

US Formliner - Adhesive SO

adhesive for US Formliner structured molds and formliners

US Formliner
Adhesive SO
Product 03518
Edition 06/21

PROPERTIES

US Formliner Adhesive SO is an elasticised, solvent-free, two-component epoxy resin with good adhesion to timber, steel and polyurethane elastomers.

APPLICATIONS

US Formliner Adhesive SO is used for low-tension adhesion of US Formliner formliners to conventional shutterings. Adhesion is even possible on humid (not wet) surfaces due to its special formulation. Once glued, the removal of the formliner is usually not possible without damaging the liner.

TECHNICAL DATA

property	value	method
mixing ratio (base : hardener):	4 : 1	(according to weight)
workable temperature:	50 °F – 85 °F	
pot life (200-g-mixture at 70 °F):	approx. 40 min	
earliest loading after:	24 h	
full mechanical loading after:	2 – 3 days	

These data are typical guide values. They are not intended for the generation of specifications.

SURFACE PREPARATION

The substrate must be stable, sound, clean and free of oil, grease or wax. The surface should preferably be dry, though a sufficient adhesion can also be achieved on a slightly humid substrate.

Steel formwork has to be ground or, better still, sand-blasted. The adhesion must be done before the steel starts rusting again. Any residues of grinding dust or oil must be removed completely.

Timber formworks need to have a sufficient capacity to bear load. Plastic-coated wood panels must be at least roughened by grinding or, even better, ground down to the wood substrate.

Before adhering, the back of the formliner must be roughened by grinding. Make sure not to grind off too much material from high spots that are transmitted to the formliner's back at thick structure segments. This can cause dents in the liner that

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will create humps in the concrete's surface. The grinding dust must be removed completely by sweeping, blowing or vacuuming.

PROCESSING

Before processing, the base component has to be stirred up thoroughly. Add the hardener (B) to the base component (A) and mix them until homogeneous. Transfer the mixture into a second receptacle and stir it up again. When stirring, avoid trapping air. Once mixed the processing of the material must be completed within the pot life (approx. 40 minutes). Mixing larger quantities decreases the processing time.

US Formliner Adhesive SO is best applied on one side only with a notched trowel (width: 2 – 3 mm). Always cover the complete surface. Within the processing time, the formliner has to be placed on the still fresh adhesive and aligned with light pressure. When placing the formliner, inclusions of air must be avoided. US Formliner formliners are subject to an inherent dimensional change due to their elasticity. Differences in length or width can be compensated by compressing or stretching as long as the adhesive is still fresh. The edges of the glued formliners must be fixed or weighted to avoid displacing or rising.

After 24 hours, US Formliner Adhesive SO is sufficiently cured to allow loading. However, it takes 2 – 3 days to achieve the full adhesive strength. At temperatures below 50 °F, the adhesion must be protected against cold to ensure sufficient adhesive strength after 24 hours.

CONSUMPTION

750 – 1000 g/m²

CLEANING OF EQUIPMENT

To clean tools and equipment, use dry, absorbent cloths. Soaking the cloth with US Formliner EK-PU Thinner can help with the removal of stubborn residues. However, immersion in solvents is not sufficient for the adhesive's removal.

PACKAGING SIZES

pair of cans: 10 lb (4.5 kg);

double kit: 1 kg (The hardener is enclosed in the lid.)

The stated weights for adhesive pails are the sum of both the hardener and base components. The hardener is shipped in separate containers to the base material.

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STORAGE

Store in a dry place at room temperature. US Formliner Adhesive SO is storable for 6 months from delivery when kept in the closed original packaging at about 65 °F. Opened drums must be closed airtight right after use.

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SAFETY

Protect skin and eyes from material splashes. Ensure adequate ventilation when handling this product. Please consult the relevant safety data sheet and observe the hazardous goods warnings on the label of the package. This pamphlet is intended solely as an application directive. It does not claim to be binding and valid for all modes of application. A preliminary test under operation conditions is highly recommended.

This version replaces all previously published technical pamphlets concerning US Formliner Adhesive SO, stating them as no longer being valid.

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