

## Technical Data Sheet

# Curvalin D 3602

## 1 Description

Aqueous, thermally low reactivatable dispersion adhesive, which can be used for single-sided lamination (e.g. automotive industry). The adhesive has a high initial adhesion, a good tension behavior and a high heat resistance. Suitable for bonding pressed fleece and hardboard with textiles, leather, leatherette, PU foams and PVC foils.

## 2 Technical Data

Basis	Modified polyurethane dispersion
Solid content	55 - 59%
Density	approx. 1,0 g/cm <sup>3</sup>
Viscosity	2000 - 4000 mPa·s (Brookfield DV-I-Prime, Sp.3, 20 rpm, 20 °C)
pH-value	7 - 9 (pH electrode)
Recommended working temperature	18 - 25 °C
Pretreatment	Surfaces have to be free from grease or oil
Application method	Spraying (HVLP)
Activator component (B-component)	Zeludur 300 / Zeludur 300 black
Amount of B-component	3-5 wt%
Pot life	6-8 h
Applied quantity	80-150 g/m <sup>2</sup> (one side application)
Reactivation temperature	at least 70 °C (in the glue line)
Curing time	at least 3 days

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### 3 Application

It is possible to use Curvalin D 3602 as a 1K variant with less resistance. To achieve better adhesive properties and heat resistance mix Curvalin D 3602 thoroughly with the hardener Zeludur 300 in the weight ratio indicated above under vigorous stirring. Please consider the pot life of the 2K adhesive after mixing with the hardener.

Apply the adhesive on one or both sides via commercially available HVLP low-pressure spray guns (nozzle size: 1.2 - 2.0 mm). Before sealing the adhesive film must be completely dry. For this purpose flash off the carrier part at room temperature, or dry it for a short time at about 40 °C. Then the bond can be made either by heated dies at about 80 °C or directly after reactivation of the adhesive film (e.g. IR field at 140 °C for 1 min) in a cold press at a pressure of 1-3 bar. In 2K case the lamination should be completed within the next 1-3 hours. The sealing temperature inside the glue line should be at least 70 °C.

It is highly recommended to use plastic or stainless steel in all parts of the spraying device. No non-ferrous metals must be used.

### 4 Shelf life

The storing temperature should not be lower than +5°C (40 °F), as the product is sensitive to frost. Frozen product is irreversibly damaged. Avoid also temperatures above 30 °C (86 °F). We recommend an average storing temperature between 15-25 °C (60-80 °F). Under these conditions, the storage time in the originally closed and sealed packaging will be up to 6 months.

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