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BONDTECH P911 ADHESIVE

TECHNICAL DATA SHEET

DESCRIPTION & USES:

Bondtech P911 is a two part polyurethane adhesive with high heat resistance and bond strength. It is designed as a low odour adhesive. When used with the relevant wipes or a halogenation primer, excellent results can be obtained on polyurethane, PVC and TPR.

MIXING INSTRUCTIONS:

To 100 parts of Bondtech P911, add 2.5 to 5 parts of Bondtech Clear Activator, then mix thoroughly. (i.e. Add 25-50mls of Bondtech Clear Activator to 1 litre of Bondtech P911). Pot life of the mixture is 8 hours.

METHOD OF APPLICATION:

- To obtain the best results, the materials to be bonded should be dry, clean and free from dust, grit, oil or grease.
- Bondtech P911 is to be mixed with the Bondtech Clear Activator. Once combined, the mixture has a pot life of 8 hours after which the residual must be discarded.
- PVC and polyurethane surfaces should be solvent wiped using Bondtech PW Solvent to remove any surface contamination. Rubber surfaces such as TPR, gristle or micro-cellular should be treated with Bondtech PH Primer.
- This adhesive is designed to be brush applied. Drying time is dependent on ambient conditions. High humidity can cause humidity blushing (moisture to form on the surface); this will prevent proper bonding. Humidity blushing can be reduced by correct atomisation settings and by increasing the ambient temperature with heat.
- Heat activation is recommended only. Since heat will tend to soften the PVC, a temperature of 50°C to 60°C is suggested. The maximum heat applied to the heat stable substrates should be a temperature of 75°C to 80°C. A press time of 15 to 20 seconds is sufficient to give excellent results. The combined product should be allowed to cure for at least 24 hours.
- At that time 96% of maximum adhesion will have taken place.

PROPERTIES:

- Appearance: Clear colourless to slightly yellow liquid.
- Specific gravity: Approx. 0.91
- Coverage: Approx. 4m² per litre.

Note: Additional information on physical properties, health hazards, storage, handling and transport is available in the Material Safety Data Sheet (MSDS).