

**PRODUCT
INFORMATION**

DAUBOND® SPECIALTY APPLICATION EPOXY ADHESIVE
DAUBOND® 8855AL&BL
SOLVENT FREE VINYL LAMINATING EPOXY ADHESIVE

Daubond® 8855-AL/BL is a high quality, SOLVENT FREE, two-part, modified epoxy adhesive designed to laminate vinyl film to various core substrates, including wood, metal and some plastics. Daubond® 8855 AL/BL should be used where a very low VOC product is required.

ADDITIONAL FEATURES OF DAUBOND® 8855-AL/BL INCLUDE:

- Solvent free
- Very low mixed VOC
- Equal volume mix ratio.
- Color coded red and yellow for easy identification and mixing.
- Cures at room temperature
- Laminates can be machined in 16 hours.
- Bonds most vinyl films (not recommended for standard reverse printed vinyl films).
- Supplied at ready-to-use viscosity.
- Non-flammable.
- Both components are non-red label (Flash Point >100°F).

TYPICAL PROPERTIES		PART A	PART B
Component		Epoxy Resin Base	Curing Agent
% Volatile of Mixed Adhesive Ambient Temperature		Negligible	Negligible
Density		11.5 ± .2 lbs/gal	9.6 ± .2 lbs/gal
Mix Ratio (by volume)		1:1	1:1
Viscosity	Component	3,000 – 5,000 cps	3,000 – 5,000 cps
	Mix	3,000 – 5,000 cps	
Mixed VOC (per SCAQMD Rule 1168) @ 77° F. 7 days		Nil (<5 grams/liter)	



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. The pot life decreases as the volume of mixed adhesive increases; therefore, mix no more adhesive than can be used immediately.
3. Apply DAUBOND® 8855 to either bonding surface. A wet film thickness of 1.5 – 2.0 mils will normally provide satisfactory bonds. Adjust to somewhat heavier laydowns if the board is excessively porous or the film heavily embossed.
4. Laminate surfaces with nip roller or other suitable means.
5. It is desirable that the film be held tightly against the wood substrate. If extremely coarse board surfaces are encountered, stacking panels face-to-face will provide a smooth surface. Laminated panels should be banded to prevent slippage.
6. Full cure is normally achieved in 7 to 10 days at 77°F. 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. Partially cured adhesive may require a solvent for complete removal. A proprietary solvent blend designed for Daubond® 8855 AL/BL is available under the name of "DAUSOL". Cleaning should be done promptly at end of each 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. Use in well ventilated area.

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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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