

### **Adhesive PU 303 - PU spray application adhesive for bonding various products made of PVC, PU, rubber, textile, wood, chipboard, veneer, metal.**

#### AREAS OF APPLICATION.

Adhesive PU 303 is recommended for facing vehicle interiors, seats and other elements in cars, buses, boats with different facing materials.

#### PROPERTIES.

- High strength and good thermal stability of the assemblies.
- Resistance to hydrolysis (water resistance), acids and mineral oil.
- Good connection flexibility, including at low temperatures.
- Short open time and therefore high initial bond strength.

#### TECHNICAL DATA.

Based	PU
Colour	Colorless, transparent
Conventional solids content, %	10 – 12
Viscosity at 20°C, mPa.s	approx. 600
Density at 20 °C, g/cm <sup>3</sup>	approx. 0.83
Open time at 20 °C, min	5
Bond Strength, N/cm, 24 hour	70 – 90
The time to reach 70% of maximum strength, min	5 – 7
Temperature resistance of the assemblies (adhesive strength not less than 20 N/cm), °C	80
Thermal activation temperature, °C	50 – 65
Maximum allowable operating temperature (short-term exposure), °C	110

#### PACKAGING.

Metal can 330g (0,54L)	24units in cardboard box
Metal can 600g (0,8L)	12 units in cardboard box
Conical metal container 2,3kg (3L)	4 units in cardboard box
Conical metal container 16,3kg (20L)	
Cylindrical metal container 40kg (50L)	

#### STORAGE.

Storage time - 12 months. Recommended storage temperature: + 5 - +25 °C. Storage in original containers.

#### WARNING

During transportation at negative temperatures, the viscosity increases, but if it enters into a warm room adhesive properties are recovered without intervention.

#### SAFETY.

Highly flammable and irritant.

This product data sheet is only valid in conjunction with the latest edition of the corresponding Safety Data Sheet. Any updating of safety-relevant information– in accordance with statutory requirements – will only

## Technical Datasheet

### Adhesive PU 303

be reflected in the Safety Data Sheet, copies of which will be revised and distributed. Information relating to the current classification and labeling, applications and processing method, and further data. Read material safety data sheet before use.

#### INSTRUCTIONS FOR USE.

##### **General recommendations**

##### **Substrates preparation:**

The substrates to be assembled must be dry, dust free and not have any traces of grease or other contaminants that could adversely affect the adhesive performance. PVC and PU substrates may be cleaned with MEK or ethyl acetate. Low or high temperature materials should be sustained for 3 – 4 hours, temperature of adhesive and substrates have to be between 15 - 25 °C.

##### ***Application :***

The adhesive is spray applied to the prepared surfaces.

Recommended glue temperature 18 - 22 ° C, humidity 60 - 65%. It is recommended double gluing with an interval between the first and the second 10 minutes. Spray nozzle 2 – 2,5 mm. Air pressure 4 – 6 bar.

##### ***Drying:***

Adhesive film should be dried under natural conditions. Minimal drying time depends on temperature and usually near 10 – 20 minutes. Maximum drying time is 24 hours.

##### ***Thermal activation:***

Directly before bonding adhesive film must be thermally activated - heated to a temperature of 50 - 65 ° C. Thermal activation can be local - heating the adhesive film with an infrared lamp (thermal shock method), a heated air flow or the total - in an oven. The adequacy of thermal activation temperature can be checked by measuring the temperature of the adhesive film (for example a non-contact thermometer). Perhaps, a rough estimate of the adequacy thermal activation temperature - adhesive film to become tacky.

##### ***Bonding:***

Press products to each other thermally activated adhesive films, and highly compressed (pressed) or rolled rollers. Leave under load is not needed.

Attention. The time between the by compressing and thermal activation must not exceed the open time - this glue - 5 minutes. After 5 - 7 minutes adhesive joint strength reaches 70% of its maximum. A further increase in strength occurs slowly during 30 - 40 hours.

##### ***Attention:***

If the product temperature can exceed 80 °C, adhesive should be used as two component adhesive – in mix with hardener.

##### ***Two component adhesive preparation:***

Add to adhesive Desmodur RC hardener, 3 – 5% by volume, and stir thoroughly. This mix should be used during first 3 – 4 hours after preparing.

Detailed information on the safe use of adhesive is given in the safety data sheet.

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