

**PRODUCT
 INFORMATION**

SPECIALTY APPLICATION EPOXY ADHESIVE

DAUBOND® 8818HV

VINYL LAMINATING EPOXY

DAUBOND® 8818HV is a two-part, modified epoxy adhesive designed to laminate vinyl film to particle board.

ADDITIONAL FEATURES OF DAUBOND® 8818HV INCLUDE:

- Equal volume mix ratio.
- Color coded pink and yellow for easy identification and mixing.
- Cures to handling strength at room temperature overnight.
- Bonds most vinyl films.
- Supplied at ready-to-use viscosity.
- Good tack combined with a long coater life.
- Both components are non-red label (Flash Point >100° F.)

TYPICAL PROPERTIES		PART A	PART B
Component		Epoxy Resin Base	Curing Agent
Solids		61 – 63%	83 – 84%
Density		12.6 – 13.0 lbs/gal	12.8 – 13.2 lbs/gal
Mix Ratio (by volume)		1	1
Viscosity	Component	9,5000 – 11,500 cps	9,5000 – 11,500 cps
	Mix	9,5000 – 11,500 cps	
Color		Pink	Yellow



Application Procedures

1. Bonding surfaces should be free of all contaminants: dirt, grease, waxes, etc.
2. Blend thoroughly equal volumes Part A and Part B.
3. Apply 8818HV to either bonding surface. A wet film thickness of CA 2 mils \pm .3 mils will normally provide satisfactory bonds. Adjust to somewhat heavier lay-downs if the board is excessively porous or the film heavily embossed.
4. Laminate surfaces with nip roller or other suitable means. Adhesive will exhibit some green strength, thereby holding film in place.
5. 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 a smooth surface.
6. The bond, depending on the vinyl film used, will exhibit up to vinyl tearing in 24-48 hours. Full cure is normally achieved in 7 to 10 days at 77°F.; however, laminates can usually be machined in 16 hours. Curing is somewhat slower when ambient temperature drops below 60°F. Do not store freshly laminated panels below 50°F.

Clean Up:

Equipment may be cleaned 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 skin contact. If contact occurs, wash thoroughly with soap and water.

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

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