



H.B. Fuller



ROYAL
ADHESIVES & SEALANTS



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Hydra FAST-EN DC12623

TECHNICAL SALES BULLETIN

VOC

9.4 gms./l

DESCRIPTION

Hydra FAST-EN™ DC-12623 is a one part sprayable contact adhesive designed to bond various porous surfaces, especially open cell polyurethane foams. The system is low-cost, highly stable, user-friendly and allows for quick mating of surfaces after adhesive application.

Hydra FAST-EN™ DC-12623 provides good bonds in lay-flat scenarios and can be used with higher strength urethane foams. Sprayed materials can be wet mated (lay-flat) or dry mated (stress scenarios). Final bonds are soft and supple. Other applications where the use of solvent based, flammable and non-flammable systems are a concern for either health or environmental reasons may also be suitable candidates for the use of this product.

PRODUCT FEATURES

- **Water-based / High Solids** - Easy clean up.
- **Soft and supple bondlines.**
- **One-part** -- Easy to use, no activator required.
- **Fast tack** -- Parts can be wet mated or allowed to dry and mated in high stress geometries.
- **Color tint available** -- Aids in noting coverage and uniformity: standard color is white
- **Equipment friendly** -- Uses standard one-part spray guns.
- **Shear stability** -- Adhesive is not affected by normal shear forces generated by mechanical pumps or mixers.
- **Temperature range** -- The dried adhesive has a use range of -50 to 200 °F.
- **Shelf life** -- 6 months when stored between 40°F and 80°F in unopened containers.

TYPICAL PROPERTIES

(specification values available upon request)

Base	Natural rubber
Color	White when wet (unless tinted)
Solvent	Water
Solids	62%
Viscosity	200 cps (#2 @ 10 rpm)
Weight/Gallon	7.84 lbs.
Specific Gravity	0.942
pH	10.0

BONDING CAPABILITIES

Hydra FAST-EN™ DC-12623 will allow sprayed parts to be bonded within minutes after application of the adhesive to both mating surfaces.

Parts can be handled immediately after mating. Foam tears can result within hours, but will depend upon the substrates bonded and ambient conditions. Higher temperatures, low humidity and good air circulation will accelerate bond development. Maximum strength is developed over 24 hours. It is within the 24-hour period that the residual water is dissipated.

If repositioning is desired because of misalignment, the system accommodates this characteristic. Parts can be realigned prior to pressure mating of surfaces.

COVERAGE

Hydra FAST-EN™ DC-12623 can be color tinted to aid in the determination by the operator of the correct amount to be applied. Custom colors are available at no extra charge. The coverage rate needed to achieve the desired level of adhesion will need to be established for each particular application. This rate will depend on the substrate's surface texture and bonding properties. In the case of urethane open cell foam, average laydown to achieve immediate hold will depend upon foam properties such as density and compression.

The approximate single surface coverage of one gallon of adhesive when applied to polyurethane foam is:

LAYDOWN	GRAMS WET PER SQ.FT.	APPRON. SQ FT. COVERAGE PER GALLON
High	10.4	390
Normal	8.3	490
Low	6.2	650

Once the coverage rates have been determined, color standards can be established and samples supplied to operators, which indicate the desired shade of color (i.e., blue) to be applied to the part. The color tint also aids

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the operator in determining if even coverage is being achieved.

EQUIPMENT CONSIDERATIONS

Hydra FAST-EN™ DC-12623 is compatible with many conventional and HVLP one-part spray gun systems. Laydowns and spray patterns are adjusted by fluid nozzle and needle selections and air pressure settings to achieve the effect desired. Atomizing air pressure should be adjusted to high settings (80-90 psi) for best performance. The air supply used must be consistent (no wide fluctuation in line pressures) and be oil free to achieve the best results.

Contact your Royal Adhesives sales representative for spray gun and total system set up recommendations.

EASY CLEAN-UP

It is not necessary to clean the gun often. If the gun is to be used again within 16 to 24 hours, the gun can be left as is (with system pressurized) without any problems. It is recommended that the gun be cleaned every 5 days, or if it is not going to be used within 48 hours (i.e. over weekend).

Clean up is easily accomplished using commercially available liquid detergent in a water solution. Tap water alone is not recommended for clean up.

PRECAUTIONARY DATA

- This product is nonflammable when wet
- For professional or industrial use only
- Use with adequate ventilation
- Read the container label and the Safety Data Sheet carefully before use
- Keep away from children
- Keep container closed when not in use
- Keep from freezing

DISPOSAL INFORMATION

Do not reuse container or remove label. Safely dispose of container and contents in accordance with applicable Federal, State and Local regulations.