBER company in Germany, gives the possibility to make a material test before starting to use as an auxiliary manufacturing material the HOSCH Ca 2000 industrial superglue, to provide the optimal content of the glue for the manufacturing product, to fit the best way to the manufacturing product contents.

### User's instructions

Important remark, before the first use, every case make a test sticking, to make sure the sticking material quality is available and suitable for the sticking procedure. Important to know the superglue is not suitable for outdated materials, only for overloaded, or damages during the transport, etc. In case of the success bonding of over dated, run-down or highly stressed materials we can't expect long term stable result, only a little bit longer lifetime for the bonded part. Please take a consider this fact in every case, to avoid any kind of disappointing or annoyances. The efficiency and the durability highly depend on the properly prepared surface, the optimal temperature, and the technical content of the bonded material, so please read preciously the User's Instructions! The HOSCH-KLEBER industrial superglue kit gives you two possibilities for use. The glue can be used as a normal superglue (for porcelain, china, ceramics, rubber) or can be used the glue and the granulate together, as a crack filler (e.g. : to fill cracks or replace missing parts) and can be used for to stick different solidity materials (e.g.: copper-rubber) The HOSCH-KLEBER industrial super glue have three distinctive base features, which make more special like the other same smells superglues which can be bought at the stores with an another price and with other quality.

**First feature:** after flexible surface sticking the bonded surface will be also flexible.

**Second feature:** waterproof

**Third feature:** not dry into the pipette. Very easy to check this: leave the glue opened bottled for 2-3 days, and you will see the consistency of the glue will not change (not dried into the bottle). Normally store with the bottle cap to avoid to get any kind of stuff into the bottle.

### **Preparation of the surface**

For the successful and durable sticking necessary to prepare the surface in two different way, chemically and mechanically.

The mechanically preparation happens by grinding of the surface, the chemically preparation happens by wiping/brushing the surface with acetate or nitro thinner. By the grinding of the surface remove the mold release agents which was used by the production (e.g.: silicone) or the previously used glue remains and duplicate the bonded surface (scratches). Begin the mechanical preparation on dry, fat-free, dust-free surface. The all-time and successful requirement of the sticking is the surface preparation! Before using always think over the preparing procedure, never use on unprepared surface or rush way.

For the strongly polluted surfaces (e.g.: oil-sludge) can be used break cleaner, but before sticking use acetate or nitro-thinner always! For the successful and durable sticking very important the right kind of, optimal temperature. The temperature can be minimum 20 C at the bonding, if you stick metal parts, heat up them to at least 60 C. For heating up can be used heat-gun, or in summertime the sun can help, in winter time put the bonded material into hot water or place on to the warm radiator. Can be said generally the higher temperature than 20 C, can be more positive influence for the successful sticking in any case.

### **Using of the glue**

You can push out the glue from the bottle with slightly pressure. Onto the one of the right kind of way prepared (mechanically and chemically cleaned too) for sticking surface pouring the HOSCH industrial super glue thinly -taking into consider that bonding technology constitution, that if you use the less glue, the power of the bonding will be greater. After put together the parts as preciously as it possible, push and squeeze them

under pressure for 8-10 seconds. As an effect of the pressure the oxygen comes out and this way happens the bonding. The total bonding time is 30 minutes.

### **Using of the glue and the granulates**

#### **Using of the glue and the granulate together**

Use the glue and the granulate alternately after each other. This case the granulate distract the oxygen from the glue and happen the bonding.

Warning: Because of gas- and heat formation, use protecting gloves and glasses. Do not breath in the formationed gas, and forced ventilation is highly recommended!

The granulate get in touch with the glue becomes tough, and bound and will be able and ready for further processing (e.g.: like drilling, trimming, preparing for warnishing) after 30 minutes. Meanwhile this period do not load the piece!

In case of replacing missing, or broken parts take the work piece horizontally, and in the same time place a paper strip (e.g.: TESA adhesive tape) under the contact points. In case of repairing cracks, breakages make the crack „V” form (make like a root-sign  $\sqrt{\quad}$ ) and fill out this channel alternately glue and granulates, but the thickness of the granulate will be max 2-3 mm. To make the „V” form can be used engraving machine by Dremmel, milling machine or simple handy shredder too. For the more stable result you can apply this bonding procedure on the other side of the work piece, in this case not necessary to make again “V” form channel.

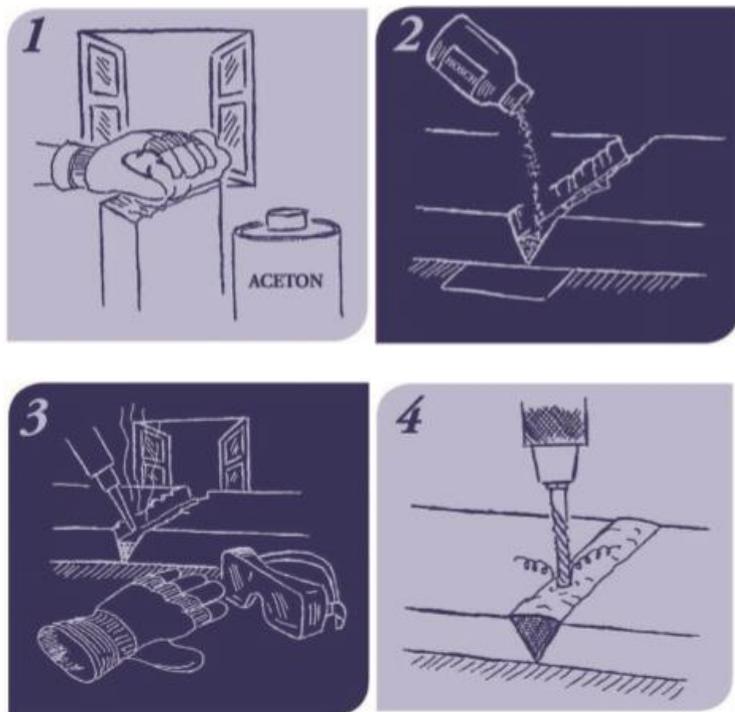
## Product information

Based on the classification of GefStoffV this product is not hazardous.

Keep away from children; do not swallow!

Because of gas- and heat formation of the Cyano-acrylat, do not breath-in the formationed gas, obligatory to use protecting gloves and glasses!

In case of eye contact, rinse out with clean water and consult with the doctor!



## Technical details:

Looks/ Feature	white, bullet-like, spherical
Odour	no special smell
Chemical components (By DIN 8201)	SiO <sub>2</sub> 65%
	CaO 8%
	Al <sub>2</sub> O <sub>3</sub> 0,5-2,0%
	Na <sub>2</sub> O 14%
	Fe <sub>2</sub> O <sub>3</sub> 0,15 %
	auxiliary 2,0 %
	MgO 2,5%
Storage temperature	dry place
Size	100-200 μ
Hardness by Mohs scale:	approx. 6-7
Hardness by Rockwell scale:	approx. 46
Hardness by Vickers scale:	approx. 645

## Application scope

Thanks to the wide applicability of the HOSCH industrial superglue and granulates applicable for bonding different strength materials (e.g.: copper-rubber, plastic-wood, aluminium- plastic or glass, rubber, ceramics, carbon, aluminium, steel, cast, leather, spiater) or possible to replace missing parts. Very important that it is suitable to bond thermoset (Polyurethane) and thermoplastic materials (ABS, PA) too. Also possible to bond each other different type of plastics (e.g.: ABS-Polyamide, ABS-Polyurethane, ABS-PVC, ABS-Polypropilene, etc.) Can be used, almost for all-type surfaces and all-type of material. The all-time base of the successes of HOSCH-Kleber industrial superglue and granulates is the material friendly feature, which means the great attitude between the glue and the bonded materials. ( In every case, necessary to make a test bonding!)

The HOSCH-Kleber glue and granulate can be used for household objects, everyday used objects, and industrial fields also. Can be good solution in case of emergency situations, (e.g.: flat-tire, leaking of the water pipe) and recommended for travelling, longer absence for react in time properly for the unexpected situations.

Heat resistance of HOSCH-Ca-2000 industrial superglue and granulate is: between -50C- + 150 C

Pressure resistance of HOSCH-Ca-2000 industrial superglue and granulate is: until 23 bar

## Storage

After using always clean the bottle gap from the glue remains, because next time will be very difficult to open. Store in cool temperature and vertically way. Storage life is 24 months.

Suggestion: Before use always check the cleaning liquid (acetate) quality, because of the frequent use can be polluted from the cleaned surfaces, which decrease the efficiency. Check the liquid, and use only if clear like a water. Don't use muddy, discoloured cleaner.

## Responsibility

Read the user's manual carefully! Follow the instructions and rules for labor safety or the environmental of the work. Injuries or damages because of the unprofessional, amateurish use of the HOSCH industrial super glue, the HOSCH -KLEBER Company make no liability. This terms valid for the third part buyers too. All the responsibility is for the end user!

The Safety Data Sheet and the all technical details can be downloaded from this website:

<http://hosch-kleber.hu/downloads/>

In case of any questions or problems concerning the HOSCH-KIEBER industrial glue, don't hesitate to contact us, we are ready for your kind disposal! [hosch@hosch-kleber.hu](mailto:hosch@hosch-kleber.hu)

Please watch our how to use video in our website for your help!

[http:// www.hosch-kleber.hu](http://www.hosch-kleber.hu)