



# THIXON™ 6106

**Description** THIXON™ 6106 is a vulcanizing adhesive used to thermally laminate polypropylene copolymers to substrates such as metal, glass and wood. This product is a one-part dispersion and must be mixed well before and during use. Cohesive failure bonds are typical for most polypropylene copolymer materials.

| Uncured Properties                      | Nominal Value | Unit              | Test Method |
|---|---------------|-------------------|-------------|
| Color                                   | Black         |                   |             |
| Solids Content                          |               |                   |             |
| -- <sup>1</sup>                         | 20            | %                 |             |
| -- <sup>2</sup>                         | 29 to 31      | %                 | ASTM D2369  |
| Density                                 | 0.935         | g/cm <sup>3</sup> | ASTM D1475  |
| VOC Content                             | 5.70          | lb/gal            |             |
| Flash Point <sup>3</sup>                | 27.7          | °C                |             |
| Viscosity <sup>4</sup> (Brookfield RVT) | 0.18 to 0.33  | Pa·s              | ASTM D1084  |
| Shelf Life <sup>5</sup> (25°C)          | 12            | month             |             |

**Surface Prep**

Review Dow 's rubber-to-substrate bonding agent application guide or contact your account manager.

**Mix Instructions**

Diluents - Diacetone alcohol or MEK

**Application Technique**

Product may be applied with reverse roll coater, spray or dip. Spray or dip coating may require dilution of the adhesive. Do not filter with less than a 600 micron filter.

The wet adhesive layer must be dried and thermally fused to the substrate onto which it is coated by heating to 400° - 450°F (204° - 232°C) PMT during a 1 to 2 minute dwell time. Once quenched to room temperature, the coated substrate has an indefinite shelf life. Cured film will provide an anti corrosion layer over substrate.

**Clean-up**

Equipment clean up should be done using recommended dilution solvents.

**Packaging/Sizes Available**

Drums, pails and cans.

**Storage & Stability**

The shelf life of this material is assured for 6 months (from the date of manufacture) at temperatures below 78°F in an unopened container.

**Toxicity and Safety Information**

Read the Safety Data Sheet before using this material. Toxicity and safety information is included in the SDS.

**Food Contact Applications**

Dow Automotive products are not approved for direct or indirect food contact or drinking water applications. If your applications include food contact or drinking water requirements, please contact your Dow representative. For more information on the regulatory status of this product, please refer to the SDS for this product.

**Notes**

These are typical properties only and are not to be construed as specifications. Users should confirm results by their own tests.

<sup>1</sup> By volume

<sup>2</sup> Non-volatile solids by weight

<sup>3</sup> Seta Closed Cup

<sup>4</sup> Spindle #1, @ 20 RPM

<sup>5</sup> Unopened

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## Additional Information

|                      |                  |                           |                |
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