



# Polyurethane Laminating Adhesive

989

## Product Data Sheet

### Product Description

Vibra-TITE 989 is a 1-component liquid adhesive based on polyurethane. It is a moisture-curing, medium open time structural assembly system. Unlike contact adhesives, which require the coating of both substrate surfaces, 989 requires only a single side. There is no need for additional handling and expensive drying ovens to flash off solvents before engaging the bond.

989 is designed to bond well to wood, lauan, fiberboard (MDF), fiberglass reinforced plastic (FRP), expanded polystyrene (EPS), polyurethane foam, particleboard, high pressure laminate (HPL), plywood, masonry, stone, ceramic and multiple surface-treated metals and plastics.

### Typical Applications

Interior & Exterior wall panels  
Architectural panels  
Insulated cooler and cold storage building walls  
RV Motorized & Travel Trailer walls, roofs, & floors  
Manufactured & Modular Housing construction  
Residential & Commercial entry doors  
Lamination of Structural Plastics  
House boat composite wall lamination  
Garage door section lamination

### Procedure for Application

All bonding surfaces must be free of oil, grease, dust, lubricants, and should be of sound quality. Remove any surface contaminants with compressed air, brush or solvents. Aluminum surfaces and certain other metals must be epoxy/ conversion coated or primed for best adhesion. Uncured adhesive can be removed with solvents such as dibasic ester (DBE), propylene carbonate, or citrus-based products. Cured adhesive can be removed with recommended specialty solvents or mechanically.

### Properties of Uncured Material

Density @ 75°	1.10 (9.2 lb/gal)
Color	Amber/Brown
Solid Content	100%
Viscosity @ 75°	7,000 cps +/- 1,000
Application Temp.	75°F (Room Temperature)
Cure System	Moisture Cure
Open Time *	25-30 minutes
Rate of Cure	~80% + in 2-3 hrs.
Fixture/Press Time*	90 minutes min.
Final Setting Time*	24 hours

\* = temperature 75°F/ 50%R.H. w/ coating of 10 g/sf<sup>2</sup> + 1 g/sf<sup>2</sup> water

### General Information

#### Storage

989 can be applied by roll coating, bead extruder, or manually by hand. Recommended coating weights will typically range between 10 and 20 grams/ ft<sup>2</sup> depending on substrates used. Moisture is required to efficiently cure the adhesive, usually 10% of the applied weight of the adhesive is recommended. Elevated temperatures will accelerate adhesive curing, and will reduce/ shorten open time. Intimate contact pressure between the substrates is necessary while adhesive is curing, 3 to 10 psi for soft core materials, 50 psi for all other materials

Product should be stored in a cool and dry location at temperatures below 30°C. Optimal storage is 22±4°C. Shelf life is 6 months from date of manufacture when stored at 22±4°C

#### Note

The data are furnished for information only and are believed to be reliable. We cannot assume responsibility for the results obtained by others over whose methods we have no control. It is recommended that the product be tested in the application for which it is to be used.