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Everad[®] HCM 5550

Reactive crosslinkable powder

Description

Form of supply:

Powder: 30 kg drum.
Everad[®]HCM 5550-AN:
0–500 µm.
Everad[®]HCM 5550-D:
< 200 µm.

Colour:

White – yellowish.

Polymer:

Polyurethane, polyester based.
Everad[®]HCM 5550 is a two component, heat-reactive, cross-linkable, one phase polyurethane adhesive. This special adhesive system offers the possibility for pre-applied applications to a variety of substrates. Thereafter, pre-applied parts can stored for up to 9 months before further processing. The commencement of the crosslinking reaction only occurs after thermal activation. For an optimal bond, it is recommended that the activation temperature utilised lies within the specified temperature range (see application details).
Everad[®]HCM 5550 is suited for direct lamination. This product already contains all the necessary constituents and therefore no further reaction partner, including moisture, is needed.

Application

Vehicle interiors, for example pillars, head liners, rear seat back trims, arm rests, seats and door panels.
Further Applications: Aluminium, wood or plastic sandwich composites. The bonding of polyolefins such as polyethylene and polypropylene requires suitable surface pre-treatment (Corona, plasma, fluorination or primer).
Before using, ensure through testing that the product complies with the expected use.

Typical values

Thermal resistance:

> 120 °C (Everad method: A 10.4.203; cotton/cotton; 25 x 100 mm; 20g; 6 h).

Fogging (According to DIN 75201-B, gravimetric): < 0.05 %.

VOC (gaseous, Fresenius PB VWT 709): 7 ppm.

FOG (condensable, Fresenius PB VWT 709): 16 ppm.

Processing

5.1 Pre-application:

Pre-application: max. 65 °C.

Color of adhesive remains white – yellowish.

5.2 Heat activation:

Preferred activation temperature: 120 - 140 °C.

color of crosslinked adhesive is opaque to translucent.

Preferred application of Everad[®]HCM 5550 is via the powder (by scattering).

Everad[®]HCM 5550 is shear and temperature sensitive, therefore, coating and application parameters must be carefully considered and controlled. During coating, this product may not be exposed to temperatures exceeding 65 °C. The end product characteristics are dependent on the temperature and the time used during the activation. The final bond strength is achieved after approx. 24 hours.

Caution

It should be noted that the presence of additives in the materials to be bonded, such as 2-ethylhexanoic acid in PU-based systems, can lead to a reduction in the adhesion properties of HCM 5550. To obtain an optimal performance of HCM 5550, it is recommended to ensure the compatibility of HCM 5550 with the selected PU-based materials.

If adhesive systems based on different raw materials have to be used on the identical equipment, thorough cleaning is essential. All technical properties on this data sheet apply for the pure product (100%). Blending of Everad[®]HCM 5550 with other adhesives and/or additives strongly affects this product, its processing, its behavior and ultimately its technical performance.

We will not be held responsible for resulting consequential damages.

Working Safety

To avoid a health risk during application and activation, appropriate ventilation system must be used.

Please follow instructions on the safety data sheet.

Storage

In well-sealed packaging at room temperature, protected from direct sunlight. A temperatures above 35 °C is not recommended due to the risk of blocking. This product has a self-life of up to 9 months after production.

Guarantee

We guarantee the consistency and faultless quality of this product, manufactured in accordance with ISO quality standards, which has been developed on the basis of our long-standing experience with the recommended applications under the specified conditions. Material, processing, and application conditions may significantly influence product properties. Pre-application tests by the user are therefore essential. For non-specified applications or deviations in application conditions, we recommend that our technical support service be consulted first. Our general sales and delivery terms and conditions shall apply.