



# DUNAPOL® AD 3206 V3

Rev. N° 7 - Date 04/30/2019

## Description

One-component structural polyurethane adhesive	
Expansion	Medium
Hardening at room temperature	Medium
Adhesion	Very good
Water resistance	Very good (Class D4 - CATAS RP164397/1)
Resistance to high temperature	WATT 91 (CATAS RP 164397/2)
Resistance to mechanical stress	Good
Chemical resistance to solvents	Fair
Chemical resistance to acids and alkalis	Good
Viscosity	Medium
Not filled	
Tenacious	
Semirigid	

## Suggested Materials

Metals  
 Expanded materials (polyurethane, polystyrene, phenolic etc.)  
 Mineral wools  
 Fiberglass laminates  
 Wood  
 Concrete  
 Ceramics

## Suggested Applications

Sandwich panels production/assembling

## Characteristics

Colour			Light yellow liquid
Density (77°F, 25°C)	ASTM D891	lb/ft <sup>3</sup> (g/ml)	66.8-69.3 (1,07-1,11)
Viscosity (77°F, 25°C)	ASTM D2196	P (mPa s)	35-40 (3500-4000)
Minimum application temperature		°F (°C)	50 (+10)
Open time (77°F, 25°C)	film	h min' sec"	15'-18'
Gel time (77°F, 25°C)	film	h min' sec"	35'-40'
Press time (77°F, 25°C)		h min' sec"	1h-1h30'
Handling time (77°F, 25°C)		h min' sec"	2h
Complete Hardening		days	3-4
Coverage rate		lb/ft <sup>2</sup> (g/m <sup>2</sup> )	0.030-0.061 (100-300)
Suggested thickness		inches (mm)	0.004-0.011 (0,1-0,3)
Press pressure (77°F, 25°C)		psi (kg/cm <sup>2</sup> )	14-71 (1-5)
Non volatiles		%	>99,0%
Open time (with 15-20% water spray, 77°F, 25°C)		h min' sec"	6'-7'
Gel time (with 15-20% water spray, 77°F, 25°C)		h min' sec"	11'-14'
Durability	EN 204	Class	D4
Durability	EN 12765	Class	C4

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Tensile strength at 80°C	EN 14257 (WATT 91)	N/mm <sup>2</sup>	8,8
Storage temperature		°F (°C)	50-95 (10-35)
Shelf Life		Months	12

### Application

It is possible to distribute by hand with a spatula, trowel, notched trowel, brush, roller, trowel or spray.

It is possible to distribute by dispensing machines.

Do not thin with solvents or other.

Areas must first be degreased, chemically and/or mechanically treated.

Hardening occurs due to humidity in the air or water nebulization. Water nebulization is necessary when the surfaces to be glued are non porous. With porous surfaces it is possible to spray water in order to improve and accelerate the reaction. Attention: water nebulization reduces the indicated reaction times considerably.

Surfaces can be damp.

Strong pressure is not required, just a close contact until hardening occurs.

Pigment only with solvent-free colored pastes.

### Hardening

Even if the object can be manipulated after the handling time, the best properties are reached only after complete hardening.

The system hardens even under conditions of high humidity as long as the surface temperature is not lower than the minimum one of application.

### Storage

Lifetime of products is referred to materials stored in sealed containers in dry rooms, at recommended temperatures and protected from direct sunlight.

The expiry date is printed on the packaging.

The moisture and/or storage in humid conditions may affect the characteristics of the components.

Wherever possible apply products in ventilated areas, wearing gloves, protective eyewear, barrier creams and suitable protective clothes.

Avoid contact with unhardened materials.

In case of accidental contact with the skin, wash with lukewarm water and soap for at least 10 minutes. Do not wash affected areas with solvents as this may increase contamination.

### Remarks

For usage information, personal protective equipment, transport, storage and disposal of waste it is essential to refer to

the Material Safety Data Sheets.

The information and data contained on this technical sheet refers only to samples tested in our laboratory and indicative

of the characteristics obtainable under controlled conditions. DUNA-USA Inc. does not accept responsibility for incorrect use of its products and cannot ensure the correct methods of application have been followed.

This Technical Data Sheet cancels and replaces any other previous issue.

The reported data outline typical characteristics and do not constitute specifications of sale.

DUNA-USA Inc. reserves the right to change the data in this information sheet without notice.

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