

**DAUBOND® 8050 CARTRIDGE**

Hot Melt Polyurethane Adhesive

**Product Description – Daubond® 8050**

Daubond® 8050 is a one component, reactive hot melt adhesive. 8050 will react with moisture present in the surrounding air, and in some substrates (wood, etc.), to become a crosslinked, thermoset adhesive. When cured, 8050 exhibits good resistance to heat, cold, and water.

8050 is suitable for general-purpose assembly bonding, as well as wrapping vinyl films, resin impregnated paper foils, and wood veneer strips to various profiles (e.g., PVC and aluminum). 8050 is ideal for large surfaces that require a long open time.

**Application**

Daubond® 8050 can be applied with an extrusion or swirl-spray gun; roller coater; or slot die. Use only in equipment intended for reactive hot melts. Do not use in conventional hot melt equipment. For most applications, the recommended application temperature is 120°C (250°F), and the suggested coverage is 5-10 grams/square foot (2-4 mils).

The bond strength is normally sufficient to allow assembled parts to be lightly handled immediately after nipping or pressing. The bond strength will increase over time, and is generally stronger than most wood substrates within several hours. Full cure takes place in 1-2 days, depending on the 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.

**Clean Up**

Equipment should be purged with a non-reactive hot melt cleaner designed for PUR (e.g., Daubond PURGE) or plasticizer (e.g., Uniplex 260). Cured adhesive requires a strong solvent (e.g., n-methyl pyrrolidone).

**Caution**

Daubond® 8050 contains a small amount of free isocyanate (diphenylmethane diisocyanate). Use with adequate forced air ventilation. Please refer to the MSDS before using this product.

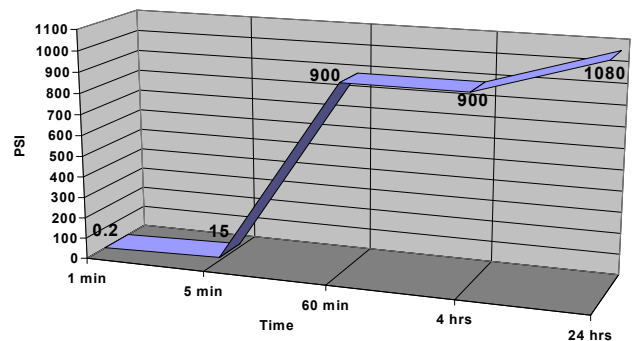
**Storage Conditions/Shelf Life**

Store in original unopened containers and use within 3 months from date of manufacture. Rotate stock and use oldest material first.

• **Typical Properties (Not Specifications)**

Chemical Type	Polyurethane
Appearance	Off White
Wt/Gallon	9.0 ± .1
Open Time (4mm bead)	3.0 min
Viscosity:	
at 120°C (248°F)	6,000 cps
at 140°C (284°F)	3,000 cps

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



• **Adhesion vs. Substrate:**

Substrate	Shear Strength *:	180° Peel **:
Maple	1080 psi	14.0 pli
Cold Rolled Steel	960 psi	9.0 pli
Aluminum	560 psi	5.4 pli
Rigid PVC	740 psi	14.0 pli
ABS	740 psi	19.5 pli
Polystyrene	360 psi	3.8 pli
Acrylic	720 psi	15.0 pli
Polycarbonate	900 psi	22.5 pli
FRP	560 psi	11.0 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

June 21, 2010:kc

**CAUTION:** The data, statements and recommendations set forth in this product information sheet are based on testing, research and other development work which has been carefully conducted by us, and we believe such data, statements and recommendations will serve as reliable guidelines. However, this product is subject to numerous uses under varying conditions over which we have no control, and accordingly, we do NOT warrant that this product is suitable for any particular use. Users are advised to test the product in advance to make certain it is suitable for their particular production conditions and particular use or uses.

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

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CHEMICAL COMPANY, INC.

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