HHD 5518BK
SOLVENT FREE POLYURETHANE ADHESIVE

PRODUCT DESCRIPTION
HHD 5518BK is a one-component, solvent-free, moisture curing polyurethane adhesive. Once it has been dispensed, the adhesive will react with ambient moisture or water content of the substrates to yield a cross-linked thermoset adhesive. HHD 5518BK contains a fluorescent agent allowing for UV inspection.

KEY FEATURES
→ Excellent adhesion to a variety of substrates including glass and metal
→ High initial strength
→ Long open time
→ Good aging resistance
→ Precision dispensing and good stability

METHOD OF USE
HHD 5518BK can be applied through a usual syringe type melting equipment. The weight of coating can vary according to the substrates and applications.

APPLICATIONS
HHD 5518BK has been specifically designed for bonding structure parts.

STORAGE
HHD 5518BK should be stored in a dry place at a temperature ranging between 15°C and 25°C. It should be processed immediately after the container has been opened.

HEALTH/SAFETY
Read Material Safety Data Sheet before using and handling this product. MSDS is available upon request.

TECHNICAL DATA

<table>
<thead>
<tr>
<th>CHARACTERISTIC</th>
<th>VALUE</th>
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</thead>
<tbody>
<tr>
<td>Appearance (solid)</td>
<td>Black</td>
</tr>
<tr>
<td>Brookfield Viscosity thermoset @ 110°C</td>
<td>6,500~8,500<a href="27#">mPa.s</a></td>
</tr>
<tr>
<td>Open time*</td>
<td>2~4[min]</td>
</tr>
<tr>
<td>Density</td>
<td>1.0~1.1[g/cm³]</td>
</tr>
<tr>
<td>Tensile Strength**</td>
<td>&gt;10[MPa]</td>
</tr>
<tr>
<td>Elongation at break**</td>
<td>&gt;800[%]</td>
</tr>
<tr>
<td>Application Temperature</td>
<td>100~120[°C]</td>
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*Open time is an application factor that depends on the environment temperature, substrates and application process.
**Cured for 8 days, curing conditions are 20°C-25°C, R.H.60%-70%

CURING TIME
The cure rate depends on the substrate type, moisture permeability and ambient conditions. HHD 5518BK exhibits high management strength instantly after being joined. However, optimum properties can be attained after one to five days at room temperature.

PACKAGING
30mL – White PP plastic syringes

CLEANING
Remove uncured waxy material by scraping with a putty knife or similar tool. For cured material, remove by cutting or sanding. Do not use any heat or flame fire to remove adhesive.

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