

TECHNICAL DATA SHEET

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ACROBOND® CR 960 R-TF**GENERAL CHARACTERISTICS / MAIN USE :****Toluene free, multi-purpose, CR-based contact adhesive**

Solvent-based but toluene-free, multi-purpose chloroprene adhesive with high initial bonding strength, specially developed for bonding of wood, plywood, medium, laminated board, fibreglass reinforced polyester, metals, absorbent and fibrous units, paperboard, nonwoven, textiles and some types of foam, rubber and rigid plastics for which specific trials have to be done. This adhesive is not suitable, neither for plasticized PVC (migration of plasticizer), nor for extruded or expanded polystyrene foams (dissolution of polystyrene). This adhesive can only be used as a 1-part adhesive without addition of hardener, mainly in double side coating, evaporating of solvents and then immediate pressing or latest within below mentioned open-time.



TECHNICAL PROPERTIES OF PRODUCT :

Chemical base	Chloroprene rubber, resins and various additives in solution in a special solvent blend
Colour	Yellow-brownish
Consistency	Liquid, easy to apply by brush or slightly serrated spatula (~1mm gears)
Density	~ 0,85 g/cm ³
Solid content	~ 26 %
Viscosity (Brookfield)	~ 2900 mPa.s
Drying time	≥ 10 and ≤ 20 minutes for a standard layer thickness (250 ± 50 g/m ²).
Open time	≤ 35 minutes for both side coating at room temperature.
Characteristics of dry film	Cohesive film. Very good initial bond strength and good resistance against ageing and temperature until +80°C to 90°C (depending on tensile). 1-part adhesive, cannot be used with isocyanate hardener.

PREPARATION AND PROCESSING :

Materials and Surfaces	The surfaces to be bonded must be clean, dry and free of any dust and grease. Store the materials at least 24 hours and process in dry places and not below +15°C. Our technical department is available for additional technical advice to any further questions you might have.
Preparation of adhesive	1-part adhesive / to be used without addition of catalyst. Stir / mix shortly before using.
Processing / bonding	Apply adhesive regularly to both surfaces to be bonded. For very porous materials a pre-coating may be necessary. Wait for complete evaporating of the solvents (as soon as the film has lost his brightness and does not transfer to the finger when it is pressed lightly / approximately 15 minutes at 20°C). Waiting time depends on room temperature, layer thickness of adhesive film as well as absorbency of the base surfaces. One side coating is sometimes possible if one material has very reduced cohesion; in this case apply adhesive on most dense material and join together very quickly (usually ≤ 10 minutes). In case of overtaking open time, a heat activation (IR) of both coated materials can be done around +60°C to +80°C for few seconds just before pressing or coat again a thin layer.
Joining / pressing	As soon as solvent is completely evaporated, best immediately and latest within above mentioned limit of the open time and on the still slightly sticky adhesive, place the 2 coated parts accurately together and firmly press shortly but strongly both materials at a pressure around 2 kg/cm ² . Initial strength is very high but terminal strength is only reached after approximately 24 hours.
Alternative adhesives	Some other adhesives of our ACROBOND® CR range are available for special requirements (for spraying, longer open time for one side coating, 2-part adhesive to be used with addition of catalyst).
Cleaning and dilution	Use exclusively our ACRODIS CR-TF, toluene-free solvent mixture corresponding to this adhesive.

RECOMMENDATIONS / STORAGE / SAFETY :

Storage	≤ 12 months (≥ +10°C and ≤ +25°C) in original, tightly closed packaging which has to be protected from direct sunlight, heat and moisture. Protect against freezing. Stir / remove before using.
Packaging Transport	125 ml aluminium tubes (boxes including 24 tubes) 250 ml (including brush) and 750 ml boxes (boxes including 24 tubes) 5, 12,5 and 25 litre cans, 200 Litre drums. ADR Classification: UN 1133, ADHESIVES, 3, III
Handling precaution	Before first using, read carefully Material Safety Data Sheet (available on request). Pictograms indicating the obligation of wearing personal protective equipment: 
Labelling CLP regulation Hazard Pictograms / Signal word	Hazard statements: Highly flammable liquid and vapour. Causes skin irritation. Causes serious eye irritation. May cause drowsiness or dizziness. Toxic to aquatic life with long lasting effects. Main Precautionary statements: see details on Material Safety Data Sheet. General information: Take regular precautions for handling and processing chemical and flammable products. Keep away from heat, hot surfaces, sparks, open flames and other ignition sources. No smoking. Assure sufficient ventilation during processing or use respiratory protective device that is independent of circulating air. Avoid direct skin contact. Wear protective gloves and glasses. For professional / industrial use only.
 GHS02 GHS07 GHS09 Danger	
General Information	The foregoing information represents values obtained in our laboratory and has been supplied in good faith, it shall not be construed to be legally binding, in particular, it shall not exempt the purchaser from taking responsibility for testing the product supplied so as to determine its suitability for the intended application. Given the high number of materials appearing on the market and the different methods of use, which are beyond our influence and control, we cannot accept any responsibility for the results of your work. Warranty is made exclusively for the constantly high quality of our products. Please note our terms of sales, delivery & payment.