



Product code : 54008B

## EMFIMELT 54008B MONO

### DESCRIPTION

Single component moisture curing hotmelt polyurethane adhesive.

### AREAS OF APPLICATION

EMFIMELT 54008B MONO can be used for the manufacturing of sandwich panels (caravan, building industry).

EMFIMELT 54008B MONO may be used for bonding different insulating materials (PU foam, expanded polystyrene) upon wood, aluminium, steel.

For difficult materials, particularly galvanized steel, raw aluminium, polyester, hard PVC, it is necessary to make tests beforehand.

### TECHNICAL DATA

Appearance	Solid
Colour	Colourless to light yellow translucent at 120 °C
Density at 20 °C	Ca 1.09
Conventional solids content (EN 827)	100 %
Application temperature	120 °C
Open time at 20 °C	Ca 4 min (according to EMFI method IT-104-Q/1)
Temperature resistance of the assemblies	-40 to ca 95 °C
Cleaner	EMFINET 683 before curing upon cold film and material at a temperature under 40 °C (caution : this solution is highly flammable). EMFINET L0051A for cleaning guns. EMFINET L0049A for cleaning rollers.
Specific data	Viscosity at 120 °C : Brookfield RVDVE / spindle 27 / 10 rpm : 11,500 ± 3,000 mPa.s

### ADVICE

See also material safety data sheet



### INSTRUCTIONS FOR USE

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 bonding performance.

If the substrates need to be cleaned, EMFINET 683 or methylethylketone (MEK) may be used.

For substrates sensitive to ketones, use EMFINET 688/1.

The use of solvents must comply with local regulations. Check the compatibility of the solvent used with the substrates.

If necessary, rub down metal surfaces beforehand.

When using solvents, extinguish all sources of ignition and carefully follow the safety and handling instructions given by the manufacturer or supplier.

#### Application :

Application at 120 °C on one of the substrates.

EMFIMELT 54008B MONO has been developed to be applied with a roller but it may also be applied with a slot nozzle gun or in strips.

During bonding and during the 24 next hours, the temperature of the materials must not be lower than 15 °C.

Assembling has to be followed immediately by a regular and maximum pressure without causing irreversible deformation of the materials on the whole surface during cooling with a vacuum, hydraulic or roller press.

After opening of packaging, it is necessary to protect the product from humidity.

#### CONSUMPTION

110 to 215 g/m<sup>2</sup> according to the materials to be bonded.

#### STORAGE AND SHELF LIFE

6 months in original, hermetically sealed packaging between 5 and 25 °C

#### PACKAGING

295 ml aluminium cartridges ; 2 kg aluminium wrapped blocks ; 20 kg buckets ; 200 kg drums.

#### SAFETY

Harmful. Read the material safety data sheet before use.

The technical data contained herein is based on our present knowledge and experience and we cannot be held liable for any errors, inaccuracies, omissions or editorial failings that result from technological changes or research between the date of issue of this document and the date the product is acquired.

Before using the product, the user should carry out any necessary tests in order to ensure that the product is suitable for the intended application. Moreover, all users should contact the seller or the manufacturer of the product for additional technical information concerning its use if they think that the information in their possession needs to be clarified in any way, whether for normal use or a specific application of our product.

Our guarantee applies within the context of the statutory regulations and provisions in force, current professional standards and in accordance with the stipulations set out in our general sales conditions.

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