

**PRODUCT
INFORMATION**

DAUBOND® 6446A

WATER-BASED VINYL LAMINATING ADHESIVE

Daubond® 6446 is a very high solids waterborne adhesive based on a modified vinyl acetate-ethylene copolymer. Daubond® 6446 is designed to laminate vinyl film to various core materials, including: luaun, particleboard, and gypsum. Improved heat resistance can be achieved by crosslinking with Daubond® 6429B, 6468B, or 6500B.

TYPICAL PROPERTIES

	<u>6446A</u>	<u>6429B</u>	<u>6468B</u>	<u>6500B</u>
Polymer	VAE		← Polyisocyanate →	
Solids	72-74%	100%	100%	100%
pH	4-6	N/A	N/A	N/A
Wt/Gallon	9.2 ± 0.2	10.0	9.7	9.5
Viscosity, Brookfield (4 @ 10)	1500-3000 cps	3000 cps	3000cps	7500 cps
Color	White (dries clear)	Clear	Clear	Clear
Mix Ratio (by wt)	100	5	5	5
Storage Life	12 months	6 months	6 months	6 months
Features	-	Standard, Workhorse	Easiest to Emulsify	Lowest Cost

APPLICATION

1. The ideal plant temperature is ca. 65-90°F.
2. Apply 2-4 wet mils to one or both substrates.
3. To increase the wet tack/set speed, allow the adhesive to partially dry before nipping (e.g., direct warm air over the surface). On cold days, or on cold board (<65°F), heat may be required to develop adequate tack. However, don't 'over dry': the adhesive should not be dry-to-the-touch prior to laminating.
4. Under ideal conditions, the bond at the end of the laminator will be stronger than the wood substrate.



Clean-Up

Equipment may be cleaned with warm water. Clean equipment promptly at end of run.

Storage

For maximum storage life, avoid temperatures above 100° F. and below 32° F.

Consult MSDS before using.

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REFER TO MATERIAL SAFETY DATA SHEET FOR HEALTH AND SAFETY INFORMATION.

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