

# 9631 DM ONE PART ADHESIVE IN WATER DISPERSION



**9631 DM** is a solventless adhesive suitable for bonding leather, fabrics, woven-non woven, felt, and foam to wood, polyurethane, foamed polystyrene, for spray application.

One-component formulation with a very good hot contactability, developed for high temperature and hydrolysis resistance bonding.

## Properties

<b>Composition :</b>	polyurethane resin in water dispersion
<b>Mode of setting :</b>	by evaporation of water and reaction with vulcanising agent
<b>Colour :</b>	dispersion is white, turning transparent when drying
<b>Solvents :</b>	solventless

## Technical data

<b>Ph :</b>	neutral
<b>Viscosity :</b>	1300-2000 mPa.s (Brookfield spindle 4, spd 50 at 25°C)

Values valid for product supply specification upon leaving the factory.

## Method of use

**Application:** apply the product in an uniform coat on to both surfaces using air spray equipment provided with a nozzle of 1,9-2 mm, pressure 2-3 bar.

**Drying time:** it depends on the temperature and humidity as well as on the porosity of the surfaces. Allow the adhesive film to turn from white to transparent before submitting it to heat reactivation. At a temperature of 20°C and 50% r.h. the film turns to transparent within about 30 min. when porous substrates are involved and in 45-50 min. with non porous materials. Drying time can be noticeably reduced by heat.

**Assembling:** heat reactivate both surfaces up to 60-70°C, then assemble under pressure for 10-15". Maximum bond strength of the adhesive is reached in 48 hours.

## Approvals

**9631 DM** complies the flammability requirements according to **FAR/CS 25853 Appendix F, Part I – 12 sec** method, test report No. 56867 issued on 22.02.2016 by Lantal Textiles AG.

## Storage stability

6 months for the product kept in the original sealed pack at a temperature range from + 10°C to + 25°C. Protect from frost.



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