

ADBOND 5635-6K SERIES

Liquid polyurethane mono-component adhesive

DESCRIPTION

ADBOND 5635-6K SERIES is a liquid polyurethane mono-component adhesive that vulcanise with moisture. ADBOND 5635-6K SERIES is used to bond rigid insulation polyurethane foam, expanded or extruded polystyrene, wood, cardboard honeycomb, particle panel, MDF, or certain plastics. Used for bonding between two flexible materials or a flexible and a rigid material. Never used for bonding two rigid materials. For assemblies including metals use ADBOND 5645 SERIES

PHYSICAL PROPERTIES

77°F (25°C) – 50% H.R.	
Color	Amber or red
Viscosity	4900 – 6000 cPs
Specific gravity	1.1 (kg/L) ±0.005
Solids content	> 99%
Cold resistance (uncured)	Protect from freezing (Possible reversibility)
V.O.C.	Refer to chart below
Open time	Refer to chart below

OPEN TIME, V.O.C. AND SHELF-LIFE CHART

	5635B-6K	5635C-6K	5635G-6K	5635GF-6K	5635H-6K
Open time at 25°C (77°F) – 50% H.R.)	15 – 30 min.	30 – 45 min.	45 – 75 min.	120 – 200 min.	9 – 15 hours.
Full cure	24 hours	24 hours	24 hours	24 hours	48 hours
V.O.C.	4.1 g/L	2.42 g/L	0.82 g/L	0.04 g/L	0 g/L
Shelf life	6 months	6 months	9 months	9 months	9 months

METHOD OF USE

ADBOND 5635-6K SERIES can be applied using compressible bottle, roller, manifold, or mechanical roller. For optimum results the adhesive should be applied at a temperature of 65°F (18°C) to 77°F (25°C). It is recommended to apply 10 to 15 g / ft² (100 to 150 gr / m²) of adhesive (depending on the porosity or nature of the substrates) and then spray a mist of water (10% of the adhesive weight) over the adhesive before substrates assembly and put ii under pressure. It is strongly advised to install a thermometer / hygrometer near the assembly station. Press time and pressure may vary depending on the nature of the material and temperature conditions. The recommended pressure is 50 to 150 lbs/ft². Consult our technical department for more information.

APPLICATION

- Sandwich panels
- Lamination

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For cleaning the mechanical rollers, first use the ADSOLVE DP60011 to remove as much adhesive as possible by rotating the mechanical rollers in reverse. Then clean thoroughly with the ADSOLVE 6040. For manifold systems cover the nozzles with hydraulic oil to completely block moisture infiltration. For any other equipment clean before curing of the product with the ADSOLVE 6040. Cleaning solvents must be recovered and send to an accredited company for the destruction of hazardous materials. For more information consult our technical department.

PACKAGING

- 18.9 liters pail
- 220 kg drum
- 1100 kg tote tank

STORAGE

The adhesive has a shelf life from 3 to 9 months from production date depending on different grade (refer to chart above), in the original closed container and stored in a cool, dry place (50°F to 77°F / 10°C to 25°C). High humidity and storage below or above these temperatures will shorten shelf life. Protect from frost. Keep container tightly closed to prevent contamination. Open drums must be protected from moisture with nitrogen or desiccant.

CAUTION

Always consult SDS (Safety Data Sheet) before using the adhesive. Apply usual hygienic rules. For industrial use only. For more information, please contact your technical representative.

IMPORTANT**READ CAREFULLY**

The information and recommendations contained herein are derived from our research and information from other reliable sources. This data applies only to our products and not when used with other products. We believe in the reliability of our information. However, no guarantee is offered to that effect. It is the responsibility of the buyer to verify this data according to their own operating conditions to ensure that they conform to the purpose for which the product is intended, even before using it.

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