

Fortis AD5113 is a single component, moisture curing sprayable polyurethane lamination adhesive. It reacts rapidly with atmospheric moisture, to provide a superior bond for many lamination applications. Suitable for a wide range of metals including stainless and Colorbond.

Features and Benefits

- Lamination Adhesive
- Spray / Roller / Brush
- Low viscosity
- Non-Flammable
- Superior adhesion at low dosage
- Excellent heat resistance

Typical Applications

- Stainless Steel Benchtops
- Composite panels
- Polystyrene
- Colorbond
- RV bodies
- Truck bodies
- Rubber matting

Properties

- Colour: Red liquid
- Coverage: 100-400 g/m²
- Solids: 50-60%
- Viscosity: <300mPas
- Open Time: <10 min@20oC (65% RH)
- Clamp Time: 40 min

Pack Size

22kg, 240kg

Shelf Life

18 months @ 25°C unopened

Safety

- Contains isocyanates
- Refer to Safety Data Sheet prior to use
- Good industrial hygiene practices should be observed at all times
- Appropriate PPE should be worn including impervious gloves & eye wear

Storage

Store in cool, dry conditions, out of direct sunlight and in a well-ventilated area. Do not store below 5°C or over 40°C.

Partially used containers should be purged with dry nitrogen to prolong storage stability as the material will skin in 1 - 2 hours if left in contact with humid air. If contact with moisture or water occurs, the drums should not be resealed. Reaction with water leads to gas evolution, with possible pressure build-up.

Application

The adhesive is designed for spray application at a rate of 100 - 200 gsm to one surface of the glue line. Airless spray with a pump of ratio of 30:1 and a fluid pressure of 8 - 17MPa (1200 - 2500 psi) is recommended. An air assisted spray gun can also be advantageous. Spray tips which give a wide spray area and of relative large diameter (0.017"- 0.025") are recommended. The adhesive is particularly suitable for high speed lamination as the methylene chloride based solvent system ensures solvent retention is minimised. Where very rapid assembly is required, the coated panels should be passed under infra-red or hot air heaters prior to assembly. It is generally recommended that panels can be assembled within 10 minutes although under normal temperatures and humidity good adhesion can be obtained after at least 15 minutes open time. Pressing of the assemblies is recommended to ensure intimate contact. Low pressures (28 - 70 kPa ie. 4 - 10 psi) are generally all that is required. Cure can be greatly accelerated by a hot press where excellent bonds can be achieved within 12 minutes at 50°C compared with 1 - 1.5 hours at ambient temperatures.

Note: Do not use through application equipment made of aluminium. Fortis AD5113 contains chlorinated solvents. Experience has shown that under certain conditions reaction between the solvents and aluminium components may occur. With the high pressures used in this type of equipment the results can be devastating. All components in contact with the adhesive should be made of stainless steel. Graco and Binks can supply suitable pump units.

Clean-Up

Moisture can permeate into spray equipment in time, particularly when the equipment is not being used. This may cause the adhesive to gel and subsequent line blockage. It is recommended that the equipment be thoroughly cleaned whenever the line is to be shut for a period of time.

Providing moisture impervious lines such as Teflon are utilised the adhesive can be left in the sealed system for longer periods of time. The lines should be flushed with a suitable solvent such as methylene chloride, leaving the spraying system full of solvent.

Limitations

For further information, including Safety Data Sheets and Technical Bulletins on adhesive applications and surface preparation, refer to the Fortis website www.fortisadhesives.com.au.

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