

**PRODUCT
INFORMATION**

DAUBOND® SPECIALTY APPLICATION ADHESIVE

DAUBOND® 6477M3

MEMBRANE PRESS ADHESIVE

Daubond® 6477M3 is a water-borne polyurethane adhesive designed for membrane pressing veneer and PVC films to various core substrates, including: MDF, particle board, etc. Part "A" may be used by itself or mixed with Part "B" if a more heat-resistant bond is required.

TYPICAL PROPERTIES	PART A	PART B
Base	Modified Polyurethane Latex	Isocyanate
Non-Volatile	40.3 ± 1%	99 ± 1%
Density (lbs/Gal)	8.7 – 8.9	9.5 ± 1
pH	7 – 9	Not Applicable
Mix Ratio by Volume	1 Gal.	5 – 5.5 oz.
Mix Ratio by Weight	100	4.5 – 5.0
Viscosity (3 @ 12)	1,100 – 1,500 cps	900 – 1,900 cps
Pot Life	5 – 8 Hours	
Coverage	400 – 800 sq.ft./Gal.	

RECOMMENDED APPLICATION TIPS

Method:	Spray/Roller/Brush
Wet Film Thickness:	2 - 4 mils
Heat Activation Temperature:	130 – 176° F. (55 – 80° C)
Heat Activation Temperature w/Primed Film	130 – 176° F. (55 – 80° C)
Dwell Time:	30 - 240 Sec.



Application

A typical spray system for Daubond® 6477M3 would be a DeVilbiss OMX JGHV S31, Kremlin M21 or similar HVLP system and pressure pot with a .8-1.8 mm orifice. A pot pressure of 5-10 psi and a line pressure of 50 psi is recommended as a starting point.

Bonding After Drying

Apply the adhesive to the substrate. Allow a dry time of 20 minutes prior to press activation. Press time should be 30 seconds to 4 minutes, with adhesive temperature of 130 – 176° F (55 – 80° C). Molding pressure depends on press system. Final bond strength is obtained after 1-3 days.

Clean Up

Partially dried adhesive may be removed with warm water or ethanol. Removal of dried/cured adhesive requires toluene, ethyl acetate, etc.

Pot Life

Five hours at 77°F (25°C). The heat resistance will remain at its peak level when the adhesive is used within 2 hours. The same 2 hour window applies to the adhesive coated board.

Storage Conditions

For optimum storage life, store above 40° F. and below 86° F. CAUTION! DO NOT FREEZE. USE WITH ADEQUATE VENTILATION. CONSULT MSDS BEFORE USING!

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