

Shenzhen Jianghe New Materials Technology Co.,Ltd

Technical Data Sheet (TDS)

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618AB-18

Application Instructions

618AB-18 Series is a two-component polyurethane resin system formulated for room-temperature or heat-assisted curing. Upon curing, it forms a transparent, glossy protective coating suitable for various stickers, wall decals, signage, nameplates, and decorative items.

The product is supplied as separate base and hardener components, which must be thoroughly mixed in the specified ratio to form a transparent, flexible resin after curing. The cured material exhibits outstanding weather resistance and UV stability, ensuring long-term performance in indoor applications.

Composition

618A-18 is the polyol component, while 618B-18 is the isocyanate component. The system is suitable for both manual and mechanical dispensing processes.

Product Characteristics

1. Extended pot life combined with rapid heat-assisted curing significantly improves production efficiency.
2. Low viscosity with excellent bubble release; cures to a smooth, high-gloss surface with superior flatness, free from ripples and tack.
3. High clarity with strong gloss and adhesion.

4. Excellent weatherability and UV resistance after curing; maintains stable performance across a broad temperature range (0 °C to 80 °C).

Uncured Properties

Test Items	Test Methods	618A-18	618B-18
Appearance	Visual inspection	Colorless to light yellow liquid	Colorless transparent liquid
Viscosity	25°C, mPa·s	200±50	250±50
Mix Ratio by Weight	A:B=1:1		
Pot Life (25°C)	15 mins		
Curing Time	65°C×3.5h or 25°C×24h		
Shelf Life	25°C, sealed	6 months	3 months

Process Flow

The 618AB-18 series is available in two formulations: a manual dispensing type with longer pot life and slower curing, and a mechanical dispensing type with shorter pot life and faster curing.

1. Manual Dispensing

- ① Maintain ambient temperature at 15–25 °C and relative humidity below 70%. Store 618AB-18 under these conditions for 24 hours before use.
- ② Preheat substrates such as PVC, plastic labels, or metal labels in an oven at 60 °C to remove surface moisture. Then place the labels on a level surface and secure them with adhesive tape.
- ③ Clean the label surfaces to remove dust and oil contamination.
- ④ Precisely weigh 618AB-18 at a weight ratio of 1:1, then mix thoroughly until uniform.
- ⑤ Degas the mixture under a vacuum of –0.1 MPa until no bubbles remain.
- ⑥ Draw the degassed resin into a clean syringe and dispense it evenly onto the prepared substrate. A typical coating thickness is 2 mm; the resin will self-level.
- ⑦ Within 5 minutes after dispensing, inspect the surface for bubbles or dust. Use a pin to burst any small bubbles and guide resin into any uncovered corners.
- ⑧ Cure the coated labels in an oven at 60–80 °C for 2–3.5 hours, or allow to cure at room

temperature for 24 hours, until the surface is tack-free.

2. Mechanical Dispensing Process

- ① Place the sealed containers of 618AB-18 in a controlled environment (15–25 °C, relative humidity <70%, dust-free) for more than 96 hours to allow entrapped air from transportation to dissipate.
- ② Install and secure suction pumps into each container, then let the system stand for 24 hours.
- ③ Position the labels on a flat horizontal surface and fix them with adhesive tape.
- ④ Clean the label surfaces thoroughly to remove dust and oils.
- ⑤ Flush the static mixer and dispensing head with dichloromethane or ethyl acetate.
- ⑥ Prime the system by dispensing material to purge air from the hoses, static mixer, and dispensing head.
- ⑦ Dispense the mixed resin evenly onto the label surface.
- ⑧ Spread the resin across the entire surface using a needle and remove any residual bubbles.
- ⑨ Transfer the coated labels to a curing oven at 60 °C.
- ⑩ Allow 2–4 hours for complete curing before collecting and packaging.

Processing & Curing Parameters

Item	Unit or Condition	618AB-18
Appearance	Visual inspection	Surface finish: Colorless transparent, smooth and ripple-free
Hardness	Shore A	70±5
Tack-free time at 25°C ambient temperature	h	5
Curing time for 50g mass	h	1-2

Packaging Specifications

5 kg PE plastic pail / 20 kg steel pail.

Storage, Transportation & Precautions

1. This product is classified as non-hazardous and should be transported as general chemicals.
2. Store in a cool, dark, and sealed environment at 15–25°C with relative humidity <70%. Refer to the container for the specific shelf life.
3. Component B is unstable when exposed to air and must be resealed immediately after use. Both Components A and B are highly moisture-sensitive—strictly prevent contact with water vapor.
4. For manual dispensing, weigh components accurately according to the specified ratio and mix thoroughly. Note that pot life shortens when mixing quantities exceed 100g.

Note: The performance data provided are typical values measured at 25 °C and 65% relative humidity. They are for reference only and do not represent a guarantee of performance under all specific conditions. Users should verify suitability through actual testing. For improved results, Component A may be vacuum-dried to remove moisture prior to use, if conditions permit.