

# BLACKGLUE 01

**BLACKGLUE 01** is a fast-curing, two-component polyurethane adhesive specially formulated for bonding anchors and repairing a wide range of materials used in orthopedics (metal, plastic, composites, wood, foams...). It is a strong structural adhesive resistant to elevated temperatures, moisture, most solvents, and chemicals and that can be quickly sanded.

Easy to use thanks to its specific rheology, this product has a perfect working time to fix any parts together while keeping a high productivity.

- Easy and very fast sanding (after 3 minutes)
- Thixotropic, does not drip, allowing vertical application
- No shrinkage
- Suitable for most plastics
- Good impact resistance
- Non-CMR (Carcinogenic, Mutagenic, Reprotoxic)\*

## Implementation of components

**BLACKGLUE 01** packaged in 50 ml and 220 ml cartridges requires the use of a 1:1 two component manual or pneumatic dispensing gun to extrude the system.

### IMPLEMENTATION CONDITIONS

Recommended operating temperature (°C)	18 to 30
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The adhesive must be applied on a clean and dry surface free of grease, dust, etc. For the choice of a degreaser, consult our technical department.

Start extruding the glue without mixer to equalize the levels of the two components, place the mixer and remove the first milliliters of the extruded cordon.

Apply the adhesive to one or all the parts to be assembled. Bring the two parts to be bonded together within the recommended working time. Hold the pressure for a few moments to allow the adhesive to set. Then release the pressure and allow the adhesive to cure.

After a few minutes, you can sand your bonding with 80-180 abrasive paper. Then wait for the weight loading time before stressing the assembly.

\*in compliance with European regulation no. 1272/2008, known as CLP for classification, labelling and packaging from 13/10/2023.



## Characteristics of the polymerized product

Shore D Hardness, EN ISO 868  
@23 °C: 73

Tensile strength, EN ISO 527 @23 °C  
(MPa): 26

Elongation at break, EN ISO 527  
@23 °C (%): 58

## Characteristics of the liquid product

### Aspect:

Part A: black / Part B: white  
Mix: deep black

### Density:

Approx. 1.25 for the two components

### Mixing ratio in volume:

1:1

**BLACKGLUE 01** can be cleaned with acetone (uncured adhesive). Hands and skin should be cleaned immediately with water and a suitable soap. Do not use solvents on your skin.

## Reactivity

**BLACKGLUE 01** polymerizes when the two components are mixed and cures at room temperature. Heat accelerates curing (time is halved for a 10°C increase) and thus reduces working time.

The volume mixing ratio 1:1 is perfectly respected thanks to the design of the two-component cartridge mixer. The bonding remains adjustable during working time. The temperature of the area to be bonded must be below 50°C.

REACTIVITY	
Working time at 23 °C / 50% RH	90''
Sand time at 23 °C	3'
Weight loading at 23 °C	10'

## Packaging

The **BLACKGLUE 01** system is available in 50 ml and 220 ml two-component cartridges (including 3 mixers). Complementary products are available for purchase separately.

NAME	PACKAGING	REFERENCE
BLACKGLUE 01 - 50 ml	1 unit	BG01 C501
MIXER FOR 50 ml CARTRIDGE	3 units	EMBC50 003
MIXER FOR 50 ml CARTRIDGE	36 units	EMBC50 036
MIXER FOR 50 ml CARTRIDGE	144 units	EMBC50 144
MANUAL DISPENSING GUN FOR 50 ml CARTRIDGE	1 unit	PISC50 001
BLACKGLUE 01 - 220 ml	1 unit	BG01 C221
MIXER FOR 220 ml CARTRIDGE	3 units	EMBC220 003
MIXER FOR 220 ml CARTRIDGE	36 units	EMBC220 036
MIXER FOR 220 ml CARTRIDGE	144 units	EMBC220 144
MANUAL DISPENSING GUN FOR 220 ml CARTRIDGE	1 unit	PISC220 001

## Storage, handling and safety

**BLACKGLUE 01** has a shelf life of 24 months from the date of manufacture, stored in a dry place at a temperature of 18°C - 30°C, in its original unopened packaging. Do not expose to direct sunlight or frost.

It is essential that appropriate protective measures are strictly observed during handling:

- ventilated rooms
- wearing gloves and glasses
- waterproof clothing

For further information, please refer to the MSDS.

## Customs' code

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BG01 C501	35069900
EMBC50 003	39269097
EMBC50 036	39269097
EMBC50 144	39269097
PISC50 001	84671190
BG01 C221	35069900
EMBC220 003	39269097
EMBC220 036	39269097
EMBC220 144	39269097
PISC220 001	84671190

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The user of this product undertakes to respect the current legislation for the elimination of waste.*