



ALL ABOUT WORKING TIME OR OPEN TIME

Two of the most important properties of structural adhesives without exception are the “working time” or “open time”.

The working or open time seems to be the easiest value to grasp. This is the amount of time you have to apply the structural adhesive to the first substrate material and successfully join the second substrate material. Effectively, the amount of time you have to work with the adhesive or that the bond is “open.” Pretty simple.

For moisture-curing products like TWEHA’s SMP adhesives, TWEHA Blacken and TWEHA WoodProtect, this time starts as soon as the structural adhesive or liquid is exposed to the air.

For two-component products like TWEHA PreFix X-tra, this time begins when the adhesive and activator are mixed.

In both the case of the one and two-component materials, this time is affected by temperature. Just like with curing time, colder temperatures result in longer open times while warmer temperatures result in shorter open times. This is simply due to the nature of chemical reactions – which are faster when heated. In the case of humidity-curing materials, the amount of water-vapor in the air is also a factor. Slower in dry conditions, faster in humid weather.

Do you have questions about open/working time, handling time, fixture time, or bonding in general? Contact Technical Support for more information.

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