

Lamination (A9356)

Solvent-Free Panel Lamination Adhesive 1K MCPU



Apollo Lamination (A9356) was developed specifically for the manufacture of a wide range of panels, including doors, cold stores, caravans and SIPs. It is a single-component (1K) moisture curing polyurethane (MCPU) adhesive, which securely bonds a wide range of materials/substrates.

- Extremely versatile
- Minimises production costs
- Weatherproof bond
- Green credentials

Extremely versatile: allows a wide range of construction materials to be bonded

Apollo Lamination (A9356) allows you to securely bond a wide range of materials including most insulation, plasterboard, metal, PVC, ABS and wood. The versatility of Lamination (A9356) helps to reduce the number of products you need to store at your factory. There is also a thixotropic version available for porous or open cell material, which is well suited for the foam conversion and panel insulation markets e.g. open cell foams and mineral-wool.

Minimises production costs: one-way stick, low coat-weight and maximises work progress

Production costs are a key concern for any manufacturer, especially given the current economic climate. Apollo Lamination (A9356) boasts an extremely economical usage rate via its one-way stick technology and low coat-weight. It develops bond strength quickly, which allows you to work with panels immediately after the press cycle, thus maximising work progress.

High performance: weatherproof bond, and resistant to water and extreme temperatures

At Apollo, we understand you need a high-performance adhesive that can withstand extreme environmental conditions. Apollo Lamination (A9356) forms a high-strength durable weatherproof bond, which is resistant to water, extreme temperatures (-30-150°C) and even chemicals once fully cured. It also has excellent aging properties.

Green credentials: solvent-free

Green issues are becoming increasingly important across all industries, and this trend is set to continue in the future. Apollo Lamination (A9356) is a solvent-free polyurethane adhesive, which helps you to meet a growing number of green issues. It also makes the product more pleasant for employees to use, creating a more comfortable working environment.



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Instructions for use:

Substrate preparation/priming:

1. Ensure all surfaces to be bonded are clean and free from grease and other contaminants. Some grades of aluminium, galvanised steel and plastics may need priming.

Application:

1. Apply an even coat of the adhesive to one surface with a roller coater, trowel, scraper or an automatic bead-applicator.
2. The amount of adhesive required will vary according to the porosity/smoothness of the substrate and the method of application, but will be between 80-140g/m².
3. Mist the adhesive with water once it has been applied (approximately 10% of water based on the adhesive coat-weight).
4. Assemble the panel and place under pressure within the open-time (see cure chart). 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.
5. Maintain pressure until the adhesive is sufficiently cured to permit handling of the bonded item (see Processing Guide).

6. 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. One of the surfaces to be bonded must be porous/permeable.

Packaging:

Apollo Lamination (A9356) is supplied in a 1000 litre IBC with 50mm butterfly valve and wooden pallet. 80mm valve option, if required. Product available in other pack sizes (including 20 litre or 205 litre).



1000 litre IBC

Technical Data

Base	Polyurethane	Cure-Time	45 minutes @ 20°C
Appearance	Neutral / Green	Open-Time	15 minutes @ 20°C
Temperature Resistance	-30-150°C	Shelf Life	9 months
Coverage	8-10m ² /L	Storage	5-25°C
Application Temperature	5-25°C	Health & Safety	See MSDS
Viscosity	3000cps @ 25°C	Cleaner	Solvent 6 or 9

Processing Guide

Temperature	13°C	15°C	17°C	19°C	21°C	23-°C	25°C
Open-Time (Minutes)	27	24	21	18	15	12	9
Cure-Time (Minutes)	81	72	63	54	45	36	27

IMPORTANT NOTES:

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.

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.

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.