



**Hysol**<sup>®</sup>

VINYL BONDING ADHESIVES

### Features

These diverse adhesives share some unique features that lend themselves to easy application:

- Rapid air dry allows for high speed production
- Water and salt resistance
- Heat activated bonding
- Low viscosity for easy application
- Bonds flexible and rigid PVC

### Applications

**BI-LAMINATE COEXTRUSION:** Adhesives used to bond PVC to aluminum or stainless steel by a continuous extrusion process.

**INJECTION MOLDING:** Adhesives used to bond PVC to PVC or PVC to aluminum or stainless steel by injecting molten PVC into a mold cavity.

**GLASS ENCAPSULATION:** Adhesives and adhesion promoters used to bond PVC to glass by injecting molten PVC around the glass window.

**COIL COATING/LAMINATION:** Adhesives that can be applied to a variety of metals, which can be subsequently laminated to PVC film.

## VINYL BONDING ADHESIVES

Bi-Laminate Coextrusion, Injection Molding, Glass Encapsulation, Coil Coating/Lamination



**Henkel**

# VINYL BONDING ADHESIVES Bi-Laminate Coextrusion, Injection Molding, Glass Encapsulation, Coil Coating/Lamination

PRODUCT	DESCRIPTION	% TOTAL SOLIDS WEIGHT (VOLUME)	WEIGHT/ VOLUME	VISCOSITY	COLOR	APPLICATION METHOD	T-BEND	MEK RUBS	ACTIVATION TEMPERATURE
<b>BI-LAMINATE COEXTRUSION ADHESIVES</b>									
Plastilock® A1104B™ Adhesive	Clear, high solids solvent adhesive. Bonds PVC to metal (aluminum and stainless steel).	18-20 (12-14)	7.40 lbs./gal. (0.89 kg/L)	17-24 seconds #2 Zahn Cup	Clear	Flow Coat Coil Coating	6T	10	350°F (177°C)
Plastilock® A1617B™ Adhesive	Moderately flexible solvent adhesive. Bonds PVC to metal (aluminum and stainless). Certified to GM9981691.	19-21 (12-14)	7.60 lbs./gal. (0.91 kg/L)	15-20 seconds #2 Zahn Cup	Yellow/ Green	Flow Coat	NA	NA	350°F (177°C)
Plastilock® A1630B™ Adhesive	Moderately flexible solvent adhesive. High solids and black color. Bonds PVC to metal (aluminum and stainless). Certified to GM9981691.	30-32 (21-23)	8.05 lbs./gal. (0.97 kg/L)	22-30 seconds #2 Zahn Cup	Black	Flow Coat Coil Coating	2-3T	10	350°F (177°C)
Plastilock® A1688B™ Adhesive	Solvent-based adhesive. Designed for coil coating application.	32-34 (24-26)	8.72 lbs./gal. (1.05 kg/L)	18-28 seconds #4 Zahn Cup	Black	Coil Coating	2-3T	10	350°F (177°C)
Plastilock® A1689B™ Adhesive	Low solids, solvent adhesive. Bonds PVC to metal (aluminum and stainless steel).	5.5-6.5 (4-6)	7.05 lbs./gal. (0.85 kg/L)	15-22 seconds #2 Zahn Cup	Clear	Flow Coat	NA	NA	350°F (177°C)
Plastilock® A1710B™ Adhesive	Medium solids solvent adhesive. Bonds PVC to metal (aluminum and stainless).	25-28 (17-19)	7.84 lbs./gal. (0.94 kg/L)	18-28 seconds #2 Zahn Cup	Black	Flow Coat	NA	NA	350°F (177°C)
Plastilock® PL1600™ Adhesive	Chromate-free version of Plastilock® A1630B™ Adhesive.	30-32 (22)	8.03 lbs./gal. (0.964 kg/L)	18-28 seconds #2 Zahn Cup	Black	Flow Coat Coil Coating	1 - 3T	3 - 15	350°F (177°C)
Plastilock® PL1601™ Adhesive	Low VOC version of Plastilock® A1689B™ Adhesive.	5.5-6.5 (5.5)	7.51 lbs./gal. (0.901 kg/L)	15-22 seconds #2 Zahn Cup	Clear	Flow Coat	1 - 3T	3 - 15	350°F (177°C)
Plastilock® PL1602™ Adhesive	Chromate-free version of Plastilock® A1617B™ Adhesive. Certified to GM9981691.	19-21 (13)	7.64 lbs./gal. (0.917 kg/L)	15-18 seconds #2 Zahn Cup	Gray	Flow Coat	1 - 3T	3 - 15	350°F (177°C)
<b>INJECTION MOLDING ADHESIVES</b>									
Plastilock® A1404B™ Adhesive	Soft, clear, solvent adhesive. Used to bond PVC to PVC only.	17-20 (11-15)	7.21 lbs./gal. (0.86 kg/L)	1400-2000 cps	Clear	Brush	NA	NA	200°F (93°C)
Plastilock® A1610B™ Adhesive	Soft, clear, solvent adhesive. Used to bond PVC to metal (aluminum and stainless steel).	27-29 (21-23)	7.60 lbs./gal. (0.91 kg/L)	23-28 seconds #2 Zahn Cup	Clear	Brush/Spray	NA	NA	325°F (163°C)
Aqualock® AL5006™ Adhesive	Soft, clear, water-adhesive. Used to bond either PVC to metal or PVC to PVC (aluminum and stainless steel).	37-41 (32-36)	8.40 lbs./gal. (1.0 kg/L)	20-45 seconds #2 Zahn Cup	White/ Clear	Brush/Spray	NA	NA	275°F (135°C)
<b>GLASS ENCAPSULATION ADHESIVES</b>									
Plastilock® A1100B™ Adhesive	Clear, hard, solvent adhesive. Bonds PVC to glass. Utilizes adhesion promoter Plastilock® A1167B™ or Plastilock® A1658B™.	14-16 (9-11)	7.18 lbs./gal. (0.86 kg/L)	10-14 seconds #4 Ford Cup	Clear	Brush/Spray	NA	NA	350°F (177°C)
Plastilock® A1669B™ Adhesive	Clear, soft, solvent adhesive. Bonds PVC to glass. Utilizes adhesion promoter Plastilock® A1167B™ or Plastilock® A1658B™.	18.5-20.5 (12-16)	7.33 lbs./gal. (0.88 kg/L)	15-20 seconds #2 Zahn Cup	Clear	Brush/Spray	NA	NA	325°F (163°C)
Plastilock® A1167B™ Adhesion Promoter	Adhesion promoter for Plastilock® A1100B™ Adhesive or Plastilock® A1669B™ Adhesive.	8-10 (7-9)	7.18 lbs./gal. (0.86 kg/L)	Water thin	Clear	NA	NA	NA	NA
<b>COIL COATING/LAMINATING ADHESIVES</b>									
Plastilock® A1716B™ Adhesive	Black solvent adhesive. Lamination of PVC films to metals.	23-27 (18-22)	7.6 lbs./gal. (0.91 kg/L)	9-20 seconds #4 Zahn Cup	Black	Coil Coating	0-1T	NA	350°F (177°C)



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