



# APTEK LABORATORIES, INC.

ISO 9001 / AS9100 Certified

28570 Livingston Avenue, Valencia, CA 91355-4171 • (661) 257-1677 FAX (661) 257-8939

## TECHNICAL DATA & INFORMATION

### APTEK® 2206-A/B

Clear urethane adhesive  
Excellent adhesion to PVC substrates

### PRODUCT DESCRIPTION

**APTEK 2206-A/B** is an unfilled, clear, two component, electrically insulating, urethane adhesive designed specifically for bonding PVC, polycarbonate, and other plastic substrates.  
**APTEK 2206-A/B** is capable of room-temperature or accelerated heat cure.

### FEATURES AND BENEFITS

- \* Non-TDI based for safety
- \* Convenient 1:1 PBW or PBV mix ratio for easy handling
- \* Low viscosity for good substrate wetting
- \* Specialty packaging available in dual-cartridge dispenser kits

### HANDLING INFORMATION

Mix ratio, parts by weight: 100 (2206-A) / 100 (2206-B)

Work life, @25°C, 20 gm mass, minutes: >60

Note: Parts A and B are sensitive to moisture contamination. If material contains gelled portions or is excessively high in viscosity - DO NOT USE. Always blanket partially used containers with dry nitrogen or argon before resealing.

### MIXING

Weigh 100 parts of APTEK 2206 Part A into a clean, dry, glass, metal, or plastic container and then add 100 parts of APTEK 2206 Part B. Machine mix on slow speed or hand stir with glass or metal stirrer until complete and thorough blending is achieved. Care should be taken to avoid any source of moisture contamination or air entrapment during mix. For optimum results, mix materials in an environment below 55% relative humidity, and vacuum mixture at less than 10 mm Hg for 2-5 minutes after "break".

### **- DISCLAIMER NOTICE -**

All statements, technical data, and recommendations expressed herein are based on tests believed to be reliable and accurate. However, APTEK LABORATORIES, INC. gives no warranty, expressed or implied, regarding the accuracy of this information. It is intended that the buyer and user of these products shall determine the suitability of the information provided for his specific application, and is responsible for its selection.

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**CURE SCHEDULE**

5-7 days @ RT  
 or  
 RT gel + 1 hr @ 85°C  
 or  
 2 hr @ 65°C

Note: As typical with urethane systems, a relaxation/stabilization period after cure is required before testing, service, or use.

**TYPICAL PROPERTIES**

(values not to be used for specification purposes)

<b><u>CHARACTERISTICS</u></b>	<b><u>2206-A</u></b>	<b><u>2206-B</u></b>	<b><u>TEST METHOD</u></b>
Color	Clear to pale yellow	Clear to pale yellow	Visual
Specific gravity	1.12	1.13	ASTM D-1475
Viscosity @ 25°C, cps	5000	3500	ASTM D-1824
Flash point, °C	>150	>150	ASTM D-92
Shelf life, months in factory sealed containers stored @ 25°C	6	6	
Cured hardness Shore D	55±5		

**SAFETY AND FIRST AID**

APTEK 2206-A is an unfilled polyol resin that is safe to handle when used properly. It is judged to be low in toxicity and to be rated as a slight skin irritant. Avoid contact with skin and eyes and use in a well ventilated area and avoid breathing vapors. In case of eye contact, flush with fresh clean water for at least 15 minutes; for skin contact, wash thoroughly with soap and water. If swallowed, drink at least one pint of water and call a physician. Refer to Material Safety Data Sheet for more details.

APTEK 2206-B is an organic isocyanate which may cause severe eye and skin irritation with direct contact. Inhalation of vapors may result in breathlessness, severe coughing, chest discomfort, and irritation of mucous membranes. Avoid skin and eye contact, and for eye contact, flush profusely with fresh clean water and contact physician. For skin contact, wash thoroughly with soap and water. If inhaled, move subject to fresh air and provide fresh water to drink. If swallowed, dilute with at least one pint of water and contact physician immediately. Refer to Material Safety Data Sheet for more details.

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