

Apollo (A9267)



Single-component Polyurethane Lamination Adhesive

Apollo (A9267) is ideal for manufacturing a wide range of panels, including cold stores, caravans, doors and SIPs. It is a single-component moisture-curing polyurethane adhesive (1K MCPU) that offers the manufacturer many benefits.

Benefits:

- **Extremely versatile:** bonds a wide variety of materials, including UPVC
- **Minimises product cost:** single component adhesive with a long open-time and low coat-weight
- **Helps to reduce equipment cost:** can be applied manually with a notched trowel and scrapper or bead applicator
- **Complete peace of mind:** ensures a high-strength durable weatherproof bond

Technical Data

Base	Polyurethane	Cure-Time	42minutes @ 20°C
Appearance	Brown	Open-Time	16 minutes @20°C
Temperature Resistance	-30-150°C	Shelf Life	12months
Coverage	8-10m ² per litre	Storage	5-25°C
Application Temperature	5-25°C	Environmental	Solvent/Hazardous/Flammable
Viscosity CPS	4500 @ 20°C	Cleaner	Solvent 6 or 9

Processing Guide

Temperature	15°C	17°C	19°C	21°C	23°C	25°C
Open-Time (Minutes)	21	19	17	15	12	10
Cure-Time (Minutes)	53	48	45	38	30	25



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Instructions for Use:

1. Ensure all surfaces to be bonded are clean and free from grease and other contaminants. Some grades of, galvanised steel, aluminum and plastics may need priming.
2. Apply an even coat of the adhesive to one surface with a roller coater, trowel, scraper or an automatic bead-applicator.
3. The amount of adhesive required will vary according to the porosity/smoothness of the substrate and the means of application, but will be between 80-140g /m².
4. Mist the adhesive with water once it has been applied (approximately 10% of water based on the adhesive coat-weight).
5. Assemble the panel and place under pressure within the open-time (16 minutes @ 20°C). Pressure is usually applied using a hydraulic press, vacuum table or bag press. The pressure required will depend on the nature of the substrates, but it is usually in the range of 0.5 to 0.9 bar.
6. Maintain pressure until the adhesive is sufficiently cured to permit handling of the bonded item (42 minutes @ 20°C).
7. Full cure of the adhesive will not be achieved for 24 hours. Keep handling to a minimum during this time.

NB: Metals should be stored in a warm environment prior to bonding in order to avoid the glue line chilling, which could lead to extended cure times. A test panel should always be prepared when using new materials in order to establish compatibility.

IMPORTANT NOTES

Storage and handling: The product should be stored unopened in a dry condition at a temperature of 5-25°C. This will ensure the stated shelf-life. The adhesive will have a limited life once the container is opened.

Temperature and timings: All information on temperature and timings represent normal working conditions and is provided as a guideline only. However, please contact Apollo for advice if you wish to operate outside of these parameters.

Disclaimer: Apollo has taken care to ensure that the information provided in the literature is correct and up to date. However, it is not intended to form any part of a contract or provide a guarantee. Purchasers/intending purchasers should contact Apollo to check whether there have been any changes to the information since publication of the literature. Please ensure you have read the hazard labels and material safety data sheet before using this product.



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