

TECHNICAL DATA SHEET

TDS N°02 / 2015.01

ACROBOND® CS 39**GENERAL CHARACTERISTICS / MAIN USE :** Spray adhesive especially designed for vacuum infusion technology

ACROBOND® CS 39 is a high performance, fast setting, solvent-based contact adhesive with high initial tack and reduced overspray which is specifically designed for bonding of fibre reinforcements such as glass and carbon fibre, fabrics, balsa and some others currently used for the vacuum infusion process. This adhesive is available as well in clear, as in light blue colour which allows optical control during applying by spray and avoids however unwanted strong visible traces. Vacuum infusion processing relies on this special adhesive for holding in place all layers until infusion is completed. Due to its ease of use, rapid coverage of large areas is possible. ACROBOND® CS 39 quickly bonds together a wide range of materials including paper, cardboard, wooden materials, foams, heat and acoustic insulators, fabrics, felt and various films and plastics for which preliminary trials are recommended. Main use is in marine and composite manufacturing processes but it is also suitable in repairing, labelling, for orthopaedics, arts, construction, saddler and general purpose assembly help.


TECHNICAL PROPERTIES OF PRODUCT :

Chemical base	Styrene-based contact adhesive in solution in a special aliphatic solvent blend.
Colour	Colourless light yellowish or blue coloured for optical control.
Consistency / Viscosity	Liquid / ~1000 mPa.s for bulk material, ~1300 mPa.s for aerosol cans (Brookfield RVT)
Density / Solid content	~ 0,81 g/cm ³ / Solid ~34% for bulk material // ~ 0,82 g/cm ³ / Solid ~39% for aerosol cans.
Consumption	~ 60 to 80 g/m ² (depending on spraying system and materials)
Initial bonding	≥ 20 seconds (depending on spraying distance, tool setting, temperature and materials).
Open time	≤ 10 minutes for 2 side bonding / ≤ 2 minutes for single side coating (depending on materials, spraying distance and adhesive layer thickness).
Film characteristics	Dry adhesive film has a very good cohesion, heat resistance up to +60°C and does not hinder the resin curing process of current vinyl-ester, polyester and styrene resins.
Processing temperature	≥ 10 °C to ≤ +35°C.
Cleaning and dilution	Use only our ACRODIS H solvent mixture corresponding to this adhesive.

PREPARATION AND PROCESSING :

Materials and Surfaces	The surfaces to be bonded must be clean, dry and free of any dust and grease. Store materials and process in dry places and not below +10°C. For special requirements or on not common materials or resins, we recommend strongly to achieve preliminary and adapted testing to ensure expected results. Our technical department is available for any additional assistance or technical advice you might need.
Preparation	ACROBOND® CS 39 is ready for use; however, best is to shake or stir shortly before using. Fill adapted quantity of adhesive into the spraying tank, close hermetically and adjust required pressure (2-4 bar). Shake the aerosol well before use and hold it vertically during using.
Processing	Spray regularly an even layer of adhesive from a distance of 20 to 30 cm on both surfaces to be joined. It must not have the appearance of being wet; if this is the case, spray from a little further away. Wait around 1-3 minutes so that the solvent present in the adhesive may evaporate (as soon as the film is losing his brightness and does not transfer to the finger when it is pressed lightly). Adhesive has the necessary tack to hold reinforcement fibre layers in place while allowing some position adjustment before setting. Then press immediately or latest within above mentioned open time the two surfaces firmly together to ensure good adhesion takes place. After each use, purge the aerosol whilst holding upside down.

RECOMMENDATIONS / STORAGE / SAFETY :

Storage	≤ 12 months (≥ +10°C and ≤ +30°C) in original, tightly closed packaging; protect against frost.
Packaging / transport	Liquid adhesive in 12,5 litre cans and 25 litre pails as well as in 160 kg net / 200 litre drums. Aerosol - 500 ml cans in cardboards with 12 units, pallets with 1080 units. ADR Classification: UN 1133 - Class 3 for bulk material / UN 1950 - Class 2.1 (5F gas) for aerosol cans (see special MSDS for Acrobond® CS 39 Spray).
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 (bulk). Extremely flammable aerosol. Pressurized container: may burst if heated. Causes skin irritation. May cause drowsiness or dizziness. Toxic to aquatic life with long lasting effects. Main Precautionary statements: Protect from sunlight. Do not expose to temperatures exceeding 50°C/122°F. Others: see details on Material Safety Data Sheet. General information: Assure sufficient ventilation during processing. Avoid direct skin contact. Keep away from heat / sparks / open flames / hot surfaces - No smoking. Wear protective gloves and glasses. For professional and industrial use only.
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.