

# DW-43(A,B)

For PVC frame wrapping

**DAEHEUNG CHEMICAL**

DW-43(A,B) is two component poly-urethane base adhesive which is the good workability and bonding strength for the profile wrapping of PVC sheet and film to PVC moldings.

## 1. Uses

- PVC FILM WRAPPING adhesion to PVC molding and plastic molding.

## 2. Characteristics

- Good initial and final bonding strength.(PVC molding)
- Good workability.
- Cold weather and heat resistance.
- Acid resistance, chemical resistance, and excellent durability, and less shrinkage for the column.

## 3. Physical properties

Properties	DW-43A (Resin)	DW-43B (Hardener)	Reference
Main component	Urethane resin	Poly isocyanate	
Color	Clear & colorless viscous liquid	Clear & colorless viscous liquid	
Solid contents	28±1 %	70±1 %	at 105±5 °C × 3hr
Viscosity	8,000±1,000 cps	Very dilute liquid	at 20 °C, BF # 4 10rpm
Specific gravity	0.85±0.1 g/cm <sup>3</sup>	1.0±0.1 g/cm <sup>3</sup>	at 20 °C
Mixing ratio	17	1	By weight
Pot life	8 hr		at 20 °C
Curing time	24 hr		at 20 °C
Shelf life	9months in unbroken package under dry and cool condition		

## 4. How to use

- For hand mixing, combine Part A and Part B in the correct ratio and mix thoroughly.  
(Mixing ratio is A:B=17:1 by weight.)
- Use profile wrapping machines.
  - Applying amount: 60~150 g/m<sup>2</sup> (0.06~0.09mm)
  - Line speed: 10~20 m/min
  - Drying channel temperature: 50±10 °C
  - Coating method: Knife coater, doctor blade etc.

- By applying an adhesive on one side of the adhering members (SHEET PVC) through the dryer of less than about 50 °C causes evaporation of the solvent.
- On the other hand, by introducing a large size to be adhered, such as MDF or PB subsequently remove the suction dirt, dust, etc., and pre-heated in a hot air such as INFRA RED
- By continuously applying and adhering to the preheated PVC SHEET chief judge and proceed to curing and processing.
- Should be allowed to stand for curing at a temperature of 20~40 °C, it must usually curing at 20~40 °C, 24~48hr time to become fully cured.
  - ※ Specification of the adhesive can be adjusted slightly depending on aptitude, job and workplace conditions for depositing material types and machines.

## 5. Caution

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- Avoid direct rays of the sun and keep in cool and dry place.
- Use the adhesive within pot-life.
- Close the cap tightly after using it.
- Ventilation the room well because of containing solvent.
- Don't use except for the original purpose.

## 6. Packaging

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- DW-43(A) [Resin]: 15kg Tin C/N
- DW-43(B) [Hardener]: 850g Tin C/N

Please contact us for further information or see Material Safety Data Sheet (MSDS) for this product.

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