

# DW-40(A,B)

For MDF wrapping

**DAEHEUNG CHEMICAL**

DW-40(A,B) is two component poly-urethane base adhesive, which is the good workability and bonding strength for the profile wrapping of PVC sheet and film to wood and plastic.

## 1. Uses

- For wrapping profiles of chipboard, MDF, solid wood, plywood on PVC film.

## 2. Characteristics

- Good initial and final bonding strength..
- Cold weather and heat resistance.
- Good workability.

## 3. Physical properties

| Properties       | DW-40(A) (Resin)   | DW-40(B) (Hardener)         | Reference             |
|------------------|--|-----------------------------|-----------------------|
| Main component   | Urethane resin   | Poly isocyanate             |                       |
| Color            | Clear & yellow viscous liquid                            | Dark brown & viscous liquid |                       |
| Solid contents   | 28±1%  | More than 98%               | at 105±5℃ x 3hr       |
| Viscosity        | 7,500±500 cps  | 200±50 cps                  | at 20℃, RION VT-04 #1 |
| Specific gravity | 1.3±0.1 g/cm <sup>3</sup>                                | 1.2±0.1 g/cm <sup>3</sup>   | at 20℃                |
| Mixing ratio     | 20   | 1                           | By weight             |
| Pot life         | 8 hr   |                             | at 20℃                |
| Curing time      | 24 hr  |                             | at 20℃                |
| Shelf life       | 9months in unbroken package under dry and cool condition |                             |                       |

## 4. How to use

- For hand mixing, combine Part A and Part B in the correct ratio and mix thoroughly.  
(Mixing ratio is A:B=20:1 by weight.)
- Use profile wrapping machines.
  - Applying amount: 100~250 g/m<sup>2</sup> (0.04~0.08mm)
  - Line speed: 15~30 m/min
  - Drying channel temperature: 65±10 ℃
  - Coating method: Knife coater, doctor blade etc.

- By applying an adhesive on one side of the adhering members (SHEET PVC) through the dryer of less than about 70 °C causes evaporation of the solvent.
- On the other hand, by introducing a large size to be adhered, such as MDF or PB subsequently remove the suction dirt, dust, etc., and pre-heated in a hot air such as INFRA RED
- By continuously applying and adhering to the preheated PVC SHEET chief judge and proceed to curing and processing.
- Should be allowed to stand for curing at a temperature of 20~40 °C, it must usually curing at 20~40 °C, 24~48 hr time to become fully cured.
  - ※ Specification of the adhesive can be adjusted slightly depending on aptitude, job and workplace conditions for depositing material types and machines.

## 5. Caution

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- Avoid direct rays of the sun and keep in cool and dry place.
- Use the adhesive within pot-life.
- Close the cap tightly after using it.
- Ventilation the room well because of containing solvent.
- Don't use except for the original purpose.

## 6. Packaging

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- DW-40(A): 18kg Tin C/N
- DW-40(B): 0.9kg PE C/N

Please contact us for further information or see Material Safety Data Sheet (MSDS) for this product.

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