

**One-Part Polyurethane Adhesive**

**Product Description – Daubond® 6550**

Daubond® 6550 is a moisture-curing, one-component reactive adhesive. 6550 will react with moisture present in the surrounding air, and in some substrates (wood, etc.), to become a crosslinked, thermoset adhesive. Daubond® 6549 expands as it cures, filling gaps and further penetrating porous substrates. When cured, 6550 exhibits good resistance to heat, cold, and water.

**Typical Applications:**

- Bonding of Wood, Polystyrene Foams, Vinyl, Mineral Boards, Sheet Aluminum, Cement Board

**Application**

Daubond® 6550 can be applied with a spatula, hand roller, plastic squeeze bottle, extrusion or swirl-spray gun or slot die. Use only in equipment intended for reactive PUR adhesives. The suggested coverage is 9-19 grams/square foot (3.5-7.0 mils).

The bond strength is normally sufficient to allow assembled parts to be lightly handled after the recommended press times. The bond strength will increase over time, and subsequent processing of the bonded parts is possible after 1-3 hours. Final strength is achieved after 2-3 days, depending on the temperature and moisture available. Laminating 'dry' substrates under conditions of low ambient humidity (<50%) may require that the coated substrate be misted lightly with water if a reasonable cure speed is to be achieved (fine water mist, approx. 1.8 g/square foot).

**Clean Up**

Equipment should be cleaned with a cleaner designed for PUR (e.g., PUR Cleaner 6500). Cured adhesive requires a strong solvent (e.g., n-methyl pyrrolidone).

**Caution**

Daubond® 6550 contains free isocyanate (diphenylmethane diisocyanate). Use with adequate forced air ventilation. Please refer to the MSDS before using this product.

**Storage Conditions/Shelf Life**

Store in original unopened containers and use within 9 months from date of manufacture. Rotate stock and use oldest material first.

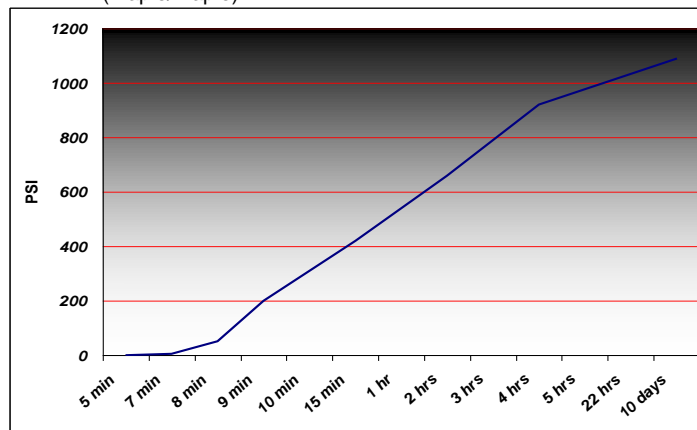
• **Typical Properties (Not Specifications)**

Chemical Type	Polyurethane
Appearance	Yellow-Brown
Wt/Gallon	9.3 ± .1
Open Time (at 68°F)	6-8 min
Viscosity: at 68°F (20°C)	4,800-7,200 cps
Press Time: *	
At 68°F (20°C) -	10-17 minutes
At 86°F (30°C) -	11 minutes
At 104°F (40°C) -	3-6 minutes

\* Ideal Processing Conditions:

1. Working Temperature: 68°F (do not process below 41°F)
2. Moisture Content of Wood: 8-12%
3. Minimum Pressure: 87 psi (.6N/mm<sup>2</sup>)

• **Shear Strength vs. Time:**  
(maple/maple)



• **Adhesion vs. Substrate:**

Substrate	Shear Strength *:	180° Peel **:
Maple	1090 psi	8.4 pli
Cold Rolled Steel	300 psi	5.2 pli
Aluminum	260 psi	4.2 pli
Rigid PVC	160 psi	.6 pli
ABS	890 psi	7.2 pli
Polystyrene	325 psi	.8 pli
Acrylic	840 psi	4.8 pli
Polycarbonate	800 psi	9.2 pli
FRP	590 psi	5.9 pli

\*Maple bonded to the substrate in the first column.

\*\* Cotton Duck bonded to the substrate in the first column.

PSI = Pounds per Square Inch

PLI = Pounds per Linear Inch

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

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