



D2655

D2655 is a single component (1K) moisture curing polyurethane (MCPU) adhesive. It has been developed primarily for applications in the laminating and panel manufacturing industries where it is used for bonding foam insulating materials, and honeycomb etc., to a wide variety of plastics, metals and woods.

- Economical:** Its ease of spreading, high solids content and one way stick, and low coat weight characteristics ensure fast, low-cost coverage. D2655 develops bond strength quickly once cured, allowing for panels to be worked with immediately after the press cycle, maximising work progress.
- Versatile:** D2655 can be used to securely bond a wide range of materials including most insulation, plasterboard, metals, plastics and wood.
- Strong, resilient, flexible bond:** The cured adhesive exhibits excellent flexibility and resistance to extreme temperatures (-40°C to +140°C), moisture and solvent for extended periods without loss of strength.

Technical Specification

Parameter	Specification
Colour:	Green
Viscosity at 23°C:	3,400 ± 500mPa.s.
Specific gravity:	1.13 gm/cc

Parameter	Specification
Application Method:	Bead Machine, Roller Applicator, Hand Application
Coverage:	100 – 250gsm depending on substrates being bonded.
Water mist application:	10% of adhesive coat weight.
Open Joint Time:	26 – 29 minutes at 19°C with water mist.
Press Time:	Nominally 65 minutes at 19°C with water mist.

Open Times and Press times as a function of Temperature

	13°C	15°C	17°C	19°C	21°C	23°C	25°C	27°C	29°C	31°C
OJT (mins)	33.5	31.0	28.5	26.0	23.5	21.5	19.5	18.0	16.0	15.0
PT (mins)	84.5	77.5	71.0	65.0	59.0	54.0	49.0	44.5	40.5	37.0

OJT: Open Joint Time (Max time open to air).

PT: Period of time required under pressure in the press.

Instructions For Use

Substrate preparation:

1. Ensure all surfaces to be bonded are clean and free from grease and other contaminants.
2. Metals should be kept in a warm place prior to bonding to avoid shock cooling of the bond line which leads to protracted curing times. Metals with backing coats or etch treatments are ideal, however, certain grades of aluminium and galvanised steel may require a suitable priming system. Details of priming systems are available upon request.

[A bond for life]



Application:

1. The adhesive should be applied as an even coat to one surface with a roller-coater, trowel, scraper or an automatic bead-applicator.
2. The amount of adhesive required will vary according to the porosity and surface texture of the substrate and the method of application but will be between 100-250g/m².
3. Mist the adhesive with water once it has been applied at a coat weight approximately 10% of the applied adhesive coat weight.
4. Assemble the panel and place under pressure within the open time (see Open Times and Press times as a function of Temperature chart). Pressure is usually applied using a hydraulic press, vacuum table or bag press. The pressure required will depend on the nature of the substrates, but it is usually in the range of 10-14 psi (0.7 - 0.9 kg./sq.cm).
5. Maintain pressure until the adhesive is sufficiently cured to permit handling of the bonded item.
6. Full cure of the adhesive will not be achieved for 24 hours. Keep handling to a minimum during this time.

Packaging

D2655 is supplied in 1000 litre IBC, smaller packaging units are also available.

Storage

D2655 should be stored in its original, unopened containers, in dry conditions at a temperature between 10°C and 35°C. Storage outside of these conditions will reduce the product's shelf life.

D2655 has a shelf life of 6 months from point of manufacture.

Health and Safety

D2655 contains a non-volatile isocyanate, when used in the European Union from 24 August 2023 adequate training is required before industrial or professional use. Before use, ensure that you have read the Safety Data Sheet for this product.

- Ensure non-porous gloves and eye protection is worn when handling.
- Avoid prolonged contact with skin.
- In cases of contact with eyes, flush out with excess water and seek medical attention.

Additional Notes

This information is for general guidance only and may contain inappropriate information under particular conditions of use. All recommendations and suggestions are therefore made without guarantee. Samples will be provided on request to enable customers to satisfy themselves as to the suitability of the product for any specific purpose and to assess the product under their own working conditions.

Every care has been taken to ensure that the information provided in the literature is correct and up to date. However, it is not intended to form any part of a contract or provide a guarantee. Purchasers/intending purchasers should contact Leeson Polyurethanes to check whether there have been any changes to the information since publication of the literature. Please ensure you have read the hazard labels and material safety data sheet before using this product.

Edition: 05/01/2022

Replaces edition dated: 17/11/2021

{ A bond for life }