

DOLPHIN 7401

WB Insulation Adhesive

DESCRIPTION: This latex adhesive was designed to provide a fast grab without the hazards of solvent borne contact cements. Formulated with one of the fastest drying vinyl acetate/acrylic latices, **DOLPHIN 7401** will bond fibers, fabrics, films, and foams to wood, fiberglass, and primed and painted metal surfaces. It is more forgiving than most contact cements because it will allow positioning after the parts are mated. The adhesive is permanently flexible and it is unaffected by water after drying. Its controlled bond strength permits removing and replacing damaged coverings without destroying the base substrate. **DOLPHIN 7401** has found wide use in bus construction; it is used for bonding materials inside the enclosed coach shell where collection of solvent vapors would pose a danger to workers. It is also used in the manufacture of HVAC units to fasten insulation to the insides of the HVAC housings.

APPLICATION: This adhesive can be applied by brush, trowel, or spray equipment. After application to both surfaces to be bonded, allow the water to evaporate from the adhesive (about 5 minutes). Mate together the materials to be bonded, position if necessary, and press or roll the bonded materials together. Tack is immediate; full strength will develop in approximately 24 hours. **DOLPHIN 7401** may be thinned with water; wet adhesive may be removed with water. If adhesive has dried, use toluene to remove. **DOLPHIN 7401** is normally supplied in drums but may be ordered in other container sizes.

PROPERTIES:

Specific Gravity:	1.39 – 1.49
Solids:	63 – 67%
Dry Time @ 68° F; 50% RH	10 minutes set to touch
ASTM D 1640; 4 mils thick	45 minutes through dry

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**THE FOLLOWING TESTS WERE PERFORMED
AFTER DRYING 21 DAYS @ 68° F (20° C); 50% RH**

Adhesion, Peel: ASTM D 903; 180	6 lbs/ in from plywood
Low Temperature Flexibility: ASTM C 711; .125" mandrel @ -20° F (-29° C)	No cracking No loss of adhesion
Effects of Heat Aging: ASTM C 792; 336 hours @ 158° F (70° C)	Flexibility maintained No loss of adhesion
Humidity Resistance: ASTM D 2247; 336 hours @ 100° F (38° C); 100% RH	Adhesion maintained
Flammability: MVSS 320	Pass

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