



ALLTER

ALTERNATE
CORROSION
PREVENTION
SYSTEMS



Allter-Bond™ PU

PRODUCT DATA SHEET

Selection and Specification Data

Generic Type	Two component, solvent based polyurethane adhesive
Product Description	Allter-Bond™ PU is a two component adhesive specially designed for bonding soft PVC foils and foam backed PVC foils and ABS/PVC foils by vacuum deepdrawing technique to various substrates like wood fibre complexes and injection moulded parts of ABS and ABS/PVC (Bayblend®). The product can be used for lamination of flat surfaces as well for edge folding with a one-side application. Other applications are the production of laminated interior automotive parts, like doors, side-and pillar linings, consoles and dashboards.
Features	<ul style="list-style-type: none">• High initial bond strength even at low reactivating temperatures• Can be used for a wide range of applications• Very good automatic spray equipment properties• Additional Crosslinker for good resistance to aging/heat and cold exposure• Bonding with-and without heat activation and vacuum technique• Contrasting color for verifying adhesive uniformity• Long open tack time/up to max. 3 hours
Color	Blue
Theoretical Coverage Rate	150g/m ² /l wet. Note: Absorbent materials may consume a higher load per m ² .

Substrate and Surface Preparation

General	Remove all dust, oil, grease, mold release agents and any other contaminants that can affect adhesion. Substrate must be dry and preferably at minimum 18°C (65°F). Avoid draught. Substrate properties like surface tension, plasticizer content etc. as well the substrate conditioning such as ambient temperature and relative humidity will affect the process of joining and bonding. Keep the substrate temperature to be 3°C (5°) above dew point.
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Mixing

Mixing Allter-Bond™ PU has standard a 100-5 mixing ratio (Adhesive : Crosslinker by weight). Keep both components at minimum 18°C (50°F) before start mixing. Agitate Part A (Adhesive) with a power mixer. Add Part B (Crosslinker) and mix thoroughly with a power mixer until uniform in color. Use low speed mechanical mixing equipment to avoid air entrapment.

Pot Life Up to 8 hours at 20°C (68°F)

Application Equipment

General Hand spray and automated adhesive spray equipment may be used. Material and spray pressure approx. 3bar (approx. 44psi). Site conditions may require modifications in spray pressure and tip sizes.

Adhesive is generally applied on one side (supporting substrate) only.

Application Conditions

General Optimum application temperature of the adhesive and the substrate is 18-25°C (65-77°F).

Flash-off Time Minimum 30 minutes at room temperature or a few minutes at 40-60°C (104-140°F) in a drying oven. Special care must be taken to avoid the substrate to be above 40°C (104°).

Cleanup and Safety Information

Cleanup Use Acetone

Safety This material is for professional use only. Please observe the precautionary information on the safety data sheets (SDS) and label on the containers before using this material. Use of this material must be kept in compliance with local health, safety and environmental conditions and regulations.

Packaging, Handling and Storage

Shelf life Minimum 6 months at 23°C (73°F) in sealed and unopened containers

Storage temperature and humidity 5 - 25°C (41-77°F).
Maximum 85%.

Storage Material should be stored indoors, well ventilated and away from sources of heat and ignition.

Shipping weight Part A (Adhesive): 165.00 kg. /194.12 Liter. (363.76 lbs. /51.28 USG)
Part B (Crosslinker): 22.40 kg. /20.93 Liter. (49.38 lbs. /5.53 USG)

Flash point (ISO 1523) Part A (Adhesive): -18°C
Part B (Crosslinker): -4°C

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