

Bond and Seal structural adhesive

Elastic PU adhesive and sealant for a wide range of applications

For universal use

Outstanding adhesive strength on a wide range of materials and surfaces

Approved for use with foodstuffs (ISEGA certificate)

- Harmless to humans in its hardened state
- Suitable for adhering and sealing in food processing plants

Highly elastic

- Can be used for joining different materials and materials of the same type
- Compensates different material expansions
- Dampens vibrations and noise

Long skin formation time

- Allows complex components to be bonded and sealed
- Also ideal for large surfaces
- Joint parts can be repositioned

Can be sanded and painted over

Following skin formation, it can be mechanically machined and painted over without surface activation (perform preliminary tests to check paint compatibility).

Non-corrosive

Prevents metal corrosion

Low-odour

Silicone-free



Chemical basis	Single component polyurethane
Min./max. skin-formation time	45-60 min
Full curing speed/conditions	3 mm/d/23 °C and 50% relative humidity, moisture curing
Min./max. processing temperature	5 to 35 °C
Shelf life from production/conditions	12 Month/at 10 °C to 25 °C

Contents	Container	Colour	Min./max. temperature resistance	Short term temperature resistance max./conditions	Art. no.	P. Qty.
300 ml	Cartridge	White	-40 to +90 °C	120 °C/after 8 hours	0890 100 1	1/12/24
300 ml	Cartridge	Grey	-40 to +90 °C	120 °C/after 8 hours	0890 100 2	1/12/24

Contents	Container	Colour	Min./max. temperature resistance	Short term temperature resistance max./conditions	Art. no.	P. Qty.
300 ml	Cartridge	Black	-40 to +90 °C	120 °C/after 8 hours	0890 100 3	1/12/24
300 ml	Cartridge	Dark brown	-40 to +90 °C	120 °C/after 8 hours	0890 100 4	1/12
300 ml	Cartridge	Light brown	-40 to +90 °C	120 °C/after 8 hours	0890 100 5	1/12
300 ml	Cartridge	Sand beige	-40 to +90 °C	120 °C/after 8 hours	0890 100 6	1/12
70 ml	Tube	White	-40 to 90 °C	120 °C/after 8 hours	0890 100 11	1/24
70 ml	Tube	Black	-40 to +90 °C		0890 100 31	1/24
400 ml	Bag	White	-40 to 90 °C	120 °C/after 8 hours	0890 100 111	12
400 ml	Bag	Grey	-40 to +90 °C		0890 100 112	12
400 ml	Bag	Black	-40 to 90 °C	120 °C/after 8 hours	0890 100 113	12
600 ml	Bag	White	-40 to 90 °C	120 °C/after 8 hours	0890 100 181	20
600 ml	Bag	Grey	-40 to 90 °C	120 °C/after 8 hours	0890 100 182	20
600 ml	Bag	Black	-40 to 90 °C	120 °C/after 8 hours	0890 100 183	20

Details/Application

- For a range of bonding and sealing tasks
- Suitable for adhering and sealing in food processing plants
- For the permanently elastic sealing of spot weld seams



Bond and Seal products	B+S	B+S Power	B+S Fast	B+S Combi
	0890 100 1 - 6	0893 235 1	0890 100 710	0893 236 110
	0890 100 111 - 3	0893 235 2	0890 100 720	0893 236 120
	0890 100 181 - 3	0893 235 3	0890 100 730	0893 236 130
	0890 100 11 + 13			

Metal	Aluminium	√ 1	√ 4	√ 1	√ 1
	Lead	x	x	x	x
	Stainless steel	√ 1	√ 4	√ 1	√ 1
	Copper	√ 1	√ 1	√ 1	√ 1
	Brass	√ 1	√ 1	√ 1	√ 1
	Steel/iron	√ 1	√ 4	√ 1	√ 1
	Zinc	√ 1	√ 4	√ 1	√ 1
Plastics	ABS	√ 2	√ 2	√ 2	x
	GFRP	√ 2	√ 2	√ 2	√
	Rubber/neoprene	x	x	x	√
	Hard foams	√ 2	√ 2	√ 2	√
	PE	x	x	x	x
	PMMA	√ 5	√ 5	√ 5	-
	Polyamide	√ 5	√ 5	√ 5	√
	Polycarbonate = PC	√ 5	√ 5	√ 5	-
	Polystyrene (not foam!)	√ 2	√ 2	√ 2	-
	PP	-	-	-	-
	PTFE	-	-	-	-
	Polyurethane = PU	√ 2	√ 2	√ 2	√
	Hard PVC	√ 2	√ 4	√ 2	√
	Silicone	-	-	-	-
Polystyrene	-	-	-	-	

Surface must be pre-treated, please refer to the technical data sheets depending on the application.

- 1. Prime with Primer for Metal 0890 100 61**
- 2. Prime with Primer for P/W/S 0890 100 62**
- 3. Pre-treat with deep-penetrating primer 0890 545 10**
- 4. Pre-treat with Activating Cleaner, 0890 100 60**
- 5. Varioprimer safe + easy, 0890 024 021/0890 024 101**

Bond and Seal products		B+S 0890 100 1 - 6 0890 100 111 - 3 0890 100 181 - 3 0890 100 11 + 13	B+S Power 0893 235 1 0893 235 2 0893 235 3	B+S Fast 0890 100 710 0890 100 720 0890 100 730	B+S Combi 0893 236 110 0893 236 120 0893 236 130
Painted surfaces	Two-part paints, stove enamels, cathodic dip painted panels	√ 4	√ 4	√ 4	√ 4
Wood and wooden materials	Wood (including MDF, chipboard)	√ 2	√ 2	√ 2	√ 2
	Laminated panels (Resopal, Ultrapas)	√ 4	√ 4	√ 4	
	HPL	√ 4	√ 4	√ 4	√ 4
	Decorative boards	√	√	√	√
	Cork	√ 2	√ 2	√ 2	√

Stone and construction materials	Concrete	√ 2	√ 2	√ 2	√ 2
	Bituminous substrates	-	-	-	-
	Aerated concrete, gypsum, gypsum plasterboard	√ 3	√ 3	√ 3	√ 3
	Synthetic stone (Corian, Varicor)	√ 2	√ 2	√ 2	√
	Delicate natural stone (e.g. marble)	-	-	-	-
	Natural stone, brick	√ 2	√ 2	√ 2	√ 2
	Cement fibreboards	√ 3	√ 3	√ 3	√
Other	Enamel	√ 5	√ 4	√ 5	√ 4
	Glass	√ 5	√ 4	√ 5	√ 4
	Fibreglass	-	-	-	-
	Mirror	-	-	-	-
	Porcelain, ceramic, tiles	√ 5	√ 4	√ 5	√ 5
	Paper	√	√	√	√
	Cardboard	√	√	√	√
	Mesh	-	-	-	-
	Leather	-	-	-	-

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Optimisation table		
Surface/material	Optimisation steps*	Notes
Anodised aluminium	1. Activating Cleaner 2. Primer for metal	-
Aluminium (AlMg3, AlMgSi1)	1. Clean thoroughly using IPA cleaner 2. Sand lightly with a very fine abrasive fleece 3. Clean again using IPA cleaner 4. Activating Cleaner 5. Primer for metal	-
Non-ferrous base metals (brass, copper, bronze etc.)		The use of Primer for metal is mandatory!
Stainless steel (rustproof)		-
Steel (St 37 etc.)		In components susceptible to corrosion: 2-component PU or epoxy corrosion protection required!
Zinc-plated steel (hot-dip or galvanised)		-
Zinc	-	-
Powder coatings (PES, EP/PES)	Activating Cleaner	Preliminary testing is recommended for applications involving significant forces or a damp environment.
2-component top-coat, water or solvent-based (PUR, acrylic)	Varioprimer safe + easy	Due to the large number of paints available, this information is only a guide. Please perform preliminary tests where necessary.
2-component primers, water or solvent-based (PUR, acrylic, epoxy resin)	Varioprimer safe + easy	-
Cathodic dip coating (E-coating)	Activating Cleaner	-
Coil-coat coating	Activating Cleaner	-
ABS	1. Activating Cleaner 2. Primer for P/W/S	The sanding process can be omitted for parts subjected to little load.
* Follow the corresponding sequence of the individual steps		

Optimisation table		
Surface/material	Optimisation steps*	Notes
GFRP (unsaturated polyester), gelcoat side or SMC	<ol style="list-style-type: none"> 1. Clean thoroughly using IPA cleaner 2. Sand with a very fine or grit 60-80 abrasive fleece and then vacuum 3. Clean again using IPA cleaner 4. Activating Cleaner 5. Primer for P/W/S 	Adhesive surface must be protected against UV radiation (opaque cover).
Hard PVC	<ol style="list-style-type: none"> 1. Activating Cleaner 2. Primer for P/W/S 	-
PMMA/PC (without scratch-resistant coating)	Varioprimer safe + easy	Adhesive surface must be protected against UV radiation (opaque cover).
Polyamide	Varioprimer safe + easy	-
Wood, plywood, MDF, wood products and cork	<ol style="list-style-type: none"> 1. Dust removal 2. Primer for P/W/S 	-
HPL laminated panels (Resopal, Ultrapas)	Activating Cleaner	-
Glass	Varioprimer safe + easy	Adhesive surface must be protected against UV radiation (opaque cover).
Enamel, porcelain, ceramic, tiles	<ol style="list-style-type: none"> 1. Activating Cleaner or IPA cleaner 2. Varioprimer safe + easy 	-
Concrete, mineral mortar, plaster and cement fibre board	<ol style="list-style-type: none"> 1. Dust removal 2. Deep-penetrating primer 	-
Synthetic stone (Corian, Varicor)	<ol style="list-style-type: none"> 1. Activating Cleaner 2. Primer for P/W/S 	-
* Follow the corresponding sequence of the individual steps		

Instructions

The application surfaces must be clean, dry and free of grease. For pre-treatment, please refer to the optimisation table in the technical data sheet.

Cut off the thread cap, screw on the nozzle and cut it to the required width. Apply the adhesive using a suitable application gun. A minimum adhesive layer thickness of 3 mm is recommended to harness the benefits of thick-coat bonding.

For more information, please refer to the technical data sheet.

Proof of performance

ISEGA:

Can be used where food is processed or stored, e.g. for bonding wall and floor areas in food processing companies.

Clearance certificate no.: 46567 U 18



Notice

- Not suitable for glass groove sealing or adhesive bonding on other transparent materials with risk of UV back reflection.
- Direct exposure to sunlight can result in slight surface yellowing and crack formation.
- Not suitable for expansion joints in construction applications.
- PVC-based paints and paints that dry by oxidation (oil and alkyd resin-based paints) are not suitable for painting over the adhesive.
- The use of Würth sealant smoothing agent can cause yellowing.

- Caution: Contact with solvents or solvent residues should be avoided, in particular during processing and the curing phase. This can lead to permanent damage of the Bond + Seal.
- Caution: In the case of high surface moisture, very wide adhesive bead application, and/or cavities/air pockets created, back-fill foams in the application, there is a risk of bubble formation in the adhesive compound.

The usage instructions are recommendations based on the tests we have conducted and on our experience; carry out your own tests before each application. Due to the large number of applications and storage and processing conditions, we do not assume any liability for a specific application result. If our free customer service provides technical information or acts as an advisory service, no responsibility is assumed by this service except where the advice or information given falls within the scope of our specified, contractually agreed service or the advisor was acting deliberately. We guarantee the uniform quality of our products. We reserve the right to make technical changes and further develop products. Please refer to the technical data sheet.

Related products	Art. no.
Standard application nozzle For 300 ml + 310 ml metal cartridges (fine thread)	0890 100 099
HaftClean activating surface cleaner	0890 100 60
Surface bonding agent Primer for Metal	0890 100 61
Surface bonding agent Adhesion Plus for plastic/wood/stone	0890 100 62
Adhesive remover	0890 100 63
Caulking gun up to 300 ml 14:1	0891 400 610
V-Cut special cartridge nozzle	0891 651 13

Related products for	Designation	Art. no.
0890 100 1	Juniorfix pneumatic application gun	0703 891 310
	Cartridge gun 24:1	0891 310 10
	Cordless application gun AKP 12 COMPACT M-CUBE	5701 107 004
	Cartridge cutter	0715 66 09
	HaftClean activating surface cleaner	0890 100 60
	Surface bonding agent Primer for Metal	0890 100 61
	Surface bonding agent Adhesion Plus for plastic/wood/stone	0890 100 62
	Adhesive remover	0890 100 63
	V-Cut special cartridge nozzle	0891 651 13
	Application nozzle Standard For 310 ml plastic cartridges (coarse thread)	0891 653
Tex-Rein cleaning cloth	0899 810	
0890 100 2	Juniorfix pneumatic application gun	0703 891 310
	Cartridge gun 24:1	0891 310 10
	Cordless application gun AKP 12 COMPACT M-CUBE	5701 107 004
	Cartridge cutter	0715 66 09
	HaftClean activating surface cleaner	0890 100 60
	Surface bonding agent Primer for Metal	0890 100 61
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	Adhesive remover	0890 100 63
	V-Cut special cartridge nozzle	0891 651 13
	Application nozzle Standard For 310 ml plastic cartridges (coarse thread)	0891 653
Tex-Rein cleaning cloth	0899 810	

Related products for	Designation	Art. no.
0890 100 3	Juniorfix pneumatic application gun	0703 891 310
	Cartridge gun 24:1	0891 310 10
	Cordless application gun AKP 12 COMPACT M-CUBE	5701 107 004
	Cartridge cutter	0715 66 09
	HaftClean activating surface cleaner	0890 100 60
	Surface bonding agent Primer for Metal	0890 100 61
	Surface bonding agent Adhesion Plus for plastic/wood/stone	0890 100 62
	Adhesive remover	0890 100 63
	V-Cut special cartridge nozzle	0891 651 13
	Application nozzle Standard For 310 ml plastic cartridges (coarse thread)	0891 653
	Tex-Rein cleaning cloth	0899 810
0890 100 4	Juniorfix pneumatic application gun	0703 891 310
	Cartridge gun 24:1	0891 310 10
	Cordless application gun AKP 12 COMPACT M-CUBE	5701 107 004
	Cartridge cutter	0715 66 09
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0890 100 5	Juniorfix pneumatic application gun	0703 891 310
	Cartridge gun 24:1	0891 310 10
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	V-Cut special cartridge nozzle	0891 651 13
	Application nozzle Standard For 310 ml plastic cartridges (coarse thread)	0891 653
	Tex-Rein cleaning cloth	0899 810
0890 100 6	Juniorfix pneumatic application gun	0703 891 310
	Cartridge gun 24:1	0891 310 10
	Cordless application gun AKP 12 COMPACT M-CUBE	5701 107 004
	Cartridge cutter	0715 66 09
	HaftClean activating surface cleaner	0890 100 60
	Surface bonding agent Primer for Metal	0890 100 61
	Surface bonding agent Adhesion Plus for plastic/wood/stone	0890 100 62
	Adhesive remover	0890 100 63
	V-Cut special cartridge nozzle	0891 651 13
	Application nozzle Standard For 310 ml plastic cartridges (coarse thread)	0891 653
	Tex-Rein cleaning cloth	0899 810
0890 100 111	Druckfix pneumatic application gun	0703 891 600
	Pack gun 24:1 to 600 ml	0891 400 620
	HaftClean activating surface cleaner	0890 100 60
	Surface bonding agent Primer for Metal	0890 100 61
	Surface bonding agent Adhesion Plus for plastic/wood/stone	0890 100 62
	Adhesive remover	0890 100 63
	Standard application nozzle For bags	0891 601 001
	Tex-Rein cleaning cloth	0899 810

Related products for	Designation	Art. no.
0890 100 112	Druckfix pneumatic application gun	0703 891 600
	Pack gun 24:1 to 600 ml	0891 400 620
	HaftClean activating surface cleaner	0890 100 60
	Surface bonding agent Primer for Metal	0890 100 61
	Surface bonding agent Adhesion Plus for plastic/wood/stone	0890 100 62
	Adhesive remover	0890 100 63
	Standard application nozzle For bags	0891 601 001
0890 100 113	Tex-Rein cleaning cloth	0899 810
	Druckfix pneumatic application gun	0703 891 600
	Pack gun 24:1 to 600 ml	0891 400 620
	HaftClean activating surface cleaner	0890 100 60
	Surface bonding agent Primer for Metal	0890 100 61
	Surface bonding agent Adhesion Plus for plastic/wood/stone	0890 100 62
	Adhesive remover	0890 100 63
0890 100 181	Standard application nozzle For bags	0891 601 001
	Tex-Rein cleaning cloth	0899 810
	Druckfix pneumatic application gun	0703 891 600
	Pack gun 24:1 to 600 ml	0891 400 620
	HaftClean activating surface cleaner	0890 100 60
	Surface bonding agent Primer for Metal	0890 100 61
	Surface bonding agent Adhesion Plus for plastic/wood/stone	0890 100 62
0890 100 182	Adhesive remover	0890 100 63
	Standard application nozzle For bags	0891 601 001
	Tex-Rein cleaning cloth	0899 810
	Druckfix pneumatic application gun	0703 891 600
	Pack gun 24:1 to 600 ml	0891 400 620
	HaftClean activating surface cleaner	0890 100 60
	Surface bonding agent Primer for Metal	0890 100 61
0890 100 183	Surface bonding agent Adhesion Plus for plastic/wood/stone	0890 100 62
	Adhesive remover	0890 100 63
	Standard application nozzle For bags	0891 601 001
	Tex-Rein cleaning cloth	0899 810
	Druckfix pneumatic application gun	0703 891 600
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	HaftClean activating surface cleaner	0890 100 60