



# Enabling improved manufacturing efficiency.

A commercial vehicle producer in Turkey, designing and producing a range of bus, truck and military vehicles, experienced a production problem with a competitive sealant in the paint shop. Their manufacturing site is located in a part of Turkey where the temperatures in the paint shop can be between 35 and 40 °C with 80 % relative humidity. L&L was asked to help solve their manufacturing problem.

## CHALLENGE

The incumbent sealing material can be easily extruded and applied. However, under the high temperatures in the production area, this product showed unacceptable sagging performance especially in vertical applications. The sealant could either not be applied properly, resulting in re-work, or not at all, slowing down the manufacturing process. In addition, for large application thicknesses, bubbling of the product was observed, which has aesthetic limitations.

## SOLUTION

L&L sealant A-J215 is a product with similar chemistry and mechanical characteristics as the incumbent product, with significantly improved resistance to sagging. In addition, the low viscosity of the product allows it to be brushed into place where needed. No bubbling could be observed.

## RESULTS

A-J215 was tested on a test vehicle and approved. Currently 30 sausages of this product are being used per vehicle without issue. As the customer was satisfied with A-J215's performance, they have extending it's use to the production of buses at the same site, where it is used for general sealing of the body.



· Example picture only

## Client

Leading Turkish Truck and Bus builder

## Industry

Commercial Vehicles

## L&L Technology

L&L Bond A-J215 is a general purpose, SMP chemistry based, sealer, and is available in black, grey and white

## Key Technical Data

Product	A-J125
Open time (min)	25
Cure rate (mm/24 hours)	3–5
Tensile strength (MPa)	2
Elongation (%)	250
Shore A hardness	50
UV resistant	Yes
Overpaintable	Yes

## POSSIBLE ADDITIONAL APPLICATIONS

- Bus interior trims
- Bus floor and roof sealing
- Air conditioning assemblies
- Internal panel sealing and assembly
- Side sealing of sandwich panels
- Exterior trim sealing
- Sealing exterior glazing

## RELATED MATERIALS

L&L Products solutions for sealing large applications also include L&L Seal A-J225, which is particularly suitable for sealing Polycarbonate sheets. Polycarbonate is a material with relatively weak chemical resistance, and bonding/sealing materials need to be selected carefully. For applications requiring stronger bonds, L&L Seal A-J235 might be a good solution. In addition to a strong final bond strength, this material processes well, with very limited stringing after applying the beads. Both of these products can be applied without pre-treatment and do not contain diisocyanates.

## TEST RESULTS

A high variety of substrates have been tested, see contacts.



## CONTACTS

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