

Henkel Technology Center

Test report BS6JUP-CAHL

Customer

Style Doors
Athens
Greece

Final report

Test date: 13.08.2020

Examiner: Helga Sandmeyer

Test material

Type of adhesive	Kind of adhesive
• TECHNOMELT [®] PUR 4655	• PUR
Carrier board	Kind of profile
• Aluminum preprimed	•
Substrate	Manufacturer
• PVC foil (exterior use)	• Hornschuch
Type of primer	Kind of primer
• TECHNOMELT [®] PUR PRIMER 6B-23	• Solvent based

Test methods

• Adhesion test

(HENKEL[®]-test method 901)

• Climate change test BMW

(internal BMW test method)

BMW Climate alternate test

Time h	Temperature °C	Humidity %
0	23	50
1	cooling	
2	-10	1
2	heating	
9	60	95
1	heating	
9	80	60
2	cooling	
0	23	50
2	cooling	
2	-30	1
1	heating	

1 cycle 43h
X
4 loops
= 172h

Test results

TECHNOMELT [®] PUR 4655	
Adhesion (HENKEL [®] judging criteria)	2 good bond strength
BMW Climate alternate test	
Climate change test BMW (o = passed/ x = failed)	O = passed
Adhesion (HENKEL [®] Notensystem)	2-3 good-satisfactory bond strength

Conclusion

TCS tested the received sample for adhesion before and after the BMW Climate alternate test.

The bonded sample from the customer shows a good bond strength and a good adhesion to the primed aluminum.

During the climate alternation acc. BMW alternate test no joint opening was observed.
After the climate alternation the adhesion is slightly lower than before.