

Product Data Sheet



STARBOND 85-60

One Component, High Performance, Inflammable, Synthetic Resin-Water Based Duct Adhesive

Uses:

- HVAC – Duct Liner Systems
- Adhesive to Metal, Aluminum, Ceramic, Concrete and Mild Steel
- Bonding of fibrous Insulation Materials to Duct substrates and various other substrates
- Bonding of various duct liners to the Duct

Product Description

STARBOND 85-60 is a single component, inflammable commercially attractive, water based adhesive designed for the interior or exterior adhesion of Fibrous Insulation Materials or Ducts Wrapping Materials (Rubber or PVC Covers or Membranes) to metal ducts as wrapping, protection and acoustical linings.

Advantages

- Economical
- Quick Setting
- Non-Flammable
- Excellent adhesion & High strength
- Excellent bonding of Fibrous Materials to GI-Sheets

Standard Compliance

- ASTM D 1475
- ASTM D 2369

Technical Properties

STARBOND 85-60	Technical Properties @ Laboratory Conditions
Physical Appearance	Thixotropic Fine Texture Adhesive
Color	Beige
Viscosity, cps	15,000 – 25,000
Solid Content, %	60 - 67
Density, kg/L	1.20
Coverage, m2/kg	4.5 – 7.5
Open Time, min	5 - 15
Flash Time, min	25 - 30
VOC	< 120 g/L

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Application

Surface Preparation

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

Application

STARBOND 85-60 should be applied on clean, dry, oil-free and sound (To clean surface use power blower) surfaces.

STARBOND 85-60 should not be thinned.

Brush:

Use a clean paintbrush. Uniformly, apply to metal surface at 4.9 – 9.8 m²/l = 100 – 130 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 10 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

STARBOND 85-60 is set to tough within 1h after application and Dried Through within 24h.

Cleaning

Remove **STARBOND 85-60** from product from tools and equipment with warm water before the initial set. Cured material can only be removed mechanically.

Packing & Coverage

STARBOND 85-60 is packed in 2.4 Kg, 12KG pails.

Product	Pack Size	Theoretical Coverage
STARBOND 85-60	2.4 & 12 Kg pail	Subject to type of surface and nature of material being bonded 4.5 – 7.5 m ² /Kg

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 **STARBOND 85-60** has a shelf life of 12 months, provided it is stored clear of ground in a dry, shaded place below 35°C.

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.

Health & Safety:

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

STARBOND 85-60 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.

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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