

# Technical Data Sheet

## High Tack Urethane Adhesive

### DINITROL® D-506

#### General description

D-506 is a high modulus, heated, one component urethane adhesive system with the following benefits:

- High viscosity
- High modulus
- Instantaneous green strength
- OEM product
- Meets all applicable FMVSS
- 1 hour drive away at 15 degrees F
- Crash test proven

#### Shelf Life

12 months in an unopened cartridge.

#### Storage Requirements

Store between 0°C (32°F) and 35°C (95°F), in closed packaging.

#### Packaging

10.5 oz

#### Part#

D-506

#### Working Time

10 minutes at 23°C (73°F) and 50% RH

#### Tensile Strength

12 MPa (1740 psi)

#### Lap Shear Strength

- 3 hours >1 MPa (145 psi)
- 24 hours >4.8 MPa (696 psi)
- 7 days >7.4 MPa (1073 psi)

#### Shear Modulus

2.1 MPa "at 10% deformation"

#### Shore Hardness

Shore A 72 ± 5

#### Elongation

500%

#### Required Pre-Treatment Products

- D-520 & D-530 or D-528 1-Step
- D-540 for PAAS only (VW & Audi glass and to be used with high modulus urethane)
- D-560 PVC-Activator (for PVC encapsulated glass.)

#### Installation

Heat D-506 for 30 minutes in a Dinitrol approved oven between 140° and 180°F.

Use the full cut method leaving 2mm as a base.

All bonding areas have to be clean, dry and grease free. The glass side has to be pre-treated with the one-step primer D-528 or with the system D-520 glass activator and D-530 glass/paint primer.

Remove the aluminum tab on the bottom of the cartridge. Cut nozzle to meet urethane dimensions as specified by the respective car manufacturer. Puncture top and attach pre-cut nozzle. Insert into gun.

If there is no existing urethane on the pinchweld to use as a substrate for D-506, the one-step primer D-528 or the glass/ paint primer D-530 should be applied on the pinchweld for best result. D-506 can be applied on the glass or on the pinchweld.

#### CAUTION:

**If Dinitrol primers are applied in cold conditions extra flash or dry time is required. See tech data sheets for respective primers.**

Drive Away With Passenger Side Airbag

TEMP/RH	>70%	>50%	>30%	>10%
>85°F (30°C)	1.5 h	1.5 h	2 h	2 h
>73°F (23°C)	1 h	1.5 h	1.5 h	2 h
>60°F (15°C)	1 h	1 h	1 h	1 h
>50°F (10°C)	1 h	1 h	1 h	1 h
>40°F (5°C)	1 h	1 h	1 h	1 h
>32°F (0°C)	1 h	1 h	1 h	1 h
>23°F (-5°C)	1 h	1 h	1 h	1 h
>15°F (-10°C)	1 h	1 h	1 h	1 h

Without Passenger Side Airbag

TEMP/RH	>70%	>50%	>30%	>10%
>85°F (30°C)	1 h	1 h	1.5 h	1.5 h
>73°F (23°C)	45 min	1 h	1 h	1.5 h
>60°F (15°C)	45 min	45 min	45 min	45 min
>50°F (10°C)	45 min	45 min	45 min	45 min
>40°F (5°C)	45 min	45 min	45 min	45 min
>32°F (0°C)	45 min	45 min	45 min	45 min
>23°F (-5°C)	45 min	45 min	45 min	45 min
>15°F (-10°C)	45 min	45 min	45 min	45 min

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