T-Rex Glue Gold

Technical data

Basis	SMX Hybrid Polymer
Consistency	Stable paste
Curing system	Moisture curing
Skin formation* (23°C/50% R.H.)	Ca. 4 min
Curing speed * (23°C/50% R.H.)	Ca. 2 mm/24h
Hardness**	Ca. 55 ± 5 Shore A
Density	1,46 g/ml
Maximum allowed distortion	± 20 %
Max. tension (ISO 37)**	2,10 N/mm²
Elasticity modulus 100% (ISO 37)**	1,60 N/mm²
Temperature resistance**	-40 °C → 90 °C
Application temperature	5 °C → 35 °C

* These values may vary depending on environmental factors such as temperature, moisture, and type of substrates. ** This information relates to fully cured product.

Product description

T-Rex Glue Gold is a high quality, neutral, elastic, 1-component adhesive sealant based on SMX-Polymer with an extremely high initial tack of min. 400 kg/m².

Properties

- Extreme high initial tack of min. 400 kg/m²
- Fast curing
- Good workability with included triangular shaped nozzle.
- high shear strength after full cure (no primer)
- Stays elastic after curing and very durable
- No odour
- Good weather and UV resistance
- Free of isocyanates, solvents, halogens and acids
- Excellent adhesion on nearly all surfaces, even if slightly moist.

Applications

- Bonding in building and metal industry.
- Elastic bonding of objects, panels, profiles and other pieces on the most common substrates.
- For bonded facade panels we refer to the Soudal Panel System.
- Elastic structural bonding in automotive applications: buses, trains, trucks, caravans or trailers …

Packaging

Colour: white, other colors on request
Packaging: 290 ml cartridge, other packaging on request

Shelf life

12 months in unopened packaging in a cool and dry storage place at temperatures between +5°C and +25°C.

Chemical resistance

Poor resistance to aromatic solvents, concentrated acids and chlorinated hydrocarbons. Good resistance to water, aliphatic solvents, mineral oils, grease, diluted inorganic acids and alkalis.

Substrates

Substrates: all usual substrates for bonding, treated wood, PVC, ...
Nature: rigid, clean, dry, free of dust and grease.
Surface preparation: Porous surfaces in water loaded applications should be primed with Primer 150. Prepare non-porous surfaces with a Soudal activator or cleaner (see Technical Data Sheet).

Remark: This technical data sheet replaces al previous versions. The directives contained in this documentation are the result of our experiments and of our experience and have been submitted in good faith. Because of the diversity of the materials and substrates and the great number of possible applications which are out of our control, we cannot accept any responsibility for the results obtained. Since the design, the quality of the substrate and processing conditions are beyond our control, no liability under this publication is accepted. In every case it is recommended to carry out preliminary experiments. Soudal reserves the right to modify products without prior notice.

T-Rex Glue Gold has excellent adhesion on most substrates. T-Rex Glue Gold is has been tested on following metal surfaces: stainless steel, AlMgSi1, electro-galvanized steel, AlCuMg1, hot dip galvanized steel, AlMg3, steel ST1403. T-Rex Glue Gold also has a good adhesion on plastics: polystyrene, PVC, polyamide, fiberglass reinforced epoxy, polyester. While producing plastics very often releasing agents, processing aids and other protective agents (like protection foil) are used. These should be removed prior to bonding or sealing. For optimum adhesion the use of Surface Activator is recommended. NOTICE: bonding plastics like PMMA (e.g. Plexi® glass), polycarbonate (e.g. Makrolon® or Lexan®) in stress loaded applications can give rise to stress cracking and crazing in these substrates. The use of T-Rex Glue Gold is not recommended in these applications. Not suitable for PE, PP, PTFE (eg Teflon®), bituminous substrates, copper or copper-containing materials such as bronze and brass. We recommend a preliminary adhesion and compatibility test on every surface.

Application method

Application method: Apply the adhesive with a caulking gun onto one surface in beads or dabs (every 15 cm). Always apply adhesive to the edges and corners of panels. Press the surfaces together and batten down with a rubber hammer. Support of the bonded materials may be required. The bond can be fully loaded after 24-48 hours.
Cleaning: Clean with White Spirit or Soudal Surface Cleaner immediately after use (before curing).
Finishing: With a soapy solution or Soudal Finishing Solution before skinning.
Repair: With the same material.

Health- and Safety Recommendations

Take the usual labour hygiene into account. Consult label and material safety data sheet for more information.
Dangerous. Respect the precautions for use.

Remarks

- T-Rex Glue Gold is paintable with most common paints. Due to the wide variety of lacquers and paints, a compatibility test is always recommended.
- The drying time of alkyd resin based paints may increase.
- T-Rex Glue Gold can be applied to a wide variety of substrates. Due to the fact that specific substrates such as plastics, like polycarbonate, etc, may differ from manufacturer to manufacturer, we recommend preliminary compatibilty test.
- T-Rex Glue Gold can not be used as a glazing sealant.
- Not suitable for bonding aquariums.
- Do not use in applications where continuous water immersion is possible.
- Not suitable for sanitary applications.
- T-Rex Glue Gold can be used for bonding of natural stone, but it cannot be used as a joint sealant on this type of surface.
- When applying, make sure that the surface of the materials is not smudged with sealant.
- When using different reactive joint sealants, the first joint sealant must be completely hardened before the next one is applied.
- T-Rex Glue Gold has a good UV resistance but can discolour under extreme conditions or after very long UV exposure.
- Discoloration due to chemicals, high temperatures, UV-radiation may occur. A change in color does not affect the technical properties of the product.
- Contact with bitumen, tar or other plasticizer releasing materials such as EPDM, neoprene, butyl, etc. is to be avoided since it can give rise to discolouration and loss of adhesion.

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Environmental clauses
Leed regulation:
T-Rex Glue Gold conforms to the requirements of LEED. Low –Emitting Materials: Adhesives and Sealants. SCAQMD rule 1168. Complies with USGBC LEED 2009 Credit 4.1: Low-Emitting Materials – Adhesives & Sealants concerning the VOC-content.

Liability
The content of this technical data sheet is the result of tests, monitoring and experience. It is general in nature and does not constitute any liability. It is the responsibility of the user to determine by his own tests whether the product is suitable for the application.

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