

TECHNICAL DATA SHEET

HOTMELT PRODUCT: AHEMAD 55G025

NEY Limited
Stonebridge Trading Estate
Sibree Road
Coventry CV3 4FD
T: 024 7630 8100
F: 024 7630 8102
E: materials.info@ney.co.uk
www.ney.co.uk



Product Description

Ney AHEMAD 55G025 is a cross-linking, single component, polyurethane dispersion adhesive, developed for applying PVC to wood based materials via membrane press. It has excellent heat resistance due to its self cross-linking qualities and shows particularly high initial bond strength. The qualities of this adhesive outweigh those of some two part products which incorporate an isocyanate hardener.

**** THIS PRODUCT SHOULD NOT BE MIXED WITH AN ISOCYANATE HARDENER ****

Technical Data

Colour:	White/cream (clear when dry)
Viscosity:	1500 ± 500 mPa.s @ 20°C
Press temperature:	60-70°C on the glue line
Pot life:	24 Hours

Application

AHEMAD 55G025 has been developed for spray application, either manual or automatic.

All surfaces must be clean and free from grease and dust. The adhesive should be applied to one surface in an even coat. Two coats of adhesive should be applied to areas where there is likely to be more stress. Reactivation of the glue line should be possible for up to 2 days after application of the adhesive with a minimum press temperature at the glue line of >65°C

Working Conditions

Temperature of adhesive/substrates/workplace:	18 - 20°C
Moisture content of wood:	8 - 10%
Relative humidity:	60 - 75%

Equipment

Nozzle diameter:	1 - 1.5 mm
Pot pressure:	1 - 1.5 Bar
Air pressure:	4 - 6 Bar

Drying

Drying can take place at an ambient temperature of 20°C. This will take approximately 20-40 minutes. Time can be reduced by flash drying, however ensure the adhesive does not exceed 40°C during the drying process.

Cleaning

Use cold water to clean machinery and tools before the adhesive sets.

Storage and Shelf Life

The adhesive should be stored in a cool, dry area at temperatures between 10°C and 30°C. Under these conditions the product has a shelf life of 6 months when stored in the original, unopened container.

DO NOT ALLOW THE PRODUCT TO FREEZE

Important:

As most requirements are unique, it is most important that trials are carried out in order that the user satisfies themselves that the adhesive is suitable. The information given on this sheet is for guidance only and does not represent a specification.