ALCOLIN CONTACT ADHESIVE

Description

ALCOLIN CONTACT ADHESIVE is a superior all-purpose polychloroprene rubber-based contact adhesive with high immediate bond strength, good brushability, water and heat resistance. Bonds instantly on contact to a variety of surfaces without clamping or sustained pressure.

Features & Benefits

- Excellent initial grab - high immediate bond strength.
- Quick drying - ideal for quick repairs.
- For porous and non-porous surfaces - bonds a wide variety of similar and dissimilar substrates.
- Good brushability - easy to apply.
- Good heat resistance - can withstand up to 80°C.
- Good water resistance - suitable for interior and exterior applications.
- Long green time - time to prepare and align surfaces to be bonded.

Applications

- General purpose applications in the light industry.
- Furniture and upholstery industry.
- Handicrafts and decorative work.
- Shoe repair and leather work.

Adhesion

- Wood, processed boards (e.g. hardboard, supawood, chipboard, high pressure laminates, masonite, plywood), formica, veneers, floor coverings, foam, canvas, textiles, leather, felt, cloth, concrete, linoleum, glass, metal, rubber, cork and some plastics.

Limitations

- Not recommended for use as a structural adhesive.
- Not suitable for polyethylene, polypropylene, expanded polystyrene, Teflon, flexible PVC and bitumen backed PVC tiles.
- Not suitable for repair of items that hold hot liquids or where heat resistance above 80°C is required.

Safety instructions

ALCOLIN CONTACT ADHESIVE is flammable. Keep away from naked flames and ignition sources. Safe handling practices should be implemented to avoid irritating sensitive skin. It is advisable to wear gloves in order to avoid direct skin contact. If glue comes into contact with skin or eyes, flush thoroughly and immediately with water. If irritation continues, seek medical attention. Glue is slippery when wet, so care should be taken when cleaning spillages that occur. Always work in a well ventilated area. Do not breathe in vapors. For unventilated areas, a NIOSH approved respirator will be necessary. Refer to our Safety Data Sheets for further toxicological information and comprehensive handling instructions.

Surface preparation

- The surfaces must be clean, dry, and free of loose materials, dust, dirt, rust and any other contaminants.

- Metal surfaces should be degreased with a solvent such as acetone.
- Poor surface preparation may result in glue failure.

Directions for use

1. For best results, ensure that temperature of the surfaces to be bonded is above 18°C.
2. Stir product well before use.
3. Apply ALCOLIN CONTACT ADHESIVE to **both** surfaces evenly with a fine serrated trowel or a stiff brush, covering the entire joint area. 80% coverage can be applied to the body of the substrate, but 100% coverage must be applied to the edges. A spread rate of approximately 2m^2 per liter should be achieved for double sided application.
4. To tell if you have applied enough adhesive, when the adhesive is dry and ready to bond, the adhesive should have a uniform glossy appearance with light reflecting on it. Any dull areas indicate insufficient adhesive from not applying enough, soak-in, or a combination of both. Dull areas should be reapplied and allowed to dry.
5. For effective bonding on absorbent surfaces and porous material e.g. edges of chipboard, apply two coats. The first coat will act as a sealer preventing excessive absorption of the second coat into the substrate. Apply the second coat only after the first has dried. It is not recommended to apply one heavy coat of contact adhesive to porous materials. Contact adhesives dry from outside in, form a skin which can fool you into believing that the adhesive is dry and ready for bonding. This can lead to solvent entrapment, and bubbling and or edge lifting as the solvents try and escape.
6. Allow both surfaces to dry until touch dry (i.e. no adhesive is transferred to the back of a finger when touched – do not test using front part of your hand due to the oiliness). The time taken for the adhesive to be touch dry is known as the Open Time. The Open Time of ALCOLIN CONTACT ADHESIVE is approximately 5 to 10 minutes under normal room temperature conditions (23°C). Conditions of high humidity and low temperature will extend Open Time, while conditions of low humidity and high temperature will shorten this time.
7. After the surfaces are touch dry, they must be brought together before the adhesive loses its "contactability". This time is known as the Green Time. For ALCOLIN CONTACT ADHESIVE, the Green Time is approximately 40 minutes. The surfaces to be bonded must be brought together within this Green Time for a strong bond to be formed.
8. Carefully align the two surfaces before bonding, since no adjustment is possible after the adhesive films have made contact.
9. Apply firm pressure to the whole surface for a few seconds, to create an instantaneous bond. A pinch roller or a J roller (8cm rubber roller with metal handle) is recommended. Apply a minimum pressure of 30 psi. The stronger the pressure, the better the bond.
10. Full strength is achieved after 24 hours, however, bonded assemblies can be machined or trimmed immediately after bonding.
11. For spray application, dilute with toluene or acetone (10 – 20%) and apply as above.

Application note

If working under conditions of high relative humidity (above 50%), a condition known as "blushing" can affect solvent based contact adhesives. The "blush" is caused by rapid evaporation of the solvents which causes condensation on the surface. After applying the contact adhesive, place your hand underneath the high pressure laminate (the decorative face) – if it feels wet, there is moisture on the glue line as well. Blushing is further indicated by a colour change in the glue line. A clear adhesive will turn cloudy. The condensation causes a barrier between the two glue lines. If it is not removed before making the bond, one will get a false initial bond, which will cause bubbling and delamination once the water evaporates off.

To avoid blushing, it is best to keep surfaces at or above room temperature during the gluing operation.

Consult your Alcolin Rep for more information on troubleshooting with contact adhesives.

Cleaning

- Clean applicators and spray equipment with suitable solvents such as toluene, acetone or thinners immediately after use.

Storage stability

ALCOLIN CONTACT ADHESIVE has a shelf life of at least 12 months if stored in a cool (below 25°C), dry place in its original moisture-tight container. If the material is kept beyond the recommended shelf life, it is not necessarily unusable. A check should be performed to observe whether the product has not separated, thickened, or shows signs

of bacterial degradation (bad smell, discoloration and low viscosity). To maximize the shelf life of the opened container, ensure that the packaging is closed to create an airtight environment when not in use. If the package is left open for long periods, the glue will thicken due to solvent evaporation. It is recommended to stir product before use to ensure even consistency.

Product packaging

- 25ml tube
- 50ml tube
- 90ml tube
- 250ml tin
- 500ml tin
- 1L tin
- 2L tin
- 5L tin

Product data

i. Physical data

Appearance	Translucent yellow liquid
Type	Neoprene / polychloroprene adhesive
Solids	Approximately 20%
Density	Approximately 0.85g/cm^3
Viscosity	Approximately 2200cps
Shelf life	12 months in sealed container

*ii. Application data**

Application temperature	18°C to 35°C
Coverage	Approximately 2m^2 per litre (double sided application.)
Open time (solvent flash off time)	5 - 10 minutes (ambient conditions)
Green time	40 minutes (ambient conditions)
Clamping pressure	Minimum 2kg/cm^2 (30psi)
Full cure	After 24 hours

**Please refer to "Directions for Use" section for further details*

iii. Performance data

90° Peel (leather – chipboard)	3.4 N/mm
Wood to wood – tensile (beech wood)	2.6 N/mm^2
Heat resistance	Approximately 80°C
Water resistance	Good

The above information is only offered, as a guide to the use of this product. Furthermore, users should satisfy themselves that it is suitable for their needs. Since we have no control over the conditions under which it is used, we cannot accept responsibility for problems caused by the use and/or application of this product.

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