

**PRODUCT
INFORMATION**

DAUBOND® 8855
SOLVENT FREE VINYL LAMINATING EPOXY ADHESIVE

DAUBOND® 8855 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 should be used where a very low VOC product is required. Equal volume mix ratio. Each part is color coded for easy identification and mixing. Cures at room temperature. Laminates can be machined in 16 hours. Bonds most vinyl films, but is 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 ± 0.2 lbs/gal |
| Mix Ratio (by volume) | | 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

Bonding surfaces should be free of all contaminants: dirt, grease, waxes, etc. 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. 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. Laminate surfaces with nip roller or other suitable means. 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. 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. Cleaning should be done promptly at end of each run. Cured adhesive can only be removed with great difficulty.

Storage Conditions

For maximum storage life, avoid temperatures above 100°F and below 32°F.

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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