



PA550 PVC MEMBRANE PRESS ADHESIVE

1 – DESCRIPTION

Akfix PA 550 is new generation adhesive for fixing PVC, PP, PET, ABS onto especially MDF by the vacuum or membrane press process for the manufacture of high gloss furniture in kitchen, bathroom or wardrobe shutters and doors. Membrane Press Adhesives are can be used together with Akfix hardeners creating a cross linked film with high adhesion properties and very good heat and water resistance.

2 – PROPERTIES

- Easy to apply, has a low viscosity.
- Quick drying.
- Water resistant
- Synthetic and natural materials, excellent bonding.
- Low and high temperatures do not lose strength.
- Moisture and chemical resistant.
- Heat-sensitive film with high adhesion for the low activation temperature.
- Not harm the environment and human health.

3 - APPLICATIONS

- Permanent adhesion for durable fixation.
- Excellent heat resistance to prevent delaminating in hot conditions
- Outstanding bonding properties on most synthetic and natural materials
- Enabling you to get perfect and smooth surface for high gloss finishes
- High initial bond strength and low activation temperature for heat sensitive films

4 - INSTRUCTIONS

- Mix the PA 550 and Akfix Hardener properly at least 3 min with a ratio of 100/5 (w/w) if a more heat resistant bond is required.
- Polyurethane dispersions are sprayed onto the work piece. For high porous surfaces, the adhesive is applied twice in the edge and routed areas.
- The pieces can be placed into the membrane or vacuum press after approx. 20 to 60 mins drying time (Depends on air temperature).
- The adhesive is being reactivated with the pressure and the temperature and the foil is being laminated onto the work piece. The veneers are slightly dampened to avoid veneer cracking or breakages.
- After the vacuum or membrane Press process, excess foil should be cut manually or automatically after the bond.
- Final bond strength is obtained after 1-3 days.
- Partially dried adhesive may be removed with warm water or ethanol. Removal of dried/cured adhesive requires some industrial solvent.



5- PACKAGING

Product	Volume	Package
PA550	20kg	drums

6- STORAGE AND SHELF LIFE

When stored in its sealed original containers at 23°C, Membrane press adhesive will remain stable for 6 months. Temperatures higher than 30°C should be avoided. The product is sensitive to frost and must not be stored at temperatures below 5°C.

7- RESTRICTIONS

- Storage above +35 °C and below +5 °C shortens shelf life.
- Hot process care must be taken to avoid injuries.
- Pressing should be carried out within 24 hours of spraying the adhesive.
- Surfaces must be free of dust, dirt and grease,
- Surfaces must be smooth as much as possible to prevent orange peel appearance. If the surface is not perfectly smooth, grinding is required for high smooth surfaces
- Fresh adhesive can be cleaned by Akfix Cleaner. Cured adhesive can be cleaned barely mechanically.
- Caution! Do not freeze. Frozen Membrane Press Adhesive is irreversibly damaged.

8- TECHNICAL PROPERTIES

Basis	: Polyurethane dispersion	
Color	: White	
Non-volatile matter	: 39 - 41	(DIN EN ISO 3251)
Activation Temperature	: 55-60 °C	
Density	: 1.10 g/ml ± 0.05	(ASTM D1875)
Viscosity	: 600-1500 cp (23 °C and 50% R.H.)	(DIN 53019)
Ph	: 6.0-9.0	
Water resistant	: Excellent	