

# VINYCOL 1520

## INDUSTRIAL ASSEMBLY

### ***Polyurethane adhesive for bonding synthetic materials (PU, PVC, Hypalon, Neoprene coated fabrics)***

---

#### **PRODUCT USES**

VINYCOL 1520 is a polyurethane adhesive specifically designed to bond synthetic materials such as PVC, polyurethane. It can be used together with hardeners DESMODUR RFE or RC or FIXDUR 100 to improve performances. It has a high resistance to hydrolysis and very good heat resistance (suitable for assembly of inflatable boats, conveyor belts etc.). Also suitable for bonding Hypalon / Neoprene coated fabrics and for repairs.

---

#### **PRODUCT BENEFITS**

- Good resistance to hydrolysis
- Good heat strength

---

#### **TYPICAL PHYSICAL PROPERTIES**

- Base: polyurethane
- Colour: pale yellow liquid
- Viscosity: approx. 2600 mPa.s
- Dry solids content: approx. 20 %
- Specific gravity: approx. 0,87
- Application temperature: above +20°C
- Relative humidity: below 60%

##### **Values given for bonding PVC fabric to itself**

##### **Peel strength:**

- After 24 hours at ambient conditions: 10 daN/5cm
- After 7 days at ambient conditions: 20 daN/5cm
- After 7 days at +70°C: 10 daN/5cm

**Static heat strength** after 7 days at +20°C (shear test for 15cm<sup>2</sup> pieces at strength of 80 daN: > 90°C).

##### **Resistance to hydrolysis:** 100°C in complete water immersion

- After 24 hours: 100% nominal value
- After 48 hours: 85% nominal value
- After 72 hours: 66% nominal value

---

#### **APPLICATION**

##### **SURFACE TREATMENT**

The surfaces to be bonded must be dry, clean and degreased. Abrade the surface with emery cloth, remove the ensuing dust by wiping with clean cloth moistened with Bostik cleaner.

##### **BONDING PVC AND PU**

Mix the adhesive with DESMODUR RFE or RC or FIXDUR 100, usually 8% in volume is needed, nevertheless according to the desired use and after carrying out prior tests different mixing ratio can be used.

Apply a first even coat of adhesive on both substrates to be bonded using a brush.

Allow the adhesive coats to dry for 10 minutes.

Apply the second coat of adhesive on both substrates; allow them to dry for 15-20 minutes according to ambient conditions.

Join the surfaces using as much pressure as possible or roll over the entire surface.

Maximum open time is 30 minutes.

##### **BONDING HYPALON / NEOPRENE COATED FABRICS**

Chemical treatment: abrade the surface with emery cloth, thoroughly remove dust, use ACTISOL SPW for halogenation (this procedure is used to assure compatibility between Vinycol 1520 and synthetic material). Allow to dry for at least one hour and up to several days (during this time stock in dust-free environment). Then bond the materials according to above-mentioned direction for use.

##### **Cleaning**

Clean splashes with SOLVENT REAC 6 or REAC 13

## SHELF LIFE

Up to 12 months in original closed pails, stored in a ventilated place at +15 to +30°C. Kits of VINYCOL 1520 + FIXDUR 100 can be stored up to 18 months in the same conditions.

## PACKAGING

Code	Packaging	Quantity	Bar Code
504311	10 litre(s) pail		3131368454260
504313	25 litre(s) pail		3131368454802
507390	kit - Vinycol 1520 + Fixdur 100	6	3131368454017
513382	200 litre(s) drum		

### SAFETY

For more details, consult the safety data sheet on [www.quick-fds.com](http://www.quick-fds.com), or ask us a copy by fax.

*Recommendations for implementation are defined through commonly used standards which should imperatively be respected (or followed). However, in case of first use or special characteristics related to the material support, the site or the environment, prior tests are advised (or are not exempted). It is recommended to follow our precautionary measures listed in the specification sheets.*



Bostik SA - 16-32, rue Henri Regnault - 92902 Paris La Défense Cedex - FRANCE  
Tel. +33 (0)1 47 96 94 65, Fax +33 (0)1 47 96 90 76, e-mail: [info.eemea@bostik.com](mailto:info.eemea@bostik.com) - [www.bostik-eemea.com](http://www.bostik-eemea.com)