

**PRODUCT  
 INFORMATION**

**DAUBOND® 8808**  
 VINYL LAMINATING ADHESIVE

Daubond® 8808 is a two-part, modified epoxy adhesive, designed to adhere vinyl film to wood, particle board, masonite, metal, concrete and many plastics.

The bond strength produced is normally in excess of the vinyl film itself, resulting in cohesive failure of the vinyl film when tested.

**ADDITIONAL FEATURES OF DAUBOND® 8808 INCLUDE:**

- equal part mix by volume
- color coded pink and yellow for easy identification and mixing
- excellent resistance to plasticizer migration
- cures to handling strength at room temperature overnight
- over three hours work life
- supplied at ready to use viscosity

TYPICAL PROPERTIES	PART A	PART B
Component	Epoxy Resin Base	Curing Agent
Color	Pink	Yellow
Total Solids	60.6 – 62.6 %	86.5 – 88.5%
Mix Ratio (by volume)	1	1
Density	11.69 – 12.09 lbs/Gal	12.64 – 13.04 lbs/Gal
Viscosity (Brookfield LVF, 4 @ 10)	5,000 – 9,000 cps	3,000 – 5,000 cps



## Application Procedure

1. Bonding surface should be free of all dirt, wood chips, grease and waxes.
2. Blend thoroughly equal volumes Part A and Part B. (Mix no more than can be used within 3 hours).
3. Apply 8808 to either bonding surface. A wet film thickness of approximately 2.0  $\pm$  .5 mils is normally sufficient.
4. Laminate surfaces with nip roller or other suitable means.
5. Adhesive will exhibit some "green strength" thereby holding film in place.

It is desirable that the film be held tightly against the wood substrate. This is usually best done by stacking bonded panels flat. If extremely coarse board surfaces are encountered, stacking panels face-to-face will provide smooth surfaces.

The bond (depending on vinyl film used) will exhibit up to vinyl tearing in 16-24 hours @ 75 degrees F. Full cure is normally achieved in 7-10 days @ 77 degrees F, however laminates can usually be machined in 16 hours. Allow more time when temperature is below 70 degrees F. Cure virtually stops below 50 degrees F, however, will start again when brought to 60 degrees F and higher.

## Clean-Up

Equipment cleaning can be done with warm water and detergent or Methylene Chloride. This should be done promptly at end of run.

Cured adhesive can only be removed with great difficulty.

## Caution

Contains epoxy resin, may cause skin irritation. Avoid prolonged or repeated contact. If skin contact occurs, wash thoroughly with soap and water.

Use in well ventilated area.

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