

TECHNICAL DATA SHEET

Edition 01 / 06.2007

ACROBOND CR 108**GENERAL CHARACTERISTICS / MAIN USE :****Toluene free, multi-purpose CR contact adhesive**

Solvent based but toluene free chloroprene adhesive with high initial bond strength, specially developed for bonding of wood, plywood, medium, laminated board, fibreglass reinforced polyester, metals, absorbent and fibrous units, paperboard, textiles and some types of rubber and rigid plastics for which specific trials have to be done. This adhesive is not suitable, neither for plasticized PVC, nor for extruded or expanded polystyrene foams. This adhesive is used without hardener in double side coating, evaporating of solvents and immediate pressing within open-time.

TECHNICAL CHARACTERISTICS OF PRODUCT :

Chemical base	Chloroprene rubber, resins and additives in solvent mixture dissolution
Colour	Yellow-brown
Consistency	Liquid, can easily be applied by brush or slightly serrated spatula (~1mm gears)
Density	~ 0,82 g/cm ³
Solid content	~ 23 % by weight
Viscosity	~ 1700 mPa.s (Brookfield RVT)
Open time	≤ 50 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. Adhesive can not be used with isocyanate hardener.

PREPARATION AND PROCESSING :

Materials and Surfaces	The surfaces to be bonded must be clean, dry and free of 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 technical advice to any further questions.
Preparation of adhesive	1-part adhesive / to be used without addition of catalyst. Stir / mix before using.
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 is losing his brightness and does not stick or transfer to the finger when it is pressed lightly / approximately 15 minutes at 20 °C). Waiting time depends on the room temperature, thickness of the adhesive film and absorbency of the base surfaces. One side coating is sometimes possible if one material has very reduced cohesion; in this case materials must be joined together very quickly (< 10 minutes).
Joining	As soon as solvent is completely evaporated and within above mentioned limit of the open time but on the still slightly sticky adhesive, place the parts accurately together and firmly press or join them together.
Pressing	Press shortly but strongly both materials together. Initial strength is very high but terminal strength is only reached after 24 hours approximately.
Alternatives	Some other adhesives of our ACROBOND CR are available for special requirements (for spray guns using, one side coating, 2-part adhesive to be used with catalyst).
Dilution / Cleaner	Use exclusively our cleaner ACRODIS CR-TF (Toluene free).

RECOMMENDATIONS / STORAGE / SAFETY :

Storage	≤ 12 months in a cool (+15 to +25 °C) and dry place in the original tightly closed packaging. Protect against freezing. Stir / remove before using.
Packaging	250 ml (including brush) + 750 ml boxes, 5 litre + 12,5 Litre cans, 200 Litre drums.
Precautions	Assure sufficient ventilation during storage and processing. Avoid direct skin contact of the uncured wet 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.