

ADHESION PROMOTER

Product code: **E/1408**
Color: Transparent

Composition and Application Field

Based on polyvinyl resin and poly functional isocyanic polymer UV drying, Recommended as adhesion promoter for melamine because of its good adhesion properties.

Product Preparation

Additives	by weight	by volume	catalyst
	20%	20%	E/1024

Pot life 3hrs at 50°C (roller coater)
 6hrs at 25°C (spray)

Dilution

Spraying: Dilute with PU thinner or E/613 at 20-30%
Roller coater: No need thinner.

Technical Characteristics

Physical Properties

Specific gravity	0.86	(± 0,025) Kg/l
* Visc. Ford 4	18	(± 20) Sec.
@ 25°C		
Weight solids	12%	(± 2) Kg/Kg
Weight solids blended	15%	(± 2) Kg/Kg
Flash Point	< 21	grades
		centigrade

(Abel Pensky closed cup)

Application Rate

Spraying	50-80 g/m ²
Roller coater	15-30 g/m ²

Drying

Air Drying: 15-30 mins. After drying of adhesion promoter, must be apply the following basecoat (without sanding).

Infrared Drying: Flash off 15-30 secs, dry 1-2 mins. then apply the basecoat.

Note: If more than 1hour after adhesion promoter applied, sanding must be done but adhesion could be worse. Considering a lot of possibility to use and variables that can have effect on drying, contact our Technical Department for more information and clarifications

Dry Film Characteristics

Mechanical Characteristics

Adhesion	Very Good
Transparency	Very Good

Surface Preparation

No special treatment for the surface, it just must be clean before application of sealer.

Application Method

You can apply the product as follows:

Spray gun: Use spray gun with a 1.5-1.8 mm nozzle at 3-4 atm/bar

Roller Coater: No need to dilute.

Curtain Coater: This kind of application is not recommended.

Subsequent Treatments

After drying, it is possible to proceed (without sanding) with the basecoat using UV or polyurethane products. The application could be by roller or spray.

Note

Do not apply on substrates with moisture content above 14-15%. Do not apply in environment with temperature below 15°C. Melamine foil is very variable, always check adhesion in preliminary tests before starting production.

Packing

Available in 1 ltr., 5ltr.

Storage

If the drum is hermetically closed and well stored at 25°C, the product (and relative additives) has six months of shelf-life. For material already included photo initiator additive the shelf life is 3 months.

Use before the expiry date indicated on labeling.