

Apollo (A7504)



Solvent-Free Panel Lamination Adhesive (1K MCPU)

Apollo (A7504) was specifically developed for the manufacture of a wide range of panels, including sandwich panels, cold stores and caravans. It is a solvent-free one-component moisture-curing polyurethane adhesive (1K MCPU) that offers the manufacturer many benefits.

Benefits:

- Extremely versatile: bonds a wide range of construction products and materials.
- Reduces equipment cost: developed to allow for manual application.
- Complete peace of mind: due to it's high strength durable weatherproof bond.
- Minimises production cost: single-component adhesive with a low coat-weight and long open –time.
- Green Credentials: solvent-free polyurethane adhesive.

Technical Data

Base	Polyurethane	Cure-Time	55 Minutes
Appearance	Brown	Open-Time	21 Minutes
Temperature Resistance	-30-150°C	Shelf Life	6 Months
Coverage	Upto 12.5m ² /kg	Storage	5-25°C
Application Temperature	5-25°C	Environmental	Solvent-Free/Hazardous/Non-Flammable
Viscosity CPS	4500 @ 25°C	Cleaner	Solvent 6

Processing Guide

Temperature	15°C	17.5°C	20°C	22.5°C	25°C
Open-Time (Minutes)	26	23	21	18	15
Cure-Time (Minutes)	65	60	55	45	35



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Instructions for Use:

1. Ensure all surfaces to be bonded are clean and free from grease and other contaminants. Some grades of aluminum, galvanised steel and plastics may need priming.
2. Apply an even coat of the adhesive to one surface with a roller coater, trowel, scraper or an automatic bead-applicator.
3. The amount of adhesive required will vary according to the porosity/smoothness of the substrate and the method of application, but will be between 80-140g/m².
4. Mist the adhesive with water once it has been applied (approximately 10% of water based on the adhesive coat-weight).
5. Assemble the panel and place under pressure within the open-time (21 minutes). Pressure is usually applied using a hydraulic press, vacuum table or bag press. The pressure required will depend on the nature of the substrates, but it is usually in the range of 0.5 to 0.9 bar.
6. Maintain pressure until the adhesive is sufficiently cured to permit handling of the bonded item (55 minutes).
7. Full cure of the adhesive will not be achieved for 24 hours. Keep handling to a minimum during this time.

NB: Metals should be stored in a warm environment prior to bonding in order to avoid the glue line chilling, which could lead to extended cure times. A test panel should always be prepared when using new materials in order to establish compatibility. One of the surfaces to be bonded must be porous/permeable.

IMPORTANT NOTES

Storage and handling: The product should be stored unopened in a dry condition at a temperature of 5-25°C. This will ensure the stated shelf-life. The adhesive will have a limited life once the container is opened.

Temperature and timings: All information on temperature and timings represent normal working conditions and is provided as a guideline only. However, please contact Apollo for advice if you wish to operate outside of these parameters.

Disclaimer: Apollo has taken care to ensure that the information provided in the literature is correct and up to date. However, it is not intended to form any part of a contract or provide a guarantee. Purchasers/intending purchasers should contact Apollo to check whether there have been any changes to the information since publication of the literature. Please ensure you have read the hazard labels and material safety data sheet before using this product.