



# Product Data

## Q-18 INSTALAM

### LAMINATING ADHESIVE

Issue Date: 11/03/2010

#### **Purpose**

This product is a replacement for moisture-cure polyurethanes, which are commonly known as PURs. It eliminates many of the problems associated with such competitive products and can be applied with the same pumps, laminating rollers, roll coaters, and hot melt equipment.

#### **Composition**

The product is composed of saturated resins, plasticizers, adhesion promoters, and pre-cured elastomers.

#### **Application**

This compound is intended for use in a factory application. The application should be made using hot melt equipment with a gear pump at a setting of 350°F (bulk melter) or 355°F with tank units. For best adhesion the orifice of the nozzle must be held close to the bead that is being applied. It is recommended that the distance be no more than one-half the thickness of the bead. For proper set up consult the compound manufactured for proper setting, orifice size, and pressure requirements.

#### **Clean Up/ Precautions**

The material can be cleaned from tools and equipment with a light application of mineral spirits.

Prolonged exposure to temperatures exceeding 400°F could result in a thermal breakdown of the compound and greatly reduce its physical characteristics and performance.

#### **Packaging**

This material is generally packaged in 55 gallon fiber drums. It can also be supplied in 5 gallon fiber pails.

#### **Freight Classification**

“NOIBN” (no red label required) Class 55, Item No 149610  
HMIS Rating: Health – 0, Flammability – 0, Reactivity – 0.

#### **Advantages of Q-18**

- 100% solids content with no volatile or contaminating ingredients
- Require no clean-up when roller coater is shut down
- No toxic fumes discharged and thus no need for protective equipment
- Instantaneous bond thus negating the need for extended cure time
- Not affected by plasticizer migration from vinyl films
- When applied to door stiles and rails, the wood has been known to separate within minutes when pulled apart
- When applied with a roller coater, the material can be applied easily in a thickness range of from 5 to 15 grams or more per square foot.

#### **Disadvantages of Traditional Laminating Adhesives & PURs**

- Low solids content results in higher costs through evaporation (30%-40% at times)
- Flammable, contaminating and possible hazardous ingredients
- Prohibited in some states due to solvent content
- Generally toxic dictating the use of special protective equipment
- Usually contain fillers, which are abrasive to commercial pumps

#### **Test Data**

**Color:** Amber

**Specific Gravity:** ASTM D71-72 -  
.96 (lbs./gal) – 8.0

**Odor:** Slightly Resinous

**Viscosity:** 25,000cps

**Solids Content:** ASTM C771-74 1  
hour @350° -99.83% min.

**Peel Strength:** ASTM C-794 Vinyl,  
12pli typical, Polypropylene, 20pli  
typical

**Flash Point:** Pensky – Martin,  
<450°F (232°C)

**Toxicity:** none



## Product Data

- Rated hazardous by OSHA (Standard 29CFR 1910.1200)
- Extremely low viscosity and may penetrate surfaces and form a weak bond line
- Moisture curing types generally exhibit open times of from 45 seconds to up to 4 to 5 minutes.

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