

# TECHNICAL DATA SHEET

## DOLPHIN HVAC CONTACT ADHESIVE

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## PRODUCT DESCRIPTION

**Dolphin HVAC Contact Adhesive** forms an instant bond on contact and has a fast-drying formula. It is ideal for bonding: PIR, Phenolic duct, Glass wool, wood, MDF, lamination, PVC, leather, rubber.

## TECHNICAL PROPERTIES



Properties	Test Method	Specifications
Color	Lab Test	Visually Dark Brown
Appearance	Lab Test	Visually Liquid
Specific Gravity	ASTM D 1475	0.92 ± 0.03 g/cm <sup>3</sup>
Viscosity @ 25°C, S4, rpm-50	ASTM D 2196	800±200 cPs
Solid Content	ASTM D 1644	46 ± 2 %
Flash – off Time (After Adhesive application in PIR, phenolic duct sheet) @28 – 35°C	Lab Test	20 – 45 Mins
PIR, Phenolic duct sheet bonding (after 24 hours of application)	Lab Test	Substrate Failure
Service Temp.	Lab Test	-4 to 80 °C
Full Cure Time	Lab Test	24 Hours
Shelf Life	Lab Test	12 Months

Note:

\* Curing time may vary depending on climatic condition during application.

(Information on this data sheet is subject to change without prior notice and should not be used for writing specifications)

## TYPICAL USES

- Multipurpose adhesive that bonds instantly on contact
- Bond most types of HVAC materials, and will even fix non-porous surfaces together e.g., wide range of DIY tasks repairs
- Ideal for bonding: wood, MDF, laminate, PVC, leather, rubber

## KEY FEATURES

- Chemical Resistance
- Bonds multiple HVAC substrates
- Quick Drying Formula
- High strength

<b>Curing mechanism</b>	<b>Dolphin HVAC Contact Adhesive</b> cures by allowing solvent to evaporate in normal atmospheric conditions.
<b>Packaging</b>	<b>Dolphin HVAC Contact Adhesive</b> is available in 250 ml,650ml,3 Liter can, and 15 Liter pails. Based on the customer requirement.
<b>Precautions</b>	All surfaces must be clean, dry, and free from dust, paint, loose material, oil, grease, sealers, curing compounds, waxes, and all contaminations.



WORLD-CLASS  
CHEMICALS

<b>Application Instruction</b>	Application surface should be dry and dust, rust, and grease-free. <b>Stir well before use.</b> Apply a uniform coat on both surfaces and wait for 20 - 45 minutes for adhesive to become tacky. Stick both surfaces applying pressure with an appropriate pressing tool.
<b>Colors</b>	<b>Dolphin HVAC Contact Adhesive</b> is available in Dark Brown color.
<b>Storage and shelf life</b>	Should be stored tightly closed and away from direct sunlight in a cool, well-ventilated area between 5°C to 38°C. Close container tightly when not in use. Store away from ignition sources. Stirring required before use and if the product becomes very cold. <b>Dolphin HVAC Contact Adhesive</b> has a shelf life of 12 months from the date of manufacturing.
<b>Application limitations</b>	<b>Dolphin HVAC Contact Adhesive</b> is not suitable for use on polystyrene, cellulose paint, vinyl, polythene, and Polypropylenes rayon fabrics. If in doubt, test a small area first.
<b>Shipping limitations</b>	Highly flammable, solvent based adhesive.
<b>Health and safety</b>	The product is flammable. Keep it away from heat, sparks, open flame, and other ignition source as vapors may ignite explosively. Use only in well ventilated areas. The product should not be swallowed or allowed to come in contact skin and eyes. Use of suitable protective gloves and goggles is advisable. If eyes are affected with adhesive, rinse it with excess amount of clean fresh water and seek for medical advice. If swallowed seek medical attention immediately and do not induce vomiting help. Don't smoke or vaping during the adhesive application process.

KEEP OUT OF REACH OF CHILDREN • KEEP CONTAINER TIGHTLY CLOSED • FOR INDUSTRIAL & POFESSIONAL USE

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