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AptTec inc.
Adhesive & Process Technologies

TECHNICAL DATA SHEET

APT-0325P

ADHESIVE

PRODUCT DESCRIPTION:

APT-0325P is a one-component polyurethane reactive hot melt adhesive. It is designed to give aggressive tack, long open time and high green strength. It can be used for lamination or bonding of baypreg, carpet, wood, fiberboard, particleboard, plywood, EPS foam, FRP, PU foam, ABS and metals.

TYPICAL PROPERTIES:

Viscosity: 12,000 cps @ 250°F

Open Time: 3-4 minutes

Color: Purple

Curing Mechanism: Humidity Curing

Suggested Running Temperature: 250°F

INDUSTRIES:

Automotive Interior Trim, RV, Office Furniture, Building Components, Product Assembly

COLORS AVALIBLE:

Off White: AP-0325P-ND
Black: AP-0325P-B

HANDLING & STORAGE:

6 Months if unopened, once opened drums/pails need to be used immediately. This product contains isocyanate. Store product in dry area at between 60F to 80F.

ROTATE STOCK:

For best results, use older lots first.

APPLICATION METHOD:

APT-0325P can be applied by roll coating, swirl spray, or reactivation. Deposition rate can vary from 8 to 20 g/sq ft, depending on substrate porosity. Sometimes surface treatment such as flame or corona treatment may be necessary. Substrate surface must be free of oil, grease, lubricants, dust and any other surface contaminants. Aluminum or other metals must be conversion coated or primed for best adhesion.

CLEAN UP:

Acetone and methyl ethyl ketone (MEK) can be used to clean uncured adhesive material. Cured materials can only be removed mechanically.

Roll Coater Cleaner: Use AP-260 Plastizer

Drum or Pail Unloader: Use Technomelt PUR Purge 3180

Tank Cleaner: Use Technomelt PUR Cleaner 2

DISCLAIMER:

The information given above is based on our best knowledge, and is believed to be true and accurate. No guaranty of accuracy is made. It is the purchaser's responsibility before using any product to verify this data under their own operating conditions, and to determine whether the product is suitable for their purposes. Please read the entire product bulletin along with our conditions of sale, which apply to all goods supplied by us. Aptec, Inc. assumes no responsibility for the use of these statements, recommendations or suggestions, nor do we intend them as a recommendation for any use which would infringe upon any patent or copyright.

NOTE: The above specifications are tentative and subject to change based on actual batch history.

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