

TECHNICAL DATA SHEET Edition 01 / up-dated 05.2013.**ACROBOND® C 37****GENERAL CHARACTERISTICS / MAIN USE :****Special adhesive for metal / PVC extrusion**

Acrobond C 37 (liquid form) and C37/S (solid form / to be dissolved before using) is a special solvent-based and low viscosity adhesive for direct bonding of PVC to metal (galvanized steel, etc.) during extrusion process. Main use of this adhesive is production of PVC plasticized wires and trims. Depending on requirements, other adhesives can be better adapted especially in case of automotive parts and trims as well as for stainless steel and aluminium; initial testing is anyway required and our technical department is available to carry out best method of use and for required advice.

TECHNICAL PROPERTIES OF PRODUCT :

Chemical base	Synthetic resins and additives in solution in a solvent blend or as solid white powder.
Colour	Translucent (after dissolution in a acetone / butanone mixture)
Consistency	Liquid, easy to apply by dumping / soaking before drying and extrusion
Density	~ 0,87 g/cm ³
Solid content	~ 20 %
Viscosity (Brookfield)	~ 150 mPa.s
Film thickness	Dry adhesive layer does usually not exceed 3-4 µm
Processing temperature	Drying and pre-heating of coated metal ~ +120°C, PVC extrusion at approx. +160°C.
Dry film characteristic	Very good ageing and heat resistance up to +80°C (c ontinuous)

PREPARATION AND PROCESSING :

Materials and Surfaces	The surfaces to be jointed or bonded must generally be clean, dry and free of dust and any grease. Stock and carry out in tempered and well ventilated rooms during and after processing. Our technical department is available for any further information or assistance you might require, especially in case of working with some non usual materials which might require some initial testing.
Processing	After degreasing and possibly metal pre-treatment such as phosphatation, adhesive can be applied on the cleaned, pre-treated metal as mentioned above by dumping or soaking and very light pressure between two felt pads in order to calibrate film thickness to above mentioned 3-4 µm (assure sufficient ventilation during processing). Coated metal must be dried and heated up at a temperature close to +120°C and following PVC is usually extruded immediately on the pre-heated coated metal. Cooling and further handling can be done as soon as room temperature is reached.
Final strength	Initial strength is very high immediately after cooling down but final strength is usually reached after approximately 24 hours.
Dilution & Cleaning	Use best our ACRODIS C solvent blend or a mainly butanone based solvent blend.

RECOMMENDATIONS / STORAGE / SAFETY :

Storage	≤ 24 months (+10°C to +25°C) in the original tightly closed packaging.
Packaging	Metallic drums containing 170 kg net. Other packaging, tins, etc. on special demand.
Labelling / Risks Precautions	Xi - Irritant. Before first using read carefully Material Safety Data Sheet which is available on request. Assure sufficient ventilation during processing. Avoid direct skin contact, do not smoke. Wear protective gloves and protective glasses. F - Highly Flammable. Follow regulation and take the regular precautions for handling / processing highly flammable & chemical products. (in the event of a large-scale use of the product, ignition sources in the immediate proximity and in low-lying areas, such as electrical equipment should be switched off ! Erect warning signs warning of the hazardous risk of explosive atmosphere !)
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 and payment.