



The Glue People

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TradePUR

88

Panel Laminating Adhesive.

General Description

TradePUR 88 is a twin component polyurethane adhesive developed to meet exacting industrial standards in a new climate of environmental awareness. The adhesive has been produced to give exceptional levels of adhesion to a wide variety of substrates. TradePUR 88 was developed for bead and spray application utilising our knowledge of application equipment to obtain optimum performance.

TradePUR 88 was designed for applications where excellent adhesion to a wide variety of substrates is required. The product can be bead or spray applied and is ideally suited for panel lamination, it is widely used in many industries including; caravans, cold storage panels, refrigerated vehicles, curtain walling and cladding panels.

Application

Preparation

Surfaces must be clean, dry and free from any contaminants liable to impair adhesion. Metal surfaces such as galvanised steel and untreated aluminium require the use of a primer in order to obtain a satisfactory bond.

Method of application

We have developed a two part metering system where both components are accurately transferred from bulk containers to a manifold where they are combined in the correct ratio and mixed prior to application. The manifold and mixer are flushed clean when application stops for extended periods. Alternatively the adhesive can be manually applied through a twin cartridge fitted with a static mixing nozzle.

Bonding / Pressure range

TradePUR 88 should be applied as it is supplied. All panels or composites should be held together throughout the cure process. This is best accomplished in a press with up to 10 p.s.i. pressure, however; this will depend on the strength of the substrates and core materials.

Temperature (°C)	Open Time	Press Time	Total Cure Time
10	90	270	360
12	81	243	324
14	69	207	276
16	60	180	240
18	53	157	210
20	45	135	180
22	38	112	150
24	33	99	132
26	29	85	114
28	26	82	102
30	23	67	90

Coverage

Between 3 and 10 m²/kg depending on the porosity and uniformity of the substrates being bonded. Only one substrate requires coating with TradePUR 88.

Physical Data

Base	Polyurethane
Colour	Part A – Blue Part B – Yellow Mixed – Green
Viscosity @ 20°C	Part A – 2500 to 3500 cps Part B – 2500 to 3500 cps
Specific gravity @ 20°C	Part A – 0.95 to 1.05 Part B – 1.10 to 1.20
Mix Ratio	100 : 114 by weight A : B
Non volatile content	100%
Flammability	No flash point
Chemical resistance	Resistant to water, aliphatic oils, dilute acids and alkalis.
Service temperature	-40°C to +130°C
Application Temperature	Between 10°C and 25°C
Storage life @ 25°C	6 months in unopened containers. Store between 4°C and 25°C. Lower temperatures can cause permanent damage to the solution.
Cleaning solvent	Tradesolve 6.
Dilution solvent	TradePUR 88 is supplied ready to use. No dilution required.

Packaging

Part A : 206kg drums and 1000kg IBC
Part B : 236kg drums and 1170kg IBC
400ml Twin cartridges.

Important Notice

Data contained in this document is for information only and is believed to be reliable. Trade Grade Products Ltd (TGP) cannot assume responsibility for results obtained by others over whose methods we have no control. It is the user's responsibility to determine suitability of the product for any specific purpose and TGP is pleased to provide a sample upon request.

Before using this product ensure that you have been supplied with and have read carefully the following information.

- The hazard label (complying with latest CDG/CPL regulations) applied to the container.
- Material Safety Data Sheet, TradePUR 88 Part A and part B.