

产品简介 Product Description

复塑胶用于将彩色 PVC、PET 装饰膜与冷轧钢板、铝板及镀锌板复合成复塑钢板,广泛用于制作复塑钢板门、铝天花以及冰箱、空调外壳等。本品为单组份溶剂型胶粘剂,使用者须配备带有烘道的机械化复塑流水线。

This adhesive laminates colored PVC / PET decorative film to cold-rolled steel, aluminum and galvanized sheet to produce vinyl-coated “laminated steel” — widely used for laminated-steel doors, aluminum ceilings and refrigerator / air-conditioner housings. It is a single-component, solvent-based adhesive and requires a mechanized lamination line with a heating oven.

技术参数 Technical Data

项目 Item	参数 Value
类型 Type	单组份溶剂型 / Single-component, solvent-based
外观 Appearance	无色或淡黄色透明粘稠液 / Colorless or light-yellow transparent viscous liquid
粘度 Viscosity	120 ~ 140 s (涂-4 杯,25°C / Ford cup #4, 25°C)
固含量 Solid content	20 ~ 30%
pH 值 pH	6 ~ 7
初固化 Initial set	≤ 5 s (最佳粘接强度在 24 h 以后 / full strength after 24 h)
涂胶量 Coating weight	40 ~ 50 g/m ²
复合温度 Lamination	150 ~ 210°C (板温 substrate)

temperature

制品特性 Laminate Performance

180° 剥离强度 180° peel
strength

PVC 膜与金属板 > 50 N (GB 2790-81)

深冲性 Deep-draw (Erichsen) ≥ 5 mm

耐腐蚀性 Corrosion
resistance

盐水喷雾 120 h、5% 盐酸 120 h、1% 氢氧化钠浸泡 20 h 均无异常
No abnormality after 120 h salt spray, 120 h 5% HCl, 20 h 1% NaOH
immersion

应用工艺 Application Process

1. 金属板材除锈、除油、清洗、磷化、干燥；电镀锌板可直接使用。De-rust, de-grease, clean, phosphate and dry the sheet; electro-galvanized sheet can be used directly.
2. 检查胶液粘度, 过于粘稠可用高级别醋酸丁酯稀释；均匀涂胶 40~50 g/m²。Check viscosity (thin with high-grade butyl acetate if needed); coat evenly at 40–50 g/m².
3. 钢板进入烘道, 先低后高逐步升温至板温 150~210°C。Pass through the oven, ramping the substrate to 150–210°C.
4. 出烘道即快速复合 PVC / PET 彩色装饰膜。On exit, immediately laminate the PVC / PET film.
5. 立即用凉水 / 冷风冷却, 吹干后复合带不干胶的 PE 保护膜。Cool with cold water / air, dry, then apply a self-adhesive PE protective film.
6. 半成品即可进行纵横裁边、冲压成型等深加工。The laminate can then be slit, stamped or deep-drawn.

注: 复塑工艺较复杂、科技含量高, 机速、温度、烘道长短均须慎重调节；初次使用建议来电共同探讨。

Note: the process is technical — line speed, temperature and oven length must be carefully tuned. Contact us before a first run.

包装与储存 Packaging & Storage

包装 Packaging: 200 kg / 镀锌桶 (galvanized drum)。

储存 Storage: 密封、阴凉条件下可有效贮存 6 个月。Stored sealed in a cool place, shelf life is 6 months.

安全防护 Health & Safety

本品为溶剂型胶粘剂,有技术上不可避免的轻度气味,车间内应保持空气流通;胶粘剂属易燃易爆物品,工作场地严禁明火。若不慎将胶溅入眼睛,先尽快用大量清水冲洗,然后请医生处理。

This is a solvent-based adhesive with an unavoidable mild odor — keep the workshop ventilated. It is flammable; strictly no open flame in the work area. If splashed into the eyes, rinse immediately with plenty of water and seek medical attention.

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