

TECHNICAL DATA SHEET

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ACROBOND® NR 140**GENERAL CHARACTERISTICS / MAIN USE :****Translucent multi-purpose contact adhesive**

Solvent based adhesive, specially developed for bonding rigid or plastic-coated PVC on various materials such as metals, glass, ceramic, absorbent and fibrous units, some hard thermoplastics as ABS, ASA, etc... For bonding with high rate of production capsule skirt of PVC foil.

TECHNICAL CHARACTERISTICS OF PRODUCT :

Chemical base	Synthetic Rubber in solvent mixture dissolution
Colour	Colourless
Consistency	Liquid, can easily be applied by extrusion or with brush
Density	~ 0,94 g/cm ³
Solid content	~ 27 % by weight
Viscosity	~ 3000 mPa.s (Brookfield RTV)
Open time	~ 15 to 20 minutes for both side coating
Characteristics of dry film	Elastic film. Very good initial bond strength and good resistance against humidity, oil and plasticizers, temperature until + 60°C without hardener. Adhesive properties can be increased in an important way by addition of 5 % catalyst.

PREPARATION AND PROCESSING :

Materials and Surfaces	The surfaces to be bonded must be clean, dry and free of dust and grease. Store the materials and process in dry places and not below +15°C. Our technical department is available for any further questions.
Preparation of adhesive	To improve resistance, you can add 5% Catalyst and stir / mix until obtaining an homogenous mixture which has to be used within the pot-life (approx. 8 hours).
Catalyst / Hardener	ACROBOND NR 140 can be used with addition of 5% Catalyst ACROCURE ISO 28
Bonding	Apply adhesive regularly to the surfaces to be bonded. For gluing of capsule skirts a one side coating and immediate joining is recommended; for other uses coat both sides and after a waiting time (ventilation time) of approx 10-15 minutes, the surfaces are to be joined together.
Joining	As soon as solvent is completely evaporated and within the limit of the open time, both materials have to be joined together.
Pressing	Press strongly both materials together. Initial strength is high but terminal strength is reached after 24 to 48 hours approximately.
Alternatives	It is also possible to use the adhesive by reactivation of dry film at approx. + 70°C.
Dilution / Cleaner	Use exclusively our cleaner ACRODIS C.

RECOMMENDATIONS / STORAGE / SAFETY :

Storage	≤ 24 months in a cool (+10 to +25°C) and dry place in the original tightly closed packaging. Protect against freezing. Stir / remove before using.
Packaging	Cans of 12,5 Liters, drums of 200 Liters.
Precautions	Assure sufficient ventilation during storage and processing. Avoid direct skin contact of the uncured adhesive. Wear protective gloves and glasses.
Labelling	Highly flammable. Take the regular precautions for handling and processing flammable products. Do not smoke. Safety data sheet available on request.
Toxicity	Irritating
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 also note our terms of sales, delivery and payment.