



# FOAMGLAS®

# PC® 88 ADHESIVE

## Description and Area of Application

PC® 88 adhesive is a two-part adhesive for bonding FOAMGLAS® insulation pieces or blocks together or for bonding FOAMGLAS® insulation to other porous or nonporous substrates. Air curing is not required. It has excellent wetting characteristics and cures to form a flexible bond that absorbs mechanical and thermal shock.



Insulation pieces should be checked for fit to the substrate surface before the adhesive is mixed or work started. Insulation pieces must be reshaped or cut smaller if they do not fit.

## Environmental Considerations

Temperature of the adhesive, substrate and the ambient temperature will affect working time and cure. Higher temperatures reduce working time, viscosity and cure. Lower temperatures increase viscosity and lengthen the working time and cure.

## Mixing Guidelines

For best results, always have the substrate ready for use prior to mixing.

Make sure an equal number of containers of Component 1 (19 L [5 gal] pail) and Component 2 (0.4-liter [12-ounce] polyethylene bottle) have been received and are on the job site.

Proper mixing of the PC® 88 Adhesive is essential for a successful application. Mix Component 1 two to three minutes before adding Component 2. A 19-mm (¾-inch) heavy-duty drill and a good mixing paddle are required. The recommended mixer paddle for a 19-liter (5-gallon) pail is available from Owens Corning. DO NOT use ribbon-type mixing paddles or any type of mixing paddle that may entrain air into the adhesive mixture.

Add Component 2 to Component 1 and mix for approximately 5 minutes. Move mixer around inside the pail. Incomplete mixing can lead to incomplete cure and residual odors.

## Cellular Glass Application Guidelines

Apply adhesive to the surface of the FOAMGLAS® insulation with a notched trowel having a square notch of 6.4 mm (¼ inch) deep, 3.2 mm (⅛ inch) wide with a 6.4 mm (¼ inch) flat surface between notches, available from Owens Corning. Adhesive application shall cover the entire face of the FOAMGLAS® insulation block or segment, which will be applied to the substrate.

Adhesive must be spread and blocks applied within the working time and before adhesive sets. Adhesive that has set cannot be recovered. On curved or overhead surfaces, temporary support and/or the HOLD CATALYST system may be needed.

On low-temperature equipment, all joints must be completely sealed with adhesive and all voids must be as completely filled as possible. Joints should be sealed and any exuded adhesive wiped off before adhesive sets. Adhesive on the face of the block may cause coating adhesion problems. If insulation is to be coated, blocks should be rubbed down to provide a uniform surface.

Trowels should be cleaned frequently and examined for wear. Clogged or worn trowels can cause either too little or too much adhesive being used. Additional coats of adhesive must be applied within 8 hours to assure bonding to the previous coat. If adhesive has cured more than 8 hours, rub briskly with a commercial gloss remover or abrade before recoating.

## Cleanup and Disposal

Always dispose of excess adhesive and containers in accordance with local, state and federal regulations.

## Type of Delivery and Storage

- 15-liter (4-gallon) kit:
  - Component 1: 15 L (4 gal) in a 19 L (5 gal) pail
  - Component 2: 296 ml (10 fl oz) in a 355 ml (12 fl oz) polyethylene bottle
- 7.6-liter (2-gallon) kit:
  - Component 1: 7.6 L (2 gal) in a 11.4 L (3 gal) pail
  - Component 2: 148 ml (5 fl oz) in a 355 ml (12 fl oz) polyethylene bottle
- Components 1 and 2 are sold and shipped separately.
- Store adhesive out of direct sunlight and at temperatures as close to 25°C (77°F) as possible and for at least 2 hours before use.
- Consult Safety Data Sheet for proper storage and handling.

## Field Application

Always read and understand the information contained within product datasheets and safety datasheets before attempting to use this product. If you have questions regarding fitness of use of this product for an application, consult Owens Corning.

## Substrate Preparation

Surfaces must be free of moisture, loose scale and rust, dust, oil and grease. Asphaltic primers, coal tars, silicones, alkyd or other solvent-sensitive or thermoplastic primers or coatings should not be used. Some acceptable primers are zinc-rich, polyester and epoxy. If in doubt, always check the surface for adhesion before starting work with a test piece. Apply a small insulation piece and let cure for a minimum of 24 hours. Insulation pieces should break before the adhesive peels from the surface.

## Typical Properties

PROPERTY <sup>1</sup>	TEST METHOD	SI	ENGLISH
Color		Black	
Density		1.08 ± 0.07 kg/L	9.0 ± 0.6 lb/gal
Solids, Volume		94 ± 2%	
Flash Point <sup>2</sup>	TCC	> 39°C	> 102°F
Combustibility (Cured)		Combustible	
Application Temperature <sup>3</sup>			
Material		28 ± 7°C	82 ± 12°F
Surface, Minimum		5°C	41°F
Surface, Maximum		60°C	140°F
Service Temperature <sup>4</sup>			
Maximum		82°C	180°F
Minimum	FOAMGLAS® to FOAMGLAS®	-150°C	-238°F
Minimum	FOAMGLAS® to metal	-180°C	-292°F
Softening Point		100 ± 20°C	212 ± 36°F
Working Time		90 minutes @ 25°C	90 minutes @ 77°F
Water Vapor Permeability <sup>5</sup>	ASTM E96 (Water Method) ASTM E96 (Desiccant Method) EN12086:1997	0.01 ng/Pa·s·m 0.00 ng/Pa·s·m 0.00 ng/Pa·s·m	0.01 perm-in 0.00 perm-in 0.00 perm-in

<sup>1</sup> Properties are subject to change. Consult Owens Corning.

<sup>2</sup> Component 1 unreacted.

<sup>3</sup> Recommended material and surface application temperatures for ideal workability, product performance, and personnel safety. Please consult Owens Corning for applications outside these temperature ranges.

<sup>4</sup> Service temperature limits are derived from laboratory evaluation of the product under conditions that simulate real world applications. Variations in substrates, loading conditions, or other external factors not explicitly covered by our guide specifications may further limit service temperature. Always follow appropriate the Owens Corning guide specifications, product datasheets and application instructions for suitability for use recommendations for specific applications.

<sup>5</sup> Material tested as a cured disk. When tested in a joint, permeability is too small to measure.

## Coverage

### Standard application of adhesive to FOAMGLAS® insulation:

- One 15-liter (4-gallon) kit will cover 7.5 m<sup>2</sup> (80 ft<sup>2</sup>).
- Standard application requires 2 L/m<sup>2</sup> (5 gal/100 ft<sup>2</sup>).
- Figures do not include losses.

## Limitations

- Do not use as exterior coating exposed to sunlight or to be recoated.
- Keep closed when not in use.
- Do not use where odor could affect food.

For additional information on FOAMGLAS® Insulation Systems, please contact Owens Corning or visit us at [www.foamglas.com](http://www.foamglas.com).

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