

# Mor-Ad™ M-630 Laminating Adhesive

## One-Part, Bead-Applied Urethane Laminating Adhesive

### FEATURES/BENEFITS

#### Description

**Mor-Ad™ M-630 Laminating Adhesive\*** is a one-part, moisture-cure urethane adhesive designed for application by bead applicator. **Mor-Ad™ M-630** is one product in the full line of Mor-Ad™ Laminating Adhesives, available in both one and two-part urethane adhesive designed for semi-continuous and continuous laminators.

#### Ease of Use

**Mor-Ad™ M-630** is easy to handle, use and apply via. Some features include:

- Good flow and transfer properties
- Bonds strongly to a wide variety of materials
- Excellent resistance to heat, cold, and moisture

Common applications for Mor-Ad™ adhesives include:

- Structural insulated panel (SIP) adhesion
- Garage doors
- Walk-in coolers & freezers
- Architectural panels
- Sunroom panels
- RV lamination
- Miscellaneous panel lamination

#### Available Sizes

**Mor-Ad™ M-630** is sold in 55 gallon steel drums.

### PROPERTIES

**Mor-Ad™ M-630 Laminating Adhesive** exhibits physical properties as indicated in Tables 1 and 2 when tested as represented. Review all instructions and (Material) Safety Data Sheet ((M)SDS) before use. Please contact DuPont at 1-866-583-2583 when additional guidance is required for writing specifications that include this product.

**TABLE 1: Typical Physical Properties for Mor-Ad™ M-630 Laminating Adhesive**

Property	Typical Value
Appearance	Syrupy liquid
Color	Amber
Viscosity (Brookfield RVT,#4 Spindle, 20 rpm), Cps@ 25°C	4500 nominal
Working and cure time @ 75°F	Refer to Table 2
Density	9.48 lbs/gal (1.14 kg/L)
Flash point (Setaflash),°F	>200 (93°C)

**TABLE 2: Cure Schedule\*\* for Mor-Ad™ M-630 Laminating Adhesive**

Application rate of 12 g/sq.ft. adhesive (129 g/sq.m.) and 2 g/sq.ft. water (22 g/sq.m.) Fiber-Reinforced Plastic (FRP) to Luan

Temperature	Maximum Working Time	Press Time
60°F (16°C)	44 Minutes	97 Minutes
65°F (18°C)	39 Minutes	81 Minutes
70°F (21°C)	34 Minutes	68 Minutes
75°F (24°C)	29 Minutes	58 Minutes
80°F (27°C)	25 Minutes	50 Minutes
85°F (29°C)	21 Minutes	44 Minutes
90°F (32°C)	18 Minutes	39 Minutes
95°F (35°C)	15 Minutes	34 Minutes
100°F (38°C)	13 Minutes	30 Minutes

\* Mor-Ad™ M-630 is a former product of The Dow Chemical Company

\*\* Panels must be under pressure within the stated maximum working time. This information is based on a continuous thin film and is to be used as a guideline. Actual parameters must be verified at the facility where the product is to be used.

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## INSTALLATION

### Use Conditions

A cure schedule detailing maximum working time and press time at varying temperatures for **Mor-Ad™ M-630 Laminating Adhesive** can be found in Table 2.

### Application

**Mor-Ad™ M-630** can be applied via bead applicator or roll coater. Water mist on the adhesive surface is recommended to ensure uniform cure rate.

### Notice

Contact your DuPont sales representative or local authorities for state and local building code requirements and related acceptances.

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## HANDLING

**WARNING: For Professional Use Only.** Read and follow the entire Handling section and the Safety Data Sheets (SDSs, formerly MSDSs or Material Safety Data Sheets) carefully before use. The information below is designed to protect the user and allow for safe use and handling of DuPont™ products. Follow all applicable federal, state, local and employer regulations.

### Precautionary Statements

- **Mor-Ad™ M-630 Laminating Adhesive** is moisture reactive and must be protected from undue exposure to moisture.
- Use only in well ventilated area away from open flames, sparks, or excessive heat.
- Avoid unnecessary contact with skin and eyes.

### Clean Up and Purge

- To clean up **Mor-Ad™ M-630** before it has cured, use DBE (dibasic ester) or propylene carbonate.
- Use all solvents with care. Make sure there is adequate ventilation. Read and understand the MSDS provided with the solvent.

### Shelf Life and Storage

- Ideal storage temperatures for **Mor-Ad™ M-630** are between 50-75°F (10-24°C).
- When stored as directed, and in the original unopened containers, at 70°F (21°C), **Mor-Ad™ M-630** has a shelf life of 1 year from the date of manufacture.
- Containers of **Mor-Ad™ M-630** should be stored under cover and protected from contact with rain or snow. Water should not be allowed to accumulate on the drums or pails where it can be drawn into the containers.
- Once opened, containers of the adhesive should be used immediately or protected by a blanket of dry nitrogen when standing unused.

### Disposal

Dispose of any residual DuPont™ product, coated debris, or solvent in accordance with applicable federal, state, and local government regulations.



**For more information visit us at  
[building.dupont.com/morad](http://building.dupont.com/morad)  
or call 1-866-583-2583**

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