



Aquagrip 8611

WATER BASE POLYURETHANE ADHESIVE

KEY FEATURES

- Suitable for Electronic consumer goods
- Could fit variety of substrates
- High initial strength

DESCRIPTION

Bostik Aquagrip 8611 is a water base polyurethane adhesive. This product is especially suitable for Electronic consumer goods assembly. It is a two component adhesive (hardener Boscodur 80) with high initial strength and very good resistance against plasticizers, heat and hydrolysis. Aquagrip 8611 exhibits good adhesion to a variety of substrates including most plastics (not including PP, PE), decorative and foamed foils and foamed backed textile coverings.

RANGE OF APPLICATION

Aquagrip 8611 is suitable for Electronic consumer goods assembly.

FEATURES

- Excellent green strength
- Solvent free
- High resistance to heat and humidity cycle
- Easy processing
- Low activation temperature
- Long open time
- Fast drying
- Easy positioning of the parts to fit

TECHNICAL DATA

CHARACTERISTIC	VALUE or Description
Color	Milky White emulsion
PH	7-9
Viscosity Brookfield at 23°C	[mPa.s] 3,000-7,000(4#, 20rpm)
Density at 23°C	[g/ml] Approx.1
Solid	[%] 49.5-53.5
Mixing ratio with hardener	[kg/kg] 100:5
Pot life after mixing	[h] 6-8 (depending on temperature and humidity)
Temperature resistance	[°C] -40-110

Regarding curing process of Bostik Aquagrip 8611, the first step is the drying, due to the evaporation of water. The second step is the molecular crystallization. The last step is the chemical cross-linking with the curing agent. At room temperature, the chemical curing is complete in about 72 hours.

METHOD OF USE

Surface preparation

The bonding surfaces must be clean, dry and free of oil and grease. The surface energy of plastic parts must be at least 38 mN/m.

Mixing

The main component should be mixed with hardener with the mixing ratio 100:5 (W/W). It should be mixed well without foaming until homogeneous. Mechanical mixer is suggested to obtain a homogenous mixture, recommended processing temperature is 15°C -30°C.

Application

The adhesive can be applied with roller, brush or spray gun (nozzle 1.5-2.5mm at 0.5-0.6 MPa pressure, lower or higher pressure needs testing before apply). For automatic application, a suitable filter system is suggested.

Adhesive application quantity

The quantity required is depending on the substrates used (non-absorbent and absorbent) and the lamination process. The normal consumption is between 100-200 g/m².

Drying

Drying @40-50°C circulated air needs about 10- 20 minutes, when drying at room temperature, atmospheric temperature and humidity will influence the amount of time required to completely dried of the adhesive. One simple judgment method is touching the adhesive film without any fingerprints left, which means the adhesive is completely dried.

Bonding

After completely dried, the adhesive can be heat-activated for bonding, both press bonding and vacuum forming is acceptable. The activation temperature is to be at least 60°C. Lower activation temperature needs testing before applying. Normally after one day, the bonding parts can be transported to other place. For the aging tests, it is recommended to do after three days.

Cleanup

Cleaning of tools: Water can be used to clean the tools for uncured adhesive, cured adhesive can only be removed by mechanical means or suitable solvent.

Spraying system: It is very important to thoroughly clean the equipment daily in order to minimize the potential for blocking the application system. Water is sufficient for the cleaning work.

STORAGE

Aquagrip 8611 can be stored for 6 months in the original, unopened packaging in a dry place at temperatures between 5°C and 30°C. Frozen protection is needed when transported and stored in winter. Suggest stirring before use.

PACKAGE

Aquagrip 8611: 20 Kg / Drum

FURTHER INFORMATION

The following publication is available on request:

- Material Safety Data Sheet (MSDS Sheet)

The information given and recommendations made herein are based on Bostik's research only and are not guaranteed to be accurate. The performance of the product, its shelf life, and application characteristics will depend on many variables, including the kind of materials to which the product will be applied, the environment in which the product is stored or applied, and the equipment used for application. Any change in any of these variables can affect the product's performance. It is the buyer's obligation, prior to using the product, to test the suitability of the product for an intended use under the conditions that will exist at the time of the intended use. Bostik does not warrant the product's suitability for any particular application. The product is sold pursuant to Bostik's Terms and Conditions of Sale that accompanies the product at the time of sale. Nothing contained herein shall be construed to imply the nonexistence of any relevant patents or to constitute permission, inducement, or recommendation to practice any invention covered by any patent, without authority from the owner of the patent.

SMART HELP

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