

# INSTRUCTIONS FOR USE

## HE 1908 ADHESIVE FOR POLYCARBONATE

HE 1908 is a state of the art Polyurethane adhesive, specifically designed for bonding Polycarbonate to Polycarbonate as well as most of other thermoplastics, glass and metals. It requires either mixing equipment, which has to be programmed to the above mixing ratio, or, if mixed by hands, needs to be weighed carefully.

### INSTRUCTIONS FOR USE

MIXING RATIO: 100 A / 85 B BY WEIGHT 100 A / 91 B BY VOLUME
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#### 1. SURFACE PREPARATION

Wipe surface with a clean soft non-abrasive cloth saturated with isopropyl alcohol and allow to dry.

#### 2. INSPECTION OF COMPONENTS

Inspect material to make sure part A is water clear, not lumpy and/or hard and waxy. If part A is hard or waxy, put the can on a hotplate (max. temperature 65 degrees C), until material reliquefies. If heating is required, allow material to cool down to room temperature before starting the mixing procedure.

#### 3. MIXING INSTRUCTION

Please note that work life of adhesive is approximately 15 minutes. Carefully weigh 100 parts A and 85 parts B (or, in case of volumetric dosage: 100 A and 91 B) and poor these into mixing container. In case mixing equipment is used, program dosage accordingly. Now add 5 drops of HE-4 anti foam (supplied with set). At this point start mixing the adhesive with the same stirring stick for 2 or 3 minutes. Make sure the stick scrapes the walls of the can to insure thorough mix. Gentle mixing of adhesive will prevent excessive air inducement, which may result from whipping or violently mixing the two parts. You can now apply the adhesive as is, unless you prefer it bubble free. If so, place it under hard vacuum until the majority of air has been removed, and then apply.

#### CURE TIME

- Tack fee time : 8 hours at room temperature.
- Curing time : 4 days at room temperature.
- Accelerated cure : 4 hours at 62 degrees C (oven or infra-red light).

#### BONDING POLYCARBONATE TO (STAINLESS)STEEL AND ALUMINUM

Prior to starting described bonding procedure, any (stainless)steel or aluminum to be bonded to Polycarbonate needs to be pre-treated with a primer.

Prescribed primer : Devcon, Metal Primer for Flexance (Type FL 10)

Supplier in the U.K.: Devcon, Brunel Close, Park Farm, Wellingborough, Northants, NN8 3QX.  
Phone: 0933-675299


#### BONDING POLYCARBONATE TO GLASS

Glass needs to be pre-treated with AP 134 primer.

Supplier in the U.K.: Union Carbide U.K. Ltd., 95 High Street, Rickmansworth, Herts, WD3 1RB.  
Phone: 0923-720.366/720.166

#### HEALTH PRECAUTIONS

May cause skin and eye irritation. Avoid prolonged contact with skin. In case of contact with skin, wash with soap and water. For eyes immediately flush with plenty of water. If irritation persists contact physician. As a precaution use eye protection and adequate ventilation.



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