

Product Information

Sussmann & Steinhauser GmbH
Glasschleiferstrasse 14
D-87600 Kaufbeuren
Telefon: +49 8341 / 62087
Telefax: +49 8341 / 65475
http://www.hasulith.com
info@hasulith.de

HASULITH® Vielzweckkleber

HASULITH® Schmuckkleber, or: „HASULITH® Zement“

Valid for article no.: 1VZK

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SPECIFICATION

HASULITH® Vielzweckkleber is a colourless, clear, acid-free, solvent-borne one-component Multi-Purpose-Adhesive for gluing many common materials. Dry **HASULITH® Vielzweckkleber** is hard and crystal-clear, so gluing borders or small excess of adhesive spilled on the glued object will be nearly invisible in most cases. Short drying time, high bonding strength, reasonable price and the variety of possible applications are other merits of this adhesive.

HASULITH® Vielzweckkleber is used for the manufacturing of fashion jewelry, bridal jewelry, hair ornaments and accessories, toys, gifts, souvenirs, arts and crafts ... and in many other related fields of application.

RECOMMENDED FOR THE GLUING OF

metals, glass, ceramics and china, stone, leather, wood, felt, fabrics, paper, cardboard and some hard plastics (like e.g. Polyacrylates (Plexi), ABS and Celluloseacetates). **HASULITH® Vielzweckkleber** is also very appropriate for gluing glass-, Strass-, or simili-rhinestones to metals and other materials. More details about gluing stones you will find in the „Appendix“ on page 2.

For gluing semi-precious-stones (e.g. lapis-lazuli, turquois, carnelian...) **HASULITH® Vielzweckkleber** is only recommended if the stones are not lubricated or greased for better gloss (but usually they are – please ask your stone supplier). It is not recommended for gluing materials like PVC, PET, Styropor®, PE, PP, rubber, Nylon or soft plastics.

APPLICATION

The gluing areas have to be dry and clean - (free from dust, grease, oil, lubricants and other abherents). For optimum gluing results it is important, that the surfaces to be joined fit well together.

For application **HASULITH® Vielzweckkleber** is put on one side of the parts to be joined. If one or both parts are absorbent materials (e.g. felt, leather, fabrics) the adhesive should be put on both parts. After putting on the adhesive, the parts should be joined immediately with slight pressure. Excesses of adhesive should be removed (e.g. with a cloth) if necessary. Afterwards the gluing should be allowed to get dry on ambient temperature without mechanical stress. In some cases it can be necessary to fix the parts for a few minutes in the desired position until some initial fastness is achieved.

DRYING

Drying time mainly depends on the size of the glued area and the properties of the glued materials. Small gluing areas are quicker dry than bigger ones. If one of the glued parts is permeable to solvents (e.g.leather) drying time is comparatively quicker. If the glued area is not too big, some initial fastness is achieved already after a few minutes.

After one hour drying at ambient temperature, the glued objects can be handled with some care (e.g. moved to another place). Over night usually the gluing strength is good enough to pack and mail the glued objects. Because of the variety of possible applications the total drying time can not be predicted precisely, but as a rule of thumb maximum bond strength is achieved after 12-24 hours in most cases.

SEPARATION OF GLUED PARTS/CLEANING

If the glued materials are resistant against solvents (e.g. metal, glass, china, ceramics) the gluing can be separated by dipping the glued objects into **Thinner for HASULITH® Vielzweckkleber (Art.-No. 3VVZK)** until the dried adhesive is dissolved. Please notice, that lacquers, paint or plastics (or other solvent-sensitive parts) on the objects might be removed resp. attacked by the thinner as well. The thinner also can be used to clean spilled adhesive on surfaces which are resistant against solvents.

SAFETY



highly flammable



irritant

R 11-36-37-66-67

S 2-7/9-16-20/21-23-24/25-26-33

Highly flammable. Irritating to eyes. Keep out of reach of children. Keep away from sources of heat or ignition. Don't smoke, eat or drink on working. Use only in thoroughly ventilated areas. Don't breathe the vapours and wear goggles for eye protection. After swallowing: see a physician immediately.

WARNING: Intentional misuse by deliberately inhaling the vapours from this product can be harmful or fatal.

STORAGE / HANDLING / WASTE

HASULITH® Vielzweckkleber should be stored well closed in a cool, dark and dry place – not together with foodstuff or drugs. In tubes it can be stored for a few years. In PE-plastic containers the adhesive will get a little bit thicker after several month because some loss of solvents by diffusion through the PE will occur (especially if stored too warm in small containers). Also frequent opening of the container will lead to some loss of solvents.

In this case some **Thinner for HASULITH® Vielzweckkleber (Art.-No. 3VVZK)** can be added until the adhesive get back the original viscosity. Completely dry adhesive residues in small amounts can be wasted with the household rubbish. Bigger quantities or not completely dry adhesive have to be wasted as hazardous waste according to the local regulations.

AVAILABLE CONTAINERS

1VZK-T	tube	31 ml
-K	box with 100 tubes	100 x 31 ml
-025W	PE-wide neck bottle	250 ml
-050W	PE-wide neck bottle	500 ml
-1W	PE-wide neck bottle	1000 ml
-5	PE-canister	5 lt
-10	PE-canister	10 lt

Other units (e.g. bottles with nozzles, steel cans) or bulk quantities on request. For resellers **HASULITH® Vielzweckkleber** is also available in containers without label or we can label and pack it according to customers demand. On a minimum order of 10 000 tubes **HASULITH® Vielzweckkleber** can be supplied individually printed, according to customers demands.

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APPENDIX – SOME IMPORTANT HINTS FOR THE GLUING OF STONES WITH HASULITH VIELWECKKLEBER

As already mentioned, **HASULITH® Vielweckkleber** is also very suitable for gluing glass-, Strass-, or simili-rhinestones especially to metals but also to materials like glass, ceramics, china and hard plastics like Polyacrylates. The diameter of the stones should be about 5 mm or bigger. For gluing smaller stones, our special **Strass Adhesive 244** (Art.No.:1SK244) should be used. For very big resp. heavy stones or if the stones don't fit well to the recesses, settings or the substratum, we recommend to use our two-component adhesive **HASULITH® Duo** (Art.No.: 1HDCV20L).

Plastic stones usually can not be glued with **HASULITH® Vielweckkleber** because the solvents in the adhesive will attack the plastic stones. For gluing plastic stones we recommend our solvent-free **HASULITH® Dispersion Glue P** (Art.No.: 1PMK). This glue is also recommended to glue glass-or simili-rhinestones to a variety of plastics.

For getting the optimum fastness and best bond strength, the stones should fit to the settings as good as possible – like shown in illustration a). If there are too strong deviations like shown in illustration b), c) and d) no satisfactory results can be expected.

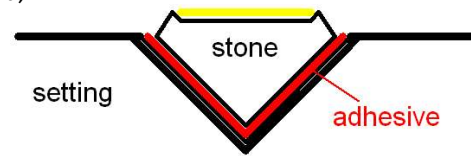
In case of c) resp. d) good results can be obtained if a two-component adhesive (e.g. our **HASULITH® Duo**) is used for the gluing. Only a two-component adhesive is able to fill the big gap between stone and setting completely.

In case of illustration b) using a two-component adhesive will lead to better but maybe not totally satisfactory results because the point of weakness on the side part of the stone will remain.

Problems also may occur if flat back stones are glued on strong curved areas. In this case also the gluing area is very small and the gap between stone bottom and substratum too big. In this case a high viscous or thixotropic two-component adhesive (like **UHU Plus endfest** or our **HASULITH® Duo +Thix- additive 1384**) should be used to obtain the maximum fastness.

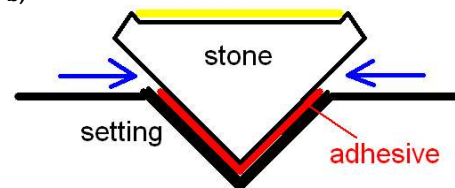
Regarding the quality of simili-rhinestones it is important, that the metal mirror and the protective bronze-coating on the bottom of the stone have good adhesion to each other resp. to the stone. If this adhesion is bad, even the strongest adhesive can not prevent the stone from coming out. Bad adhesion between glass and mirror becomes obvious when the rhinestone comes out and the mirror will stick together with the adhesive to the setting. Wrongly this is interpreted sometimes as a lack of bonding strength of the adhesive. (Actually in this case the bonding strength of the adhesive is very good – just the adhesion between the glass and the mirror is too weak).

Illustration a)



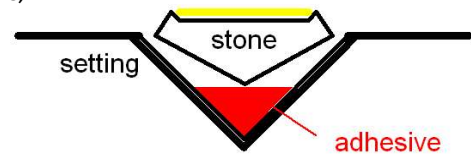
Ideal case of a gluing. The stone fits well to the setting. Maximum gluing area – optimum adhesion and bond strength.

Illustration b)



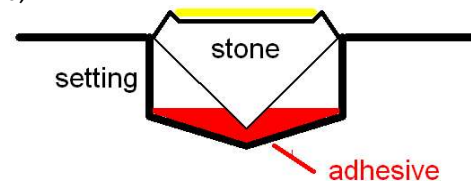
The stone is too big and stands out of the setting so the gluing have some point of weakness -especially against mechanical stress to the side parts. The gluing area is comparatively small. Some bending or peeling stress to the stone and it will come out.

Illustration c)



The angle of the stone is very different to the angle of the setting. Most of the adhesive collect at the bottom of the setting. Almost no or very small gluing area. Some push or bump to the object and the stone will jump out.

Illustration d)



Cylindrical setting. The adhesive collect at the bottom of the setting. Gap filling not possible. Almost no or very small gluing area.