

TECHNICAL DATA SHEET

Version: 4
Date: 27.07.23

Description:	Single-component polyurethane adhesive in water dispersion for cold bonding.
Field of applications:	Ideal for laminating and folding leather, synthetic leather, fabrics, linings, cartons, regenerated materials, leather up to 15% grease. Also suitable for bonding PVC, nylon and properly prepared rubbers.
Note:	ECOSTICK® 1816B is resistant to yellowing. It does not require activation by heat if bonded within 20 minutes after drying. Bonding by heat activation and by addition of catalyst is also possible.
Recommendation for end use:	Apply ECOSTICK® 1816B to both sides. Allow to dry. For cold processing, couple the two parts within 20 minutes after drying and press. For laminating leather with fabrics, moltoprene, foam rubber is possible to apply the adhesive on one side: apply ECOSTICK® 1816B in copious amounts to the leather or to the less absorbent material and couple immediately. At the end of the cold bonding open time (about 30 minutes after application), it is possible to reactivate the adhesive by heat (surface temperature of the adhesive film: 60-65°C). Final bond strength after about 48 hours.
Application:	Spray gun, roller machine, brush
Quantity:	50 -150 g/m ² depending on adsorption properties of the material
Open time:	Cold bonding: up to 20 minutes after drying Heat reactivation bonding: within 48 hours
Working temperature:	Room temperature, not below 16° C.
Hardener:	Harter FI 1002A (3-6%)
Pot life:	4 hours
Dilution:	Demineralized water

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Solid content:	approx. 52%
Density at 20°C:	approx. 1,06 g/cm ³
pH:	6 - 8
Color:	White
Viscosity: Brookfield, S4, 50 rpm, 20°C	850 -1150 mPa*s
Shelf life:	12 months

Other information

Application devices cleaning:	Routine cleaning with water. MEK or commercially available mixtures of cleaning solvents are recommended for dry adhesive removal.
Storage:	Store in the original sealed containers, in a cool and dry place, out of direct sunlight. Recommended storage temperature is 5-30°C. The product is sensitive to freezing and is irreversibly damaged at temperatures below 5°C.
Precautions for handling:	Ensure adequate ventilation during spray application to prevent inhalation of aerosols and dust. Labeling and safety information are available in the current MSDS.

The information presented in this publication is based on Intercom's current knowledge and experience. In view of the many factors that may affect workmanship and application, the recommendations and suggestions given in this sheet do not relieve the user of the responsibility for performing the appropriate tests to determine whether the product is suitable for a specific purpose, nor do they imply any legally binding guarantee of certain properties or suitability for that purpose. It's the responsibility of those to whom Intercom supplies its products to ensure compliance with any proprietary or patent rights and with applicable laws and regulations.