

# Henkel Technology Center Test report BUYC2W-GMOR



## Customer

Style Doors  
Athens  
Greece

## Final report

Test date: 10.11.2020

Examiner: Helga Sandmeyer

## Test material

<b>Type of adhesive</b>	<b>Kind of adhesive</b>
• TECHNOMELT <sup>®</sup> PUR 5300	• PUR
<b>Carrier board</b>	<b>Substrate</b>
• WPC profile (sanded) No.1,2,3 (New formula)	• PVC foil (exterior use)

## 6. Test methods

• Adhesion test

(HENKEL<sup>®</sup>-test method 901)

• Climate change test BMW

(internal BMW test method)

### BMW Climate alternate test

1 cycle 43h  
X  
4 loops  
= 172h

Time h	Temperature °C	Humidity %
6	23	50
1		cooling
2	-10	1
2		heating
9	60	95
1		heating
9	60	60
2		cooling
6	23	50
2		cooling
2	-30	1
1		heating

## HENKEL<sup>®</sup> judging criteria

1	<b>very high bond strength</b>	(strong and complete tear from the carrier board, cohesion failure)
2	<b>high bond strength</b>	(complete tear from the carrier board, cohesion failure)
3	<b>satisfactory bond strength</b>	(low tear from the carrier board, partial adhesion failure)
4	<b>low bond strength</b>	(minimal tear from the carrier board, distinct adhesion failure)
5	<b>very low bond strength</b>	(no tear from the carrier board, complete adhesion failure)
*	<b>Downgrade by one note because of adhesion failure</b>	

## Test results

WPC No.	1.	2.	3.
Sanded	✓	✓	✓
Adhesion (HENKEL <sup>®</sup> judging criteria)	2 good bond strength full fiber tearing from WPC	2 good bond strength full fiber tearing from WPC	2 good bond strength full fiber tearing from WPC
<b>Climate change test BMW</b>			
Climate change test BMW (o = passed/ x = failed)	o = passed	o = passed	o = passed

## Conclusion

The samples we received from the customer with TECHNOMELT PUR 5300 were tested in our lab according to customer wishes.

Perform an adhesion before / after climate alternation test according BMW.

The bonded samples show a good bond strength.

After the climate alternation test there is no joint opening visible, but the adhesion is slightly lower than before.

The sample passed the test climate test.