

PRODUCT APPLICATION:

- ❖ HIGH SOLIDS CONTENT
- ❖ EASE OF SPREADING
- ❖ CURED ADHESIVE HAS EXCELLENT FLEXIBILITY
- ❖ RESISTANT TO HEAT, COLD, MOISTURE & SOLVENT
- ❖ DOES NOT CONTAIN SUBSTANCES OF VERY HIGH CONCERN (SVHC)

PROPERTIES	TYPICAL VALUE
COLOUR	Dark Brown
VISCOSITY @ 25°C	3500 mPa.s
SOLIDS CONTENT	100%
WATER MIST APPLICATION	10% of adhesive weight
OPEN JOINT TIME (WITH WATER MIST)	20 mins
PRESS TIME (WITH WATER MIST)	45-60 mins
COVERAGE (DEPENDENT ON SUBSTRATE)	100-250 g/m ²

APPLICATION PROCEDURE:

- ❖ Materials to be bonded must be free from surface contamination.
- ❖ The adhesive should be applied to one surface only. The amount of adhesive used will depend upon the porosity of the substrate. Normal coverage rates are between 100 and 250 g/m².
- ❖ Normally, a fine mist of water should be applied to the bond-line at approximately 10% of the adhesive coat weight applied.
- ❖ Substrates may be assembled immediately after adhesive application or left for the indicated open time (Note: the open time changes with temperature - this should be monitored)
- ❖ Sufficient even pressure must be applied to keep components in intimate contact during the curing cycle. The applied pressure will depend on the nature of the substrates, but is normally in the range of 0.3 to 0.7 kg/cm².
- ❖ At the end of the application run, equipment should be cleaned with a suitable solvent cleaner such as isopropanol.

STORAGE:

- ❖ Adhesive A45 has a shelf life of 6 months if stored in original unopened containers.
- ❖ Store between 5°C and 25°C.

HEALTH & SAFETY:

- ❖ Adhesive A45 contains a non-volatile isocyanate.
- ❖ Avoid prolonged contact with skin.
- ❖ In cases of contact with eyes, flush out with large excess of water and seek medical attention.
- ❖ Before use, carefully read Safety Datasheet for this product.

LEGAL DISCLAIMER:

Recommendations and technical information are provided in good faith, based on current knowledge and experience. However, due to variations in storage conditions, storage period, substrates and site conditions, no warranty in respect of fitness for purpose can be inferred from this information.

The user must test the product's suitability for the intended application. Ru-bix Tooling Board is happy to provide free-issue samples for this purpose. All orders are accepted subject to our current terms of sale, a copy of which can be obtained from the Ru-bix office.