

AQUENCE PL 1506

October 2019

PRODUCT DESCRIPTION

AQUENCE PL 1506 provides the following product characteristics:

Technology	PUR
Product Type	1C PUR Dispersion
Application	Automotive Interior Lamination
Appearance	liquid milky after drying

Application Areas

- Lamination of automotive interior parts (steering wheel, gearshift knob)

Product Properties

- Free of solvent
- Clean spraying
- High green tack
- High heat and moisture resistance
- Sealable at low temperature
- NMP- and APEO free

TECHNICAL DATA

pH value (20 °C) ISO 976	7 to 10
Viscosity, mPa.s Brookfield - Sp. 3, 20 rpm, 20°C , ISO 2555	2,000 to 3,500
Solid content, %	~ 40
Drying time, minutes depending on temperature, humidity and quantity applied	≥ 30
Activation temperature in the adhesive, °C	≥ 55
Curing time, hours	24
Complete curing, days	≥ 7

DIRECTIONS FOR USE

Preliminary Statement:

Prior to use it is necessary to read the **Material Safety Data Sheet** for information about precautionary measures and safety recommendations. Also, for chemical products exempt from compulsory labeling, the relevant precautions should always be observed. Please also refer to the local safety instructions and contact Henkel for analytical support.

Instructions for Use:

AQUENCE PL 1506 is a one-component adhesive system -

without additional cross-linker.

The working temperature of the workpiece and adhesive should be over +18°C to achieve optimal bonding results. Lower working temperature results in higher viscosity of the adhesive. The adhesive is sprayed with an appropriate spraying gun (nozzle size: 1.4 to 2 mm). The adhesive can be also used in manual application. As a rule, it is sufficient to apply one coat to the flat surface. Open pore inner and outer radii, however, need to be coated a second time after a brief drying interval. The pre-applied pieces should be sealed within 2 days to achieve optimum bond.

Note:

Temperatures above +25°C will shorten the max. storage time of pre-coated parts significantly.

All parts which come into contact with the adhesive must be made either of stainless steel (V2A/V4A) or plastic.

Cleaning:

Equipment used to apply the adhesive may be cleaned easily using cold or luke warm water before the adhesive has dried hard. Hard dried adhesive remains have to be removed mechanically.

Storage:

The adhesive should be transported and stored in a closed original container at temperatures above +10°C and below max. +30°C.

Storage below +10°C can lead to coagulation.

Storage life: up to 6 months.

Classification:

Please refer to the corresponding **Material Safety Data**

Sheets for details on:

Hazards identification

Transport information

Regulatory information

ADDITIONAL INFORMATION**Disclaimer****Note:**

The information provided in this Technical Data Sheet (TDS) including the recommendations for use and application of the product are based on our knowledge and experience of the product as at the date of this TDS. The product can have a variety of different applications as well as differing application and working conditions in your environment that are beyond our control. Henkel is, therefore, not liable for the suitability of our product for the production processes and conditions in respect of which you use them, as well as the intended applications and results. We strongly recommend that you carry out your own prior trials to confirm such suitability of our product.

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