



Everything for Inflatables

## PVC Curing Agent Instructions

IBS PVC Curing Agent is a dark brown isocyanate- based hardener for adhesives

### **RECOMMENDED USE**

IBS PVC Curing agent is mainly used to cure polyurethane based adhesives when superior bond strength, heat and fluid resistance is required.

### **BONDING INSTRUCTIONS**

Add IBS PVC Curing Agent to the appropriate adhesive ( taking care to avoid splashing) in the recommended proportions and mix together carefully and thoroughly.

Typical mixing ratio is:

20 parts Parts Glue 1 parts Curing agent (5%)

Apply the mixed adhesive and carry out bonding as appropriate to the particular adhesive and its use, ( See PVC Two Part Glue instructions)

### Pot Life & Curing Time

When using IBS PVC Curing agent with typical solution adhesives the pot life of the mixed adhesive is usually 6 to 8 hours at normal room temperature provided the container is kept closed. This period will be shorter in open container due to solvent evaporation. Also, the pot life decreases with the age of the adhesive

A typical curing time for the mixed and applied adhesive is 24 hours at normal room temperatures but bond strengths continue to increase, reaching a maximum with approximately 7 days. Cure rate may be accelerated by heating.

### **TYPICAL CHARACTERISTICS**

APPEARANCE	Dark coloured liquid
COLOUR	Dark Brown
ODOUR	Chlorinated
Boiling . (°C)	41
VISCOSITY	less than 50cps@ 20c

### **WARNING**

Precautions must be taken to ensure that IBS PVC Curing Agent and the mixed, uncured adhesive are not contaminated with water as this could have a detrimental effect on bond strengths.

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