

TECHNICAL DATA SHEET

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ACROBOND® PR 11**GENERAL CHARACTERISTICS / MAIN USE :****adhesion promoter for EVA foam and shoe soles**

Acrobond PR 11 is a solvent-based and very low viscosity primer used as an adhesion promoter mainly for EVA foam and soles (excepted UV-treated EVA) and thermoplastics such as PA mixtures (tests are necessary). Acrobond PR 11 is increasing the adhesive strength on above mentioned materials mainly combined with solvent-based and water-based PU adhesives. This product is mainly used as a 2-part primer by addition of ~ 5% Acrocure ISO 23S hardener to increase resistance of primer + hardener mixture against temperature and moisture.

TECHNICAL PROPERTIES OF PRODUCT :

Chemical base	Synthetic resins and additives in solution in a special aromatic solvent blend
Colour	Translucent (transparent to slightly turbid or lightly yellow)
Consistency	Very liquid, easy to apply by brush
Density	~ 0,87 g/cm ³
Solid content	≤ 1 %
Viscosity Brookfield	~ 20 mPa.s
Consumption	~ 60 g per m ²
Drying time	≥ at least 10 minutes at room temperature
Open time	≤ maximum 48 hours at room temperature until application of PU adhesive
Temperature resistance	~ +85°C for 2-part (tests & approval recommended)
Hardener addition	~ 5% to 10% Acrocure ISO 23 S (stirr well and use this mixture within 8 hours)
Cleaning and dilution	Use only our Acrodis TX solvent mixture.

PREPARATION AND PROCESSING :

Materials and Surfaces	The surfaces to be coated must be clean, dry and free of dust and any grease. Best adhesion is obtained by heating up shortly the plastic at approximately +60-80°C. Our technical department is available for any further information.
Preparation of coating	After hardener addition, shake or stirr well before using and do not prepare more mixture than able to be used within 8 hours which is the maximum pot-life.
Processing	Acrobond PR 11 can be applied directly on the plastics by brush and other systems such as spraying (assure sufficient ventilation during processing).
Drying time	After application of the primer, the solvents of the primer need to be completely evaporated; after at least 10 to 15 minutes and latest within 48 hours the adhesive, must be applied on the primer coated plastic.
Drying conditions	Drying of the primer can be done at room temperature or during a short time (2-5 minutes) at approximately +60-80°C which improves basically adhesive strength.

RECOMMENDATIONS / STORAGE / SAFETY :

Storage	Not longer than 12 months (+10°C to +25°C) in the original tightly closed packaging which has to be protected from direct sunlight, heat and moisture.
Packaging	Metallic tins containing 4 kg net.
Precautions	Assure sufficient ventilation during processing. Avoid direct skin contact, do not smoke. Wear protective gloves and glasses. Follow regulation on Highly Flammable Liquids.
Labelling / Toxicity	F-Highly Flammable - Xn-Harmful. Take the regular precautions for handling / processing chemical products. Before first using read carefully Safety data sheet which is available on request.
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.