

## AQUENCE FD 150/6

Known as Dorus FD 150/6 LS  
March 2013

### PRODUCT DESCRIPTION

AQUENCE FD 150/6 provides the following product characteristics:

Technology	PUR
Product Type	1C PUR Dispersion
Application	3D Application
Appearance	liquid transparent after drying

### Application Areas

- Thermoforming presses (with and without membrane)

### Product Properties

- Free of solvent
- Clean spraying
- High green tack
- Highest heat and moisture resistance
- Sealable at lowest temperature

### Technical Data

#### AQUENCE FD 150/6:

pH value (20 °C) ISO 976	7 to 10
Viscosity, Brookfield - RVT, 3/20/20, mPa.s ISO 2555	2,000 to 3,500

### DIRECTIONS OF USE

#### Preliminary Statement

Prior to application it is necessary to read the **Material Safety Data Sheet** for information about precautionary measures and safety recommendations. Also, for chemical products exempt from compulsory labeling, the relevant precautions should always be observed. Please also refer to the local safety instructions and contact Henkel for analytical support.

#### Instructions for Use

In general, AQUENCE FD 150/6 is a one-component glue system - without additional cross-linker.

The working temperature of the workpiece and glue should be over +18°C to achieve optimal bonding results. Lower working temperature results in higher viscosity of the glue.

The glue mix is sprayed with an appropriate spraying gun (nozzle size: 1,4 to 2 mm). As a rule, it is sufficient to apply one coat to the flat surface. Open pore inner and outer radii, however, need to be coated a second time after a brief drying interval. The pre-glued pieces should be sealed within 2 days to achieve optimum bond.

Drying time, minutes depending on temperature, humidity and quantity applied	≥30
Activation temperature in the glue line, °C at the edges	≥55
Curing time, hours complete curing after 7 days	24

All parts which come into contact with the glue must be made either of stainless steel (V2A/V4A) or plastic.

#### Cleaning

Equipment used to apply the glue may be cleaned easily using cold or luke-warm water before the adhesive has dried hard. Hard dried glue remnants have to be removed mechanically.

#### STORAGE

The glue should be transported and stored in the tightly closed original container at temperatures above + 10 °C and below max. + 30 °C.

Cooling below +10 °C can lead to coagulation.  
Storage life up to 6 months.

**Classification:**

- Please refer to the corresponding **safety data sheets** for details on:  
**Hazardous Information**  
**Transport Regulations**  
**Safety Regulations**

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## Reference 0.0

Henkel AG & Co. KGaA  
73438 Bopfinger, Germany  
Phone: +49-7362-81-0

Henkel Corporation  
Bridgewater, NJ 08807, USA  
Phone: +1-908-685-7000

Henkel (China) Co.Ltd.  
201203 Shanghai, China  
Phone: +86-21-2891-8000