

TECHNICAL DATA

MEKOL 1952/O

adhesive for laminating

DESCRIPTION

MEKOL 1952/O is dispersion adhesive for 3D laminating in blue color.

FIELDS OF APPLICATION

Adhesive is used for bonding thermoplastic foils on MDF boards and other suitable supporting material in membrane presses as well as in non-membrane presses where adhesive is applied by spraying in the productions of outdoor furniture.

It is used as two component system with 5% hardener MEKOL B10. In this combination it reaches high green strength, good adhesion on thermoplastic foils like PVC, PP, PET, ABS, the heat resistance of final joint up to 120°C and high water and steam resistance. The thermoplastic foils should be primed.

TECHNICAL DATA

Component A – dispersion MEKOL 1952/O

Chemical base

polyurethane dispersion

Colour

light blue

Viscosity at 20°C

(ISO 2555-Brookfield RVT, spindle 2/20 rpm)

600 - 1000 mPa s

pH value (ISO 976)

ca. 7,5

Marking

not subject to marking-see our safety data sheet

Component B- hardener MEKOL B10

Chemical base

polyisocyanate

Colour

slightly yellowish

Marking

contains isocyanate (see safety data sheet)

Mixing ratio

Addition comp. B on 1000 g MEKOL 1952/O

50 g

Pot life

ca. 10 hours (depending on ambient temperature)

APPLICATION

Good stirring of the adhesive before use is recommended after longer storing period.

The materials to be bonded must be clean, free from dust, oil and grease.

The hardener is added to the agitating adhesive. The both components must be mixed together homogeneously so that the finest possible of polymer particles is achieved.

The mixture is applied on the board using spray gun which provides a good and even coating. On the shape of the profiles double spraying is recommended.

The most convenient binding conditions are:

temperature of wood and all materials involved

18 - 20°C

spread quantity

- smooth, non-machined surface

50 – 80 g/m²

- shape of the profiles, machined surface

100 – 120 g/m²

required pressure for spraying

2,5 – 4 bar

nozzle diameter

1,5 mm

drying time at normal conditions

20 – 60 min (depending on absorbency and moisture content of supporting material, the spread quantity, ambient temperature and relative humidity. The drying time could be reduced with heat or air motion.)

Recommended reactivation temperature

in the glue line

60°C – 80°C in the glue line

press pressure

4 bar

Final strength of the bond is achieved after several days.



CLEANING

Application tools, machines and packaging should be cleaned with warm water before glue dries.

PACKAGING

Component A – dispersion MEKOL 1952/O

polyethylene vessels	30 kg net
other packing units according to agreement	

Component B- hardener MEKOL B10

plastic bottle	0,75 kg net
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STORAGE

Adhesive should be stored in properly closed original packaging between +15°C and +30°C.
During transport, the temperature may be lower, from +5°C to 15°C for a max. duration of 14 days.
Properly stored adhesive can be stored for at least 6 months.
Good stirring of the adhesive before use is recommended after longer storing period.

The information provided herein, especially recommendations for the usage and application of our products, is based on our knowledge, results of laboratory tests and practical experience gained to date.

We guarantee a constant quality of our products under our technical specifications. Technical advice of our application department is available without obligation. This does not release the buyer from testing our products in his own responsibility with respect to their suitability for intended application and application process. Such an evaluation should be repeated if materials are changed in any way or bought from a different source.

We do not accept any liability with regard to above information or with regard to any verbal recommendation since different materials used in conjunction with our products as well as varying working conditions are beyond our control.