

BASE	TECHNICAL DATA SHEET	PRODUCT
Polyurethane	Timbond Polyurethane Adhesive	Rapid
SOLIDS	<p>DESCRIPTION</p> <p>Timbond PU Rapid is a moisture curing single part, polyurethane adhesive specifically designed for bonding wood to wood, for the woodworking industry. It can also be used to bond many types of plastic foams and other insulating materials to a wide variety of both rigid and flexible facing materials. Such composites form structural sandwich panels and insulated building boards and may be used in the manufacture of cold stores, caravans, mobile homes and offices, insulated building units etc.</p> <p>Timbond PU Rapid has a short open time, which gives fast cure rates.</p> <p>SURFACE PREPARATION</p> <p>Materials to be bonded should be clean and free from dust, grease and other contaminants.</p> <p>A test panel should always be prepared when new materials are to be used to establish the adhesives compatibility.</p> <p>ADHESIVE APPLICATION</p> <p>The adhesive can be applied by trowel, notched spreader, or a polybottle to one surface only of each glue line.</p> <p>The amount required will vary according to the porosity/smoothness of the substrates and the means of application, but will normally be in the range 80 – 140 grams per square meter.</p> <p>The panel is then assembled as soon as possible and placed under pressure within 5 minutes.</p> <p>The pressure is required will depend to a great extent on the nature of the substrates but is usually in the range 0.5 to 0.9 bar.</p> <p>Pressure should be maintained until the adhesive is sufficiently cured to permit handling of the bonded item. Full cure of the adhesive is not obtained for 24 hours and handling within this period should be kept to a minimum.</p>	
100%		
VISCOSITY		
3500 ± 4500 cps @ 25°C		
COLOUR		
Brown		
TACK LIFE		
N/A		
COVERAGE		
Up to 12.5m ² per kg		
CLEANER		
Solvent 6 or 9		
FLASH POINT		
See MSDS		
SHELF LIFE		
3 months 5 - 25°C		

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CONTINUATION

The open time and cure cycle to permit handling will vary according to:-

- | | | | |
|----|----------------------------|----|-------------------------|
| 1. | Temperature | 3. | Method of working |
| 2. | Weight of adhesive applied | 4. | Substrates being bonded |
- and should always be determined by experiment

Processing Guide

Temperature (°C)	15	20	25
Open time (mins)	10	6	3
Cure time (mins)	30	20	10

CLEAN DOWN

Timbond PU Rapid when uncured can be removed when cleaning Solvent 6 or Solvent 9. Cured product will prove very difficult to remove, however, soaking in Solvent 6 overnight will soften the adhesive.

STORAGE AND HANDLING

Timbond PU Rapid is a moisture sensitive adhesive and left in contact with the open atmosphere will eventually gel. For this reason Timbond PU Rapid is protected with a blanked of Nitrogen in the container prior to despatch, which forms a dry, inert layer on top of the adhesive

Ref: Timbond PU Rapid Date: 11/06/12

The above figures do not constitute a specification. They typical values obtained for this product.

HEALTH AND SAFETY

Before using this product please ensure that you have been supplied with and have read carefully the following information:

1. The hazard labels (complying with CHIP and CDG/CPL Regs).
 2. Timbond PU Adhesive Rapid Material Safety Data Sheet.
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