

Product Data Sheet



STARFIX DG CA 22-10 (PIR)

One Component, High Performance, Inflammable, Synthetic Rubber Based Adhesive

Uses:

- Pre-Insulated PIR Duct Systems & Accessories
- Adhesive to Metal, Aluminum, Ceramic, Concrete and Mild Steel
- Bonding of PIR+PIR Boards to form PIR-Duct Systems
- Bonding of PIR & PU – Foam products

Product Description

STARFIX DG CA 22-10 (PIR) is a single component, inflammable commercially attractive, synthetic elastomer adhesive specially designed for the interior or exterior adhesion and assembly of PIR Duct Systems & Synthetic Materials (Polyethylene Foam, PIR or Phenolic Sheets).

Advantages

- Excellent adhesion properties
- Good resistance to ageing
- Resistance to high temperature up to 180 C
- High green strength
- Chemical resistance
- Excellent abrasion resistance

Standard Compliance

- ASTM C916 Type IV (ASC-A-7001-A, Type IV)

Technical Properties

STARFIX DG CA 22-10 (PIR)	Typical Values & Laboratory Conditions
Color	Transparent Yellow
Viscosity, Cps @25°C, S 3, rpm 20	3,000 – 4,500
Solid Content, % @110°C, 2 hrs	40 – 50
Density, kg/L	0.85 – 0.93
Coverage, m ² /kg	15
Wet Film Thickness, mm per coat	0.1 – 0.2
Flash Point, °C	< 10
Service Temp, °C	-20 to +180 C - 20 to +95 C at High Stress
Open Time, min	10 - 20
Solubility	Aromatic Solvent
Cleaning	Clean all tools immediately with aromatic solvent
Non-Volatile Content	17 – 19% by volume (27 – 30% by weight)
Bond Time	0 to 15 minutes
Wet Flammability	Flash point: -7°F (-22°C)

Product Data Sheet

Application

SURFACE PREPARATION

The surface should be clean, dry, sound and free from oil, grease and wax contamination or others.

PRIMING

Priming is normally not required on Aluminum, PIR or PU substrates.

APPLICATION

STARFIX DG CA 22-10 should be applied on clean, dry, oil-free and sound (To clean surface use power blower) surfaces.

STARFIX DG CA 22-10 should not be thinned.

Brush:

Use a clean paintbrush. Uniformly, apply to metal surface at $4.9 - 9.8 \text{ m}^2/\text{l} = 100 - 130 \text{ mic}$ per coat Press insulation into place, making sure complete contact is made with applied adhesive. Bond may be made after observing the evaporation time within 0 to 15 minutes.

Apply the adhesive on the substrates & wait until solvent is fully evaporated, then assemble the surface by applying normal hand pressure.

Allow the completed joint or assembly to dry at least 24 hours above 25°C before pressure testing.

High humidity (70%) and or cooler temp. may retard drying. Total WFT to be 30-35 mils.

Curing

STARFIX DG CA 22-10 is set to tough within 1h after application and Dried Through within 24h.

Limitations

To resist rain wash off, allow at least 12-15 hours drying time above 4°C , with a relative humidity of 50%. Higher humidity or lower temperatures may retard drying.

Always test foil and paper facings for acceptable adhesion.

Outdoor horizontal surfaces must always drain completely. A pitch of at least 4 cm/m is required.

If used between impermeable surfaces, drying time will be extended.

Cleaning:

Remove STARFIX DG CA 22-10 from product from tools and equipment with STAR Solvent before the initial set. Cured material can only be removed mechanically.

Packing & Coverage:

STARFIX DG CA 22 is packed in 15 ltr pails.

Product	Pack Size	Theoretical Coverage
STARFIX DG CA 22-10	15 ltr pail	Subject to type of surface and nature of material being bonded $4.9 - 9.8 \text{ m}^2/\text{l}$ at wet film thickness of $0.1 - 0.2 \text{ mm}$

Stated consumption data are for general guidance. Actual consumption depends on the nature of substrate, method of application, and wastage.

Shelf Life & Storage:

The original sealed Pail of STARFIX DG CA 22-10 has a shelf life of 12 months, provided it is stored clear of ground in a dry, shaded place below 35°C .

Health & Safety:

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

STARFIX DG CA 22-10 is not considered hazardous – But contains Solvents.

For detailed information and advice on the safe handling, storage, and disposal of chemical products, users shall refer to the most recent Material Safety Data Sheet containing physical, ecological, toxicological, and other safety-related data.

Product Data Sheet

Additional Information:

STAR manufactures a wide range of construction chemicals and specialty products for various applications divided into the following product sections:

1. **Waterproofing Products**
2. **Sealants, Grouts, and Joint Fillers**
3. **Adhesives**
4. **HVAC – Adhesives, Coatings & Sealants**
5. **Flooring Products**
6. **Industrial Adhesives (i.e. Paper Industry)**
7. **Accessories**

STAR Technology provides various technical information such as detailed method statements, specification clauses, application manuals and technical support both in contractors and consultant's offices as well as construction sites.

For further information on these products and systems kindly visit our website or contact your local STAR representative