

# HD-T

For ABS Door

**DAEHEUNG CHEMICAL**

**HD-T is a urethane base adhesive, which is excellent bonding strength. It is good spray and roll coating type for one part moisture curing adhesive.**

## 1. Uses

- PVC, ABS and Various plastic.
- Wood and Iron plate.
- Metal and PVC form.

## 2. Characteristics

- Excellent in initial bonding strength and final bonding strength.
- Excellent in cold resistance and water resistance.
- Good spray characteristic.

## 3. Physical properties

Properties	HD-T	Reference
Main component	Poly urethane	
Color	Dark brown transparent viscous liquid	
Solid contents	85~89 %	at 105±5°C x 3hr
Viscosity	500~1,000 cps	at 20°C, BF #2, 50rpm
Specific gravity	1.10±0.05 g/cm <sup>3</sup>	at 20°C
Pot life	1 hr	at 20°C
Curing time	24 hr	at 20°C
Shelf life	3months in unbroken package under dry and cool condition	

## 4. How to use

- Remove all dirt, grease, water and rust from the bonding surface before applying
- Coating it both surface and joint and press then tightly
  - Applied amount : 100~200 g/m<sup>2</sup>
  - OPEN TIME : 20~30 min
  - Compression pressure : Over 3~5 kgf/cm<sup>2</sup>
  - Press time : 3~6 hours

- Curing time : Over 24 hours
- Working conditions standard : Room temperature(15~25℃), Humidity(40~60%)
- After adhesive curing and proceed to the machining process.
  - ※ It is difference for kind of material, kind of machine and work situation.

## 5. Caution

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- Avoid direct rays of the sun and keep in cool(5~25℃) and dry place.
- Keep it away from the fire.
- 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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- 18kg Tin C/N

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

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