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#### Application

One-component dispersion adhesive for the lamination of leather with polyurethane and PVC-foils, as well as PVC-foam foils and ABS-foils on molded parts from ABS, PVC, particle board, derived timber products, etc. by deep drawing.

Especially suitable for the adhesion of glossy foils in heat-activated procedure (3-D-process).

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#### Properties

low activation temperature

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#### Technical Data

Base:	polyurethane-dispersion
Colour:	white
Viscosity (Brookfield):	approx. 2.500 mPas*
Density:	approx. 1,06 g/cm <sup>3</sup>
Thinner/Cleaner:	water
Application	spray gun
Drying time:	approx. 60 minutes at normal temperature; depending on material and amount
Activation temperature (joint)	min. + 60 °C to 65 °C depending on material
Heat resistance	approx. + 120 °C (internal method)
Setting time	approx. 72 hours
Storage life	approx. 6 months
Conditions for storage and transport	well closed at temperatures between + 10 °C and + 25 °C
Sensitive to cold	yes; after influence of temperatures below + 10 °C, the adhesive can not longer be worked up
Labelling acc. to regulations for dangerous goods	none

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\* The viscosity indicated above is based on a temperature of + 20 °C prevailing at the time of production. Minor deviations may occur during storage.



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### Instruction for use

Stir adhesive before working.  
Applicate the mixture with spray gun on the carrier material.  
After drying time approx. 60 minutes (can be accelerated by warmness), the adhesion can be done with activation by deep drawing.

Sealing time depends on thermal conductivity of the material.  
Determine the sealing- and press time by preliminary tests.

To avoid faulty bonding, the temperature of room and adhesive should not be below 18°C.

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### Hygiene and safety

see the EC-safety datasheet

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