

**PRODUCT
 INFORMATION**

DAUBOND® 6493
MEMBRANE PRESS ADHESIVE

Daubond® 6493 is a water-borne polyurethane adhesive designed for membrane pressing veneer and PVC films to various core substrates, including MDF, particleboard, etc. Part “A” may be used by itself or mixed with Part “B” if a more heat-resistant bond is required. Daubond® 6493 exhibits a mildly thixotropic rheology for improved holdout and spray characteristics.

TYPICAL PROPERTIES	PART A	PART B
Base	Modified Polyurethane Latex	Isocyanate
Non-Volatile	40 ± 1%	99 ± 1%
Viscosity (3 @ 12)	1,800 – 2,600 cps	1,000 – 2,500 cps
Zahn #5	7 – 9 seconds	N/D
Density	8.8 ± 0.2	10.3 ± 1
pH	7 – 9	Not Applicable
Available Colors	Cream or Blue	Clear
Mix Ratio by Volume	1 Gal	5.0 oz.
Mix Ratio by Weight	100	4.5
Pot Life	5 Hours	
Coverage	400 – 800 sq.ft./Gal.	

RECOMMENDED APPLICATION TIPS

Method:	Spray/Roller/Brush
Wet Film Thickness:	2-4 mils
Heat Activation Temperature:	160-200 °F (71-93 °C)
Heat Activation Temperature w/Primed Film:	150-200 °F (65-82 °C)
Dwell Time:	30-120 Sec.



Spray Equipment:

DeVilbiss OMX HVLP or Kremlin M21VLP spray gun. Suitable equipment is also available from Binks, Graco, etc.

Bonding After Drying:

Apply the adhesive to the substrate. Allow a minimum dry time of 20 minutes prior to press activation. The press time should be 30 seconds to 4 minutes, with a glue line temperature of 150-180 °F (60-82 °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). For optimum heat resistance, use the catalyzed adhesive 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!

**Caution! Do not freeze. Use with adequate ventilation.
Consult MSDS before using.**

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

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4700 South Central Avenue ■ Chicago, IL 60638 ■ 1-800-688-0459 ■ or 708-496-7350 ■ Fax: 708-496-7367

Visit our web site at www.daubert.com ■ Our e-mail is dauchem@daubert.com