



TECHNICAL SHEET

DUDITERM PU 133

A solid hot-melt adhesive based on hygroreactive polyurethane, Duditerm PU 133 has been specifically formulated for pre-finished floors by automatic machines.

CHARACTERISTICS

- Chemical compound	Hygrohardening polyurethane
- Color	Transparent
- RVF mod. Brookfield viscosity at 140°C with Thermosel	10.000 - 16.000 mPa.s
- Weight density	About 1.1 g/cm ³
- Reticulation time	3 - 7 days
- Shelf life at 20°C	6 months

CONDITIONS FOR USE

- Application temperature	140 - 160 °C
- Environment temperature	> 15 °C
- Material moisture	8 - 12 %
- Relative humidity	65 - 75 %
- Speed line	10 - 15 m/min.
- Application quantity	70 - 120 gt/m ²

APPLICATION SYSTEM

- Spreading devices	roller coaters, slot nozzles, guns
- Melters	Tank melters and Drum melters (teflon coated)

CLEANING

To clean slot nozzle, guns and melters we recommend our PULITORE PER PU.

When application devices or melters are in contact with air, cleaning operation should be done daily. In all others cases cleaning can be done periodically.

Cured polyurethane residuals can be removed by using PULITORE PER PU L warmed.

For further information regarding cleaning operation see technical data sheets of the cleaners PULITORE PER PU L.

USEFUL RECOMMENDATIONS

- Polyurethane hot melt adhesives cure with air humidity, bonding substrates moisture and with hydroxide groups included on the bonding substrates. For this reason, polyurethane adhesive produces high heat, water and solvent resistance bonding.
- Polyurethane hot melt adhesives are sold in sealed packagings. DUDITERM PU 133 is delivered in blocks of 18 or 180 kg, wrapped with aluminium foil. Normaly, 18 and 180 kg blocks are packed by mean nitrogen gas head atmosphere.
- DUDITERM PU 133 must be melted in special tanks or melting pots in nitrogen atmosphere or dehumidified air to avoid any contact with the environment humidity.
- The tanks and the parts in contact with the adhesive must be teflon-coated to permit easy detachment of the reticulated product.
- In case of interruptions for a period of time longer than 24 hours, the machine parts in contact with DUDITERM PU 133 must be properly cleaned with special cleaners (PULITORE PU) to avoid any damage from the reticulating product.
- Devices to draw off the vapours must be provided in the area where DUDITERM PU 133 is used to avoid that isocyanate concentration in air exceed the permitted value, see Safety Data Sheet.
- Complete DUDITERM PU 133 crosslinking reaction occurs approx. 3 - 7 days after application (depending to the ambient conditions). Only after this period of time max. adhesive power can be obtained.
- Shelf life of DUDITERM PU 133 when kept in its original sealed packages in cool dry room at a temperature from 15° to 25°C is approx. 6 months.

PACKAGING

- 18 kg cardboard drums
- 180 kg metal drums

The contents of this technical sheet is purely of general nature and is not subject to any guarantee. Therefore, the above recommendations should be adapted to the materials used and to the specific environmental conditions.

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