



2-PART ADHESIVE DATA SHEET

APRIL 2023

AM-CLAD 2-PART ADHESIVE DATA SHEET



All information provided is for guidance only and AM-Clad Ltd cannot be held responsible for any faults arising from incorrect interpretation or application of the guidance set out in this document.

Recommendations are given in good faith based on our current experience and knowledge of the products when properly stored, handled and applied under normal conditions in accordance with our instructions.

The user must test the product(s) for suitability for the intended application before proceeding and follow the advice in the AM-Clad Installation Guide. Factors outside of our control relating to materials, substrates, storage, and handling conditions and site conditions mean that we assume no legal liability for the advice given.

AM-CLAD 2-PART ADHESIVE

**PC 6136 BASE / PC 6136 ACTIVATOR POLYURETHANE
2-PART ADHESIVE RESIN SYSTEM**

DESCRIPTION

PC 6136 Base / PC 6136 Activator is a two-part polyurethane adhesive and can be described as a non VOC regarding to European directive (1999/13/EC) and American legislation (CARB/ EPA 40FR 59.203(f)1).

It is suitable for adhering of all types of substrate including PVC to walls and floors. The product is supplied in the correct constituents for mixing. Both parts are supplied within a plastic bucket. Processing and curing times are dependent on working temperatures.

PROCESSING METHODS

AM-Clad 2-Part Adhesive is supplied in a ready to mix format.

Packaging

Standard tub size 6.5kg.

Component A is packed directly into a plastic bucket with a plastic sheet placed on the component A surface.

Component B is supplied in a hermetically sealed aluminium pouch placed in the same container on the plastic sheet.

AM-CLAD 2-PART ADHESIVE DATA SHEET



Mixing Instructions

Stir Component A thoroughly. Transfer component B into the plastic bucket holding component A and mix thoroughly until a uniform consistency is obtained throughout.

A drill with a paddle attachment can be used to ensure complete mixing but users must ensure slow and steady speed setting. Also ensure use of a flat bladed implement to scrape the container sides and base ensuring any splashed material is fully incorporated. Mixing should take at least 3 minutes before use.

The mixed adhesive should be applied to the PVC sheet by notched trowel ensuring full and consistent sheet coverage.

The recommended working application temperatures are; Material: 15°C. Environment: 10°C.

Use of the adhesive below working temperatures will result in much higher viscosity during application and increased mixing times and is not recommended unless strictly controlled.

PROPERTIES

Cures at room temperature, high bond strength, easy to trowel and work, good moisture and chemical resistance, excellent impact resistance, good adhesion, inert following cure (based on uniform mix).

CURE TIMES

100 Grams @ 25°C forms a gel state in 30-40 minutes, dependent on ambient temperatures.

Tack free time is approximately 4-6 hours dependent on ambient temperatures. Full cure is 24 hours.

COVERAGE

One 6.5kg tub will cover one AM-Clad PVC wall cladding sheet.

SHELF LIFE

6 months from date of manufacture.

AM-CLAD 2-PART ADHESIVE DATA SHEET



TYPICAL PROPERTIES @ 25°C

	PC 6136 BASE	PC 6136 ACTIVATOR **
	Part B	Part A
Appearance	Thick Buff Paste	Brown Liquid
Viscosity (Poise)	3,000.00 - 3,850.00	2.00 - 5.00
Specific Gravity Density (g/ml)	1.70 - 1.73	1.21 - 1.23
Gel Time (min)[100g mass @ 25C]	85.00 : 105.00	
Mix Ratio (Part B to A*)	11.99 : 1 parts by weight	
Shelf Life (months) in original container and @ recommended storage conditions	6	6

*Recommended Part A; **Requested Part A

CURED PROPERTIES AFTER 24 HOURS

The two-component thermoset, polyurethane, resin system is cured through chemical reaction by the correct mixing and application of the two components. Thermoset resins (also called thermosetting polymers) once cured cannot go back to its constituent parts or be melted. The name polyurethane refers to the chemical linkage of the polymer structure.

STORAGE REQUIREMENTS

Store in the original sealed container in a dry environment. In case of the base component it is advised that containers are rotated on a regular basis; please refer to the housekeeping guide for more detailed information and refer to product labels. Recommended storage conditions are between 15-25°C.

AM-CLAD 2-PART ADHESIVE DATA SHEET



AVOID MOISTURE

Water reacts with the Activator (ISO) component and generates carbon dioxide gas which can cause problems in application. Both components actively attract moisture in the atmosphere and will also react with moisture in damp or porous media - such as wood. As soon as a container is opened material will be exposed to moisture and it is therefore recommended to use a container within a few days of opening, not to leave the container open for longer than is necessary and promote the use of either desiccants or nitrogen blankets if material is to be left for longer period of time, even in a sealed container that has had access to the atmosphere.

PRE-MIXING

Before mixing the two components it is very important to make sure the BASE (POLYOL) component is homogenous. The BASE component is often a mixture of a number of ingredients and the mixture can separate over time in a similar fashion to the way a can of paint settles. It is therefore very important to carefully stir and rehomogenise the material in the container before processing. The activator component is usually a mixture of compatible liquids which does not require rehomogenising before use.

MIXING

Polyurethane systems are affected by both temperature and mass. The greater the mass mixed or the higher the temperature the faster the reaction will occur. In order for the reaction to occur properly the correct proportion or ratio of part B, must be reacted with part A.

This mix ratio is critical in producing the correct cured product.

A mix ratio tolerance of +2% is generally acceptable. It is important to ensure both components are they are mixed together thoroughly.

DISCLAIMER

All performance data and advice given is based on typical laboratory test results and live site applications in normal conditions. The application of AM-Clad 2-Part Adhesive is the responsibility of the user and the product should be tested in the prevailing site conditions before full application. AM-Clad Ltd assumes no legal liability for the advice given or the technical performance of the product.



FOR MORE INFORMATION

CALL +44 1274 020 331

WHATSAPP +44 789 187 9050

EMAIL INFO@AM-CLAD.COM

AM-CLAD.COM

AM-CLAD LTD, 10-14 WARD STREET, BRADFORD,
WEST YORKSHIRE, UNITED KINGDOM, BD7 3PR

© AM-CLAD APRIL 2023