

# Product Information

## Strass 244

### Strass adhesive 244

Valid for article no.: 1SK244

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Sussmann & Steinhauser GmbH  
Glasschleiferstrasse 14  
D-87600 Kaufbeuren  
Telefon: +49 8341 / 62087  
Telefax: +49 8341 / 65475  
<http://www.hasulith.com>  
[info@hasulith.de](mailto:info@hasulith.de)

#### SPECIFICATION

**Strass 244** is a special colourless, solvent-borne one-component adhesive to glue glass-, strass- or simili-rhinestones (e.g. Swarovski-stones) with a diameter up to 5 mm (equivalent to Swarovski SS 22) to a variety of materials. **Strass 244** don't form threads on application and can be applied dropwise.

Dry **Strass 244** is hard and crystal-clear, so gluing borders or some excess of adhesive spilled on the stone will be nearly invisible. The dried **Strass 244** will not turn yellow or brown on aging or exposure to light.

For gluing of bigger stones (more than 5 mm in diameter) we recommend to use our **HASULITH® Cement Vielzweckkleber (Multi-purpose-Adhesive Art.-Nr. 1VZK)**. For very big resp. heavy stones or if the stones do not fit well to the recesses, settings or the substratum (please see the illustrations on the next page) we recommend to use our 2-Component-Adhesive **HASULITH® Duo (Art. Nr. 1HDCV20L)**.

#### RECOMMENDED FOR THE GLUING OF

Strass-, glass-, or simili-rhinestones especially to metals - but also to materials like glass, ceramics, china and hard plastics like Polyacrylates. For gluing semi-precious-stones (e.g. lapis-lazuli, turquois...) **Strass 244** is only recommended if the stones are not lubricated or greased for better gloss (but usually they are – please ask your stone supplier).

Not recommended for gluings on materials like Polystyrene, PVC, Styropor®, PE, PP, rubber, Nylon or other kind of soft plastics or flexible materials like fabrics, leather etc.

Plastic stones can not be glued with **Strass 244** because the solvents in the adhesive will attack the plastic stones. For gluing plastic stones we recommend our solvent-free **HASULITH® Dispersion Glue P (Art. Nr. 1PMK)**. This glue is also recommended to glue glass- or simili-rhinestones to a variety of plastics.

#### APPLICATION

**Attention ! On using the tubes the plastic cap have to be unscrewed first. Then the metal membrane of the tube have to be pierced with a pointed utensil (e.g. a nail or a pointed knife).**

The gluing areas have to be dry and clean -(free from dust, grease, oil, lubricants and other adherents). For optimum gluing results it is important, that the stones fit well to the settings resp. the substratum ( please see the illustrations on page 2).

For application **Strass 244** is put to the settings.

Because the drying of **Strass 244** take place with some minutes retardation it is possible to put the adhesive to about 25 settings first and subsequently set the stones to the settings – in other words: it is not necessary to set a stone *immediately* after putting on the adhesive. When all stones of an object are set, the stones have to be pressed down slightly to the settings (e.g. with a toothpick) and – if necessary – adjusted to the desired position.

Because **Strass 244** becomes crystal clear and hard on drying it's usually not necessary to remove excess adhesive spilled on the stone or object. The application of **Strass 244** can take place e.g. directly from the tube or with a PE-plastic bottle with a nozzle, by a syringe with needle or with a toothpick.

#### DRYING

The retarded drying of **Strass 244** makes it possible to adjust the stones to the correct position after gluing. This is possible up to 30 minutes after setting the stones. After this time the stones should not be moved anymore.

Drying time depends mainly on the size of the stones (the bigger the longer) and the ambient temperature. After about one hour the initial fastness of the gluing is already strong enough to handle the objects with some care (e.g. move them to another place). The gluing borders or excess of adhesive will not be wet or tacky anymore.

Maximum bond strength is achieved after about 48 hours - but within 24 hours usually the adhesive is already dry enough to pack and mail the glued objects. In this case you should take care to pack the glued objects in a way that there is not too much mechanical stress on the glued stones.

Although the most common way is to let the gluing get dry on ambient temperature it's also possible to accelerate the drying of **Strass 244** by slight heat ( recommended: max. 50°C ). Because of the highly flammable solvents the oven have to be explosion-protected. Accelerated drying at higher temperatures can be done at the earliest after a pre-drying of at least 4-5 hours at ambient temperature. If you put the glued objects to an oven too early, there are still too many volatile solvents in the gluing area and if they evaporate too quick, bubbles will appear in the gluing area and in the worst case the stones might be lifted out of the settings.

#### SEPARATION OF GLUED PARTS/CLEANING

From metal, glass or ceramic objects stones can be removed by dipping the whole object in our **Thinner 1002 (Art.-Nr. 3V1002)** for a while. Usually the mirror on the backside of the stones will be not attacked by this procedure but as a precaution the object should not be dipped longer than necessary. Please notice, that lacquers, paint or plastics (or other solvent-sensitive parts) on the objects might be removed resp. attacked by the thinner as well.

#### SAFETY



highly flammable



irritant

R 11-36-66-67

S 2-7/9-16-20/21-23-24/25-26

Highly inflammable. Irritating to eyes. Keep out of reach of children. Keep away from sources of heat or ignition. Don't smoke, eat or drink on working. Use only in thoroughly ventilated areas. Don't breathe the vapours and wear goggles for eye protection. After swallowing: see a physician immediately.

WARNING: Intentional misuse by deliberately inhaling the vapours from this product can be harmful or fatal.

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### STORAGE / HANDLING / WASTE

**Strass 244** should be stored well closed in a cool, dark and dry place – not together with foodstuff or drugs. In tubes **Strass 244** can be stored for a few years. In PE-plastic containers the adhesive will get a little bit thicker after several month because some loss of solvents by diffusion through the PE will occur (especially if stored too warm in small containers). Also frequent opening of the container will lead to some loss of solvents. In this case some **Thinner 1002 (Art.-Nr. 3V1002)** can be added until the adhesive get back the original viscosity.

Completely dry adhesive residues in small amounts can be wasted with the household rubbish. Bigger quantities or not completely dry adhesive have to be wasted as hazardous waste according to the local regulations.

### AVAILABLE CONTAINERS

1SK244-T	tube	20 ml
-K	box with 100 tubes	100 x 20 ml
-8	PE-bottle with nozzle	80 ml
-2	PE-refill-bottle with nozzle	2.000 ml
-10	PE-canister	10 ltr
-025W	PE-wide neck bottle	250 ml
-050W	PE-wide neck bottle	500 ml
-1W	PE-wide neck bottle	1.000 ml

Other units or bulk quantities on request. For resellers **Strass 244** is also available in containers without label or we can label and pack it according to customers demand. On a minimum order of 10 000 tubes **Strass 244** can be supplied individually printed according to customers demands.

### APPENDIX – SOME IMPORTANT HINTS FOR THE GLUING OF STONES WITH STRASS 244

For getting the optimum fastness and best bond strength, the stones should fit to the settings as good as possible – like shown in illustration a). If there are too strong deviations like shown in illustration b), c) and d) no satisfactory results can be expected.

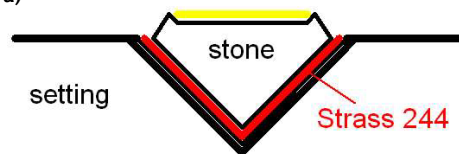
In case of illustration c) resp. d) good results can be obtained if a two-component adhesive (e.g. our **HASULITH Duo**) is used for the gluing. Only a two-component adhesive is able to fill the big gap between stone and setting completely.

In case of illustration b) using a two-component adhesive will lead to better but maybe not totally satisfactory results because the point of weakness on the side part of the stone will remain.

Problems also may occur if flat back stones are glued on strong curved areas. In this case also the gluing area is very small and the gap between stone bottom and substratum too big. In this case a high viscous or thixotropic two-component adhesive (e.g. **UHU plus endfest 300** or our **HASULITH Duo** modified with **Thixotropic Additive 1384**) should be used to obtain the maximum fastness.

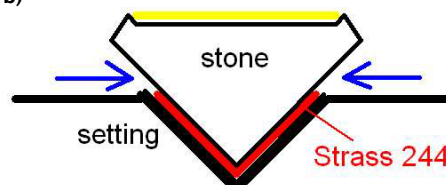
Regarding the quality of simili-rhinestones it is important that the metal mirror and the protective bronze-coating on the bottom of the stone have good adhesion to each other resp. the stone. If this adhesion is bad even the strongest adhesive can not prevent the stone from coming out. Bad adhesion between glass and mirror becomes obvious when the rhinestone comes out and the mirror will stick together with the adhesive to the setting. Wrongly this is interpreted sometimes as a lack of bonding strength of the adhesive. (Actually in this case the bonding strength of the adhesive is very good – just the adhesion between the glass and the mirror is too weak ).

Illustration a)



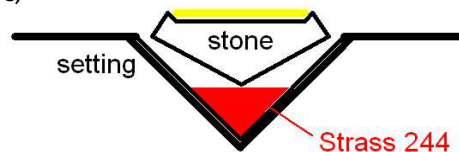
Ideal case of a gluing. The stone fits well to the setting. Maximum gluing area – optimum adhesion and bond strength.

Illustration b)



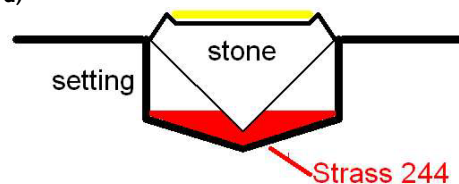
The stone is too big and stands out of the setting so the gluing have some point of weakness -especially against mechanical stress to the side parts. The gluing area is comparatively small. Some bending or peeling stress to the stone and it will come out.

Illustration c)



The angle of the stone is very different to the angle of the setting. Most of the adhesive collect at the bottom of the setting. Almost no or very small gluing area. Some push or bump to the object and the stone will jump out.

Illustration d)



Cylindrical setting. The adhesive collect at the bottom of the setting. Gap filling not possible. Almost no or very small gluing area.