Henkel Technology Center
Test report BUYC3C-GMOR

Customer

Style Doors
Athens
Greece

Final report

Test date:	10.11.2020	**Examiner:**	Helga Sandmeyer

Test material

Type of adhesive	**Kind of adhesive**
• TECHNOMELT® PUR 5300	• PUR
Carrier board	**Substrate**
• Aluminum lacquered	• PVC foil (exterior use)

Test results

Adhesion (HENKEL® judging criteria)	1-2 high bond strength
BMW Climate alternate test	
Climate change test BMW (**o** = passed/ **x** = failed)	O = passed
Adhesion (HENKEL® Notensystem)	1-2 high bond strength

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 %
6	23	50
1	cooling	
2	-10	1
2	heating	
9	60	95
1	heating	
9	80	60
2	cooling	
6	23	50
2	cooling	
2	-30	1
1	heating	

1 cycle 43h
X
4 loops
=
172h

Conclusion

TCS performed a suitable climate test with the received sample bonded with TECHNOMELT PUR 5300.

The adhesion test showed a high bond strength with a good adhesion to the lacquered Aluminum surface.

After the climate alternation test there is no joint opening visible and the adhesion is the same than before.
The sample passed the climate alternation test.