PU dispersion

150.90/91/95

Application:

Laminating adhesive for the manufacture of three-dimensional coated furniture parts with thermoplastic foils (e.g. PVC)
The properties of the bonded parts and where necessary, surfaces of the materials have to undergo application related tested prior to use.

Directions for use:

PU dispersion with built-in crosslinking mechanism. The adhesive can be processed in one-component form, i.e. without the addition of a further crosslinking agent.
Laminating is to be carried out within the first 8 hours after adhesive application.
The processing characteristics may vary depending on the application technology, which can affect the bonding process.

Customer trials are required.

Applied by spraying (cup or pressure pot). Pot and gun components must be stainless steel or plastic. Diameter of the spray nozzle should be 1.0-1.5 mm (0.040-0.060 inches). The edges should be sprayed a second time after the first coat has dried. Glue film must be completely dry before pressing. Complete curing at room temperature takes about 7 days.

We recommend that all materials coming into contact with the glue are made from high-quality stainless steel or of inert plastics, e.g. Teflon, PP, Polyamide, Avoid contact with other metals like, zinc, brass, copper, or aluminum. For more information contact the equipment manufacturer or our technical service.

Before the use in spraying equipment, it is recommended to strain the adhesive with a wide meshed filter (400 - 1000 micron) to remove dried adhesive skin that might have formed.

Typical Key Data:

Min. temp. (materials, glue and room air):	15 °C (58 °F)
Appearance:	Final digit 0 = opaque with UV indicator
	Final digit 1 = white
	Final digit 5 = blue
Glue application	One sided
Application amount:	2-5 mil wet = 5-12 g/ft (depending on board quality)
Min activation temp. in the bond line:	55 °C (131 °F)

Our application Technology Department and our Application Specialists will provide technical data to assist you in your choice of an appropriate adhesive for your requirements. Please observe the information in the section “Remarks”.

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Requirements for High-Quality Bonding Process:

The properties (e.g. surface tension, plasticiser content…..) and the conditioning of the substrates, as well as the processing conditions (e.g. ambient temperatures, humidity…) will influence the processes of joining and bonding. Customer tests under consideration of everyday production conditions are therefore absolutely necessary to define stable process parameters and to ensure that the product is fit for purpose. For best bonding results, the materials to be bonded should be free of dust, oil and grease, and be dry. Ideally, the minimum temperature should be at 18 ºC (64 ºF). Avoid draught.

Specification:

Viscosity at 20 ºC (68 ºF) [mPa·s]: (Brookfield, Spindle 3, 20 RPM)	3,000 ± 500
Density at 20°C [g/cm³]:*	1.05 ± 0.01 (8.85 ± 0.08 lb/gal)
Solids content [%]:*	40 ± 5
pH Value at 20 °C (68 °F):*	8.0 ± 1.0

***** According to Jowat test method.

Cleaning:

Fresh glue may be removed with cold water. Dried glue must be removed mechanically.

Storage:

May be stored in properly closed original containers, cool and dry (15-25°C (59-77°F)). During transport, the temperatures may be lower, between 6 to 14°C (43 – 58°F). The material may be exposed to these temperatures a maximum duration of 14 days. If in doubt, the temperature need to be checked in goods entry. Cold material may not be processed, but must be previously warmed up slowly at 15-25 °C (59-77°F) (exposure over 2-3 days depending on volume of the packaging unit).
For best before date, please refer to label on the packaging unit. After the elapse of the best-before-date, it is essential that you again verify that the product is fit for your intended application.

Packaging:

Information about packaging types and units is available upon request.

Remarks:

For further information concerning handling, transport and disposal, please refer to the Safety Data Sheet.
The information on this data sheet is based on test results from our laboratories as well as on reported experience gained in the field by our customers. It can, however, not cover all parameters for each specific application and is therefore not binding upon Jowat, nor should it be relied upon in lieu of your own required testing. The information given in this leaflet represents neither a performance guarantee nor a guarantee of properties, nature, condition, state or quality. No liability may be derived from the information contained herein nor from the information provided by our free technical advisory service.

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JOWAT Corporation Information

Gluing, as one of the most efficient methods of bonding, is constantly expanding into new areas of application. At the same time, the number of substrates to be bonded is also growing at an unprecedented rate. New methods and equipment to process adhesives are constantly being improved and developed.

The in-house R&D department of JOWAT Corporation ("JOWAT") is responding with intensive efforts to keep pace with these constant changes. A highly trained and qualified team of chemists and engineers are using the latest techniques and the brightest ideas to provide adhesives that meet the needs of our customers for new and innovative applications.

We have assimilated information based on test results from our laboratories as well as on experience gained in the field by working with our customers. This information is available by contacting our technical service department. Customers who have obtained information and thereafter undertake modifications during a running production are invited to provide this information to us to assist us in maintaining our field information and obtain any updated information we may have. However, any technical information we provide is provided without any representation or warranty and for informational and assistance purposes only, and must not be relied upon or used to replace field testing by the user of the adhesive in the actual application for which the adhesive is to be used. Our laboratory testing and field information obtained cannot simulate all eventualities that may occur in each specific application, and for that reason we cannot and do not insure performance or results in specific applications.

Any user of adhesives manufactured by JOWAT must test the adhesive(s) for suitability in each individual application, performing such tests in connection with the first use of a sample as well as all subsequent modifications during any ongoing production.

In addition to such other tests the users of our adhesives deem appropriate to insure suitable bonding, all users of adhesives manufactured by JOWAT should test the adhesives for suitability on original parts equal to normal processing conditions. The adhesive bond should then also be tested and assessed by subjecting it to the actual stress and conditions it will undergo in all of its intended and reasonably foreseeable uses. ALL OF THESE TESTS ARE ABSOLUTELY NECESSARY AND MUST BE PERFORMED.

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