

145SPT Contact adhesive

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Technical data

Basis	Polychloroprene rubber (neoprene).
Consistency	Fluid
Curing system	Physical drying and crystallisation
Density	Ca. 0,81 g/ml
Tools	Pneumatic gun Spray opening: min. 2,5 mm Pressure: 3 - 5 bar Pressure on can: 0,5 - 2 bar
Viscosity (Brookfield)	250 mPa.s → 400 mPa.s
Total solid content	Ca. 17 %
Open time (*)	Ca. 20 min.
Evaporation time (=minimum time before bonding)	Ca. 10 min
Drying time (23°C and 50% R.H.)	Ca. 72h
Consumption (*)	100 - 300 ml/m ² , each side
Temperature resistance**	-15 °C → 70 °C

* These values may vary depending on environmental factors such as temperature, moisture, and type of substrates. ** This information relates to fully cured product.

Product description

Ready to use, toluene free, transparent, sprayable contact adhesive based on polychloroprene (Neoprene®)

Properties

- Ready to use, on a sprayable viscosity
- Immediately fixed
- Fast strength build-up.
- Moisture resistant.
- Resistant against high temperatures
- Toluene free

Applications

- Used in two-sided adhesions on various materials, wood and stratified decorative covering panels (Formica®, Resopal®,...), veneer, stairsteps and nosings, PVC-plinths, leather, cork, textile, with each other for wood, wood derivatives, stone, concrete, plaster, metal and other smooth, non-porous surfaces.
- Meant for all adhesions where a fast bonding is required, for adhesions of two non-porous materials.
- Only for interior use

Packaging

Colour: transparent

Packaging: 20L can

Shelf life

12 months in unopened packaging in a cool and dry storage place at temperatures between +5°C and +25°C. After use, close the packaging with the original cap.

Substrates

Surface preparation: Substrates have to be clean, dry, free of dust, rust, oil and grease. The adhesive is easiest to handle in a dry environment with a temperature of minimum +15°C. Make sure both the adhesive as the substrates are acclimatized. For a better adhesion it's recommended to roughen the surface with sanding paper P80, metal has to be free of rust and roughened at a St 3 level (according to ISO 8501-1). Always perform an adhesion test on non-current substrates prior to use. Both substrates have to be even and/or well matched.

Not suitable for PE, PP, PTFE (eg. Teflon®) and bituminous substrates. Given the wide

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variety of EPDM-substrates, a preliminary adhesion test is required.

Application method

Sprayable with the traditional spray installations or with pneumatic spray guns. Opening: 2,5 mm or wider Pressure: 3 to 5 bar Pressure on can: 0,5 to 2 bar, also sprayable with a HVLP gravity feed spray gun Remark: The adhesive doesn't spray like a paint, it forms drips and wisps. When the adhesion doesn't have to happen immediately or when bonding two non-porous materials: Apply the adhesive two-sided with the spray gun. Make sure that the adhesive is sprayed equally, the coverage has to be min. 80%. For strong porous materials (plaster, concrete, ...) a second adhesive layer has to be applied, \pm 20 mins after the first layer. About 5 to 10 mins, depending on the circumstances, let dry and close within 20 minutes after applying. The bonding happens immediately. Then press hard with a roller or tap strongly with a rubber hammer. If the adhesion has to be adapted (at least 1 substrate has to be porous) or when bonding two porous materials: It's sufficient to apply 145SPT Contact adhesive on one of the two sides Close immediately after usage.

- When the metal is free of rust and roughened, it's important to ground the element. A discharge of static electricity can ignite the solvents if the adhesive is applied on the surface.
- Pressing the materials, during curing, is not necessary to reach the highest end strength. The initial strength and not the duration of the compression will determine the ultimate strength.
- Once the maximum open time is exceeded and the adhesive is too dry to bond, the surface can be reactivated with an extra thin layer of 145SPT Contact adhesive.

Health- and Safety Recommendations

Take the usual labour hygiene into account. Use only in well-ventilated areas. Do not smoke. In case of insufficient ventilation it is appropriate to wear respiratory protection. Consult label and material safety data sheet for more information.

Remarks

- In a colder period, the viscosity of the adhesive can raise because of the lower temperature, this will result in a more difficult adhesive to spray. If necessary, the adhesive can be diluted with max. 10% of Soudal Dissolver SP.

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