



# STARFIX PH-24

(Phenolic Foam Adhesive)

## DESCRIPTION

**PH-24** is inflammable, heat resistant, one component adhesive. **PH-24** is a blend of Polychloroprene rubber with special tackyfier and additives. It is specially developed for Pre Insulated Phenolic foam Air Duct.

## PROPERTIES

**PH-24** has correct balance of wet and dry tack with smooth flow properties, uniform film and fast drying characteristics. **PH-24** is having very good heat and fire retardant properties. **PH-24** is having very good cohesive and bonding strength.

## APPLICATION

**PH-24** has excellent adhesion to Phenolic v/s Phenolic applications. It is also compatible with range of metal substrate as well. Used for Pre Insulated Air Duct System, Pre Insulated Pipe sections, Pre Insulated slabs etc.

## SURFACE PREPARATION

Before applying, the surface should be prepared clean and free from dust loose shavings, oil and grease.

## DIRECTION OF USE

Apply **PH-24** either with brush or pressure feeding equipment to a uniform coat.  
Allow 10 to 15 minutes to evaporate the complete solvent, and then assemble the surface by applying normal hand pressure to give strong bond.

## OPEN TIME

Open time varies from 10 to 15 minutes depending on thickness of layers of adhesive, substrate type, moisture and temperature.

## COVERAGE

The wet coverage of **PH-24** is 4 to 6 m<sup>2</sup> /kg subjected to the applied film thickness. The recommended wet film thickness is 100 to 120 mic. To get proper coverage always keep the container's spout closed to prevent the solvent evaporation.

## CAUTION

Adequate ventilation must be maintained particularly in confined spaces. Due to volatile in nature of solvent keep away from source of ignition such as pilot lights or sparks. Prohibition of smoking must be rigidly enforced in the vicinity of use.

## STORAGE & SHELF LIFE

Store under cover, protect from direct sunlight and high temperature (>25<sup>0</sup>C). Shelf life is up to 12 months in unopened container when stored as directed.

Failure to comply with the recommended storage conditions may result in premature deterioration of the product or packaging. Please follow the petroleum regulation and law of the land.



**CLEANING**

Clean all the tools with aromatic solvent.

**PACKING**

**DG-PH-24** is available in 15 liters spouted metal pail.

**HEALTH & SAFETY**

As with all chemicals, caution should always be exercised. Protective clothing such as gloves and goggles should be worn.

**INHALATION:** Inhalation of vapor or mist should be avoided. If inhaled symptoms include coughing, wheezing, laryngitis, and shortness of breath, headache, nausea, and vomiting. Immediately shift victim to fresh air, and, if needed immediately start artificial respiration. Give oxygen if breathing is labored. Get emergency medical help.

**EYE CONTACT:** Flush eyes with water for 15 minutes and call for medical help.

**INGESTION:** causes nausea, vomiting, and loss of consciousness. If accidentally

swallowed do not induce vomiting rather call for medical help immediately.

**SKIN CONTACT:** Flush with water or soap and water until all traces have been removed. Seek medical attention if required.

**TECHNICAL DATA**

|                              |                                 |
|------------------------------|---------------------------------|
| Base                         | Synthetic rubber                |
| No. of component             | One                             |
| Color                        | Transparent yellow              |
| Solid                        | 25% ± 2                         |
| Viscosity @ 25°C, S6, rpm 20 | 5000 - 15000 cps (brook field)  |
| Density                      | 0.85 ± 0.10                     |
| Service Temp.                | -20° C to + 120° C              |
| Flash Point                  | Below 10° C                     |
| Water Resistance             | Excellent                       |
| Chemical resistance          | Good                            |
| Application tools            | Brush, Roller and Airless spray |
| Solubility                   | Toluene                         |
| * Flammability               | Flammable (wet product)         |

**WARRANTY**

*The information given is based on our knowledge and performance of the material. Every precaution is taken in the manufacture of the product and responsibility is limited to the quality of supplies with no guarantee of results in the field, as manufacturer has no control over site conditions or execution of work.*

**Star Adhesive & Resin Ind. Factory**

